



Product	PD205381M AUTOMOTIVE BLACK POLYESTER MATT
Curing	10 MINS @ 200C Metal Temperature
Brilliance	15-22
Approvals	

PRODUCT DESCRIPTION

Recommended for general exterior situations where good weathering resistance is required. A specialised grade is available for architectural applications.

Supply form

Fine powder suitable for all types of electrostatic spray equipment

Storage Life :

Store in dry, cool conditions, preferably below 25°C. Shelf life under these conditions will be approx 12 months. For full information on handling this product type, refer to individual Safety Data Sheet and the 'Code of Safe Practice' issued by the British Coatings Federation.

CHARACTERISTICS

Spec. Gravity (kg/l): 1,20 – 1,70
depending on colour

Theoretical Coverage (m²/Kg @50µ): 11 – 14

Colour:

Wide range available to all common colour standards and to order

Gloss:

Full range available from full gloss to matt

Aesthetic variants:

Textured versions are available

Continuous Heat Resistance:

Good colour stability up to 130°C, or intermittent exposure up to 140°C, depending on formula type.

APPLICATION

Sherwin-Williams' powder coatings' Polyesters are suitable for use with all types of electrostatic powder spraying equipment. Our attention to processing and formulation detail ensures optimum transfer efficiency. Specially formulated versions of these products are available for use with 'Tribostatic' application equipment on request

Curing Cycle

High Bake Type:

200°C/10 minutes metal temperature

Standard Bake type:

180°C/10 minutes metal temperature

Low Bake type:

160 - 170°C/10 minutes metal temperature.

SUBSTRATE PREPARATION

Good quality pre-treatment is essential if the excellent properties of these products are to be obtained under field conditions. The type of pre-treatment will vary according to the metal substrate to be used.

As a general rule the article to be coated must be free from all surface contaminants and must then be treated with a suitable metal surface conversion pre-treatment e.g. iron phosphate, zinc phosphate to chromate type systems.

Our technical service department will be pleased to offer further advice on this subject if required

PERFORMANCE DATA

Meets the following criteria, as determined on 0.8mm Mild Steel test panels pre-treated with medium weight zinc phosphate, to which a typical non-textured product was applied, at a film thickness of 50-60microns and cured at 10 minutes @ 180°C metal temperature.

N.B. Some products within this range may be cured at different schedules, see box label or individual product data sheet for details. Typical values are noted under 'Curing Conditions'.

Mandrel bend test:

Pass 2mm
BS3900 E1

Cross hatch adhesion:

No loss of adhesion
BS3900 E6

Impact resistance:

Pass 100 in/lb
ASM D2794

Scratch test:

Pass 4kg
BS3900 E2

Taber abrasion resistance:

Excellent

Erichsen pencil hardness:

H-3H depending on formulation type

Erichsen indentation:

7-9.5mm depending on formula type

Salt Fog resistance

Maximum 2mm creep
ASTM B117 (500 hours)

Humidity resistance:

No blistering
BS3900 F2 (500 hours)

Exterior exposure (12 months):

Good colour and gloss retention

CAUTION

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Safety Data Sheet (SDS) prior to using this product.

A Safety Data Sheet is available from your local Sherwin-Williams facility or distributor

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the user obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in user handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.

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PD205381M - AUTOMOTIVE BLACK POLYESTER MATT

Attributes	
Chemical Type	Polyester
Specific Gravity (Theoretical) (kg/l)	
Coverage @ 1 µm DFT m ² /kg	
Technical Features	
Film Properties	Range/Value
Recommended Film Thickness	60-80 microns
Flexibility (Cylindrical Mandrel)	
Flexibility (Conical Mandrel)	
Adhesion	
Gloss (60 degrees)	15-22
Gloss (20 degrees)	
Direct Impact (cm/kg)	
Reverse Impact (cm/kg)	
Erichsen Cupping Test (mm)	
Cure Cycle	10 MINS @ 200C Metal Temperature
Appearance	
Application	Suitable for automatic and manual electrostatic application. Please check with your sales representative for Tribo.
Pretreatment	The surface to be coated must be free from oils, grease, and flash rust. A good quality pre-treatment process is recommended for optimum performance.
Substrate	Suitable for metal substrate.
Approval	
Version	

Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

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