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|--------------------------------------|---|
| Product | P1-858-6138-001 POLIEST LUCIDO VERDE FLUO 6038 |
| Series: P1 Group: P1004000 | FLUORESCENT POLYESTER THERMOSETTING POWDER COATING TGIC-FREE |

SPECIFIC PRODUCT PROPERTIES

| | | | |
|--------------------------|---------|--------------------|--------------------|
| CURE TEMPERATURE: | 180 | °C | Object temperature |
| CURE TIME: | 20 | Min | - |
| GLOSS AT 60°: | 85 - 95 | % Units % | ISO 2813 |
| THEORIC OUTPUT: | 11.14 | m ² /Kg | Thickness 60 µm |
| APPLICATION: | Corona | - | - |

| Polymerization area (Object temperature) | Temperature (°C) | Min time (min) | Max time (min) |
|---|------------------|----------------|----------------|
| | 170 | 20 | 35 |
| | 185 | 15 | 25 |
| | 200 | 11 | 17 |

GENERAL PROPERTIES OF THE SERIES

| Fundamental Product characteristics | <p>Powder coatings of this Series are based on polyester resins characterized by high resistance to atmospheric agents and UV radiations.</p> <p>They contain special organic pigments with fluorescent effect, which are characterised, on the other hand, by poor resistance to UV rays.</p> | | | | | | | | | | | | | | | | |
|--|---|---|--------------|-------------|--------------|-----------|--|-----------------------|---|--------------|---|---|---|--------------------|---|---------------------------------------|---|
| Substrate preparation | <p>Before the painting, the item should be adequately pre-treated in accordance with surface type, final use and required performances. The following table can be used as starting point for the pre-treatment choice.</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>Substrate</th> <th>Indoor Use</th> <th>Outdoor Use</th> <th>Architecture</th> </tr> </thead> <tbody> <tr> <td>Aluminium</td> <td>Soil removal, Chromate, Chromate-Free</td> <td>Chromate, Chrome-Free</td> <td>-</td> </tr> <tr> <td>SteelAcciaio</td> <td>Soil removal, Iron Phosphate, Zinc Phosphate, Sand-blasting</td> <td>Iron Phosphate, Zinc Phosphate, Sand-blasting</td> <td>-</td> </tr> <tr> <td>Zinc coated steel*</td> <td>Acid attack, Iron Phosphate, Zinc Phosphate, Chromate</td> <td>Acid attack, Zinc Phosphate, Chromate</td> <td>-</td> </tr> </tbody> </table> <p>* If the powder has to be applied on galvanized steel, please contact the representative.</p> | Substrate | Indoor Use | Outdoor Use | Architecture | Aluminium | Soil removal, Chromate, Chromate-Free | Chromate, Chrome-Free | - | SteelAcciaio | Soil removal, Iron Phosphate, Zinc Phosphate, Sand-blasting | Iron Phosphate, Zinc Phosphate, Sand-blasting | - | Zinc coated steel* | Acid attack, Iron Phosphate, Zinc Phosphate, Chromate | Acid attack, Zinc Phosphate, Chromate | - |
| Substrate | Indoor Use | Outdoor Use | Architecture | | | | | | | | | | | | | | |
| Aluminium | Soil removal, Chromate, Chromate-Free | Chromate, Chrome-Free | - | | | | | | | | | | | | | | |
| SteelAcciaio | Soil removal, Iron Phosphate, Zinc Phosphate, Sand-blasting | Iron Phosphate, Zinc Phosphate, Sand-blasting | - | | | | | | | | | | | | | | |
| Zinc coated steel* | Acid attack, Iron Phosphate, Zinc Phosphate, Chromate | Acid attack, Zinc Phosphate, Chromate | - | | | | | | | | | | | | | | |
| Particle size distribution | Powder coatings of this Series are characterized by an average particle size included between 30 and 40 microns. According to the customer's specific needs, specific particle size distributions can be supplied. | | | | | | | | | | | | | | | | |
| Typical applications | Powder coatings of this Series can be used for painting several products for indoor use. | | | | | | | | | | | | | | | | |
| Storage stability | The self-life of this Powder coatings Series, if stored in a dry place and at temperatures below 30°C, will be at least 36 months from production date. For product older than 36 months, it is recommended to check the characteristics before use. | | | | | | | | | | | | | | | | |

| General properties of the series ⁽¹⁾ | Regulation | Test result |
|---|-------------------------------------|---|
| Impact Test ⁽²⁾ | ASTM D2794 | 2,5 Nm |
| Adhesion ⁽²⁾ | ISO 2409 | GT0 |
| Deep-drawing | ISO 1520 | 5 mm |
| Bending test ⁽²⁾ | ISO 1519 | 5 mm |
| Salt spray ⁽³⁾ | ISO 9227 | 500 hours without film separation |
| Accelerated ageing | EN ISO 11341 | 600 hours with remaining gloss superior to 50% |
| Humidity test ⁽³⁾ | ISO 6270 | 500 hours without film separation or blistering |
| Acetone | 100 double passages with cotton wad | Scarce resistance |
| Ethyl alcohol | 100 double passages with cotton wad | Excellent resistance |
| Methylethylketone | 100 double passages with cotton wad | Scarce resistance |
| Perchloroethane | 100 double passages with cotton wad | Scarce resistance |
| Toluene | 100 double passages with cotton wad | Limited resistance |
| Trichloroethane | 100 double passages with cotton wad | Scarce resistance |
| Xylene | 100 double passages with cotton wad | Limited resistance |
| Acetic acid (10%) | Film immersion for 30 days | Excellent resistance |
| Citric acid (10%) | Film immersion for 30 days | Excellent resistance |
| Hydrochloric acid (10%) | Film immersion for 30 days | Excellent resistance |
| Phosphoric acid (10%) | Film immersion for 30 days | Excellent resistance |
| Lactic acid (10%) | Film immersion for 30 days | Excellent resistance |
| Sulphuric acid (10%) | Film immersion for 15 days | Excellent resistance |
| Ammonium hydroxide (10%) | Film immersion for 30 days | Scarce resistance |
| Sodium hydroxide (10%) | Film immersion for 30 days | Scarce resistance |

⁽¹⁾ All tests were performed on smooth glossy white powder without fillers sensitive to acids. For physical-chemical tests on specific codes please contact the Technical Direction of ST Powder Coatings.

⁽²⁾ Tests carried out on Unichim steel panels with coating thickness of about 60 microns.

⁽³⁾ Tests carried out on Bonder 26S/60/0C panels with coating thickness of about 60 microns.

Note 1

The information given in this Technical Data Sheet, based upon laboratory tests, is currently correct to the best of our knowledge. Since product application and conditions vary and are often beyond our control, we can guarantee only the product quality itself. In the light of continuous product improvement, ST Powder Coatings reserves the right to modify without notice the content of this technical sheet.

Note 2

The acronym RFG, if present in the description, indicates a product formulated with special additives that minimize the problems related to direct polymerization in gas ovens.