İBA KİMYA SAN. ve TİC. A.Ş.
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PE54

Technical Data Sheet

Description

PE54 is a thermosetting powder coatings based on TGIC free polyester binder system designed for exterior applications. It has very good UV and yellowing resistance. It is designed specifically for industrial applications.

Characteristics

Available for all RAL colours
One coat finishes
Very Good UV resistance
Suitable for most exterior environments
Less waste and pollution to the environment
TGIC free

Applications

Window and door systems
Dish antenna
Garden tools
Industrial applications
IBADECOR applications

Product Properties

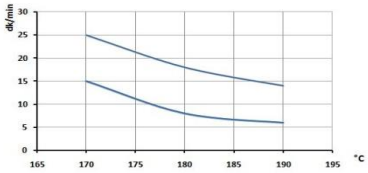
UV Resistance	Good UV resistance.
Flow out	Very good
Surface	Gloss GL – Semigloss HR – Semimatt CM – Structure ST – Silk Pattern SP – Wrinkle WR
Specific gravity	1.5-1.8 gr/cm3 (low with dark colours, high with light colours)
Shelf Life	12 months (< 30°C and < 50% RH)

Application Data

Application: Corona (Can be applied by tribo guns if product code has "T" for the 6th character)

Curing: 180°C 10 minutes recommended*

Metal Temperature (°C)	Time (minutes)
170	15-25
180	8-18
190	5-14



Film Thickness: 60-80 µm (recommended)**

Theoretical cons. 8-10 m^2/kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

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**160°C curing, catallized version is available.*

***Recommended film thickness for WR coded products is 80-130µ, theoretical consumption value should be calculated due to this thickness range.*
***Recommended film thickness is 80-100 µm for IBADECOR applications, so it is recommended to calculate theoretical consumptions accordingly.*

Coating Properties

Test results shown below are based on 0.5 mm steel with 60µ applied powder coatings.

Direct Impact	>25 kgcm	(ISO 6272-2)
Reverse Impact	>25 kgcm	(ISO 6272-2)
Buchholz Hardness	>85	(ISO 2815)
Conical Mandrel	0 mm	(ISO 6860)
Cross Hatch Adhesion	Gt:0	(ISO 2409)

*** Mechanical properties may decrease for WR coded products due to higher film thickness values.*

Application Guide

Surface Preparation
All surfaces should be degreased and pretreated for optimal performance.
Suitable pretreatment includes:

Aluminium	Yellow chromate or green chromate/phosphate
Ferrous metals	Zinc phosphate or Iron phosphate
Zinc Coated Metals	Zinc phosphate or chromate

Application Procedure and Equipment
PE54 series powder coatings charging properties are optimized when powder is free-flowing and moisture-free. Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.
If storage room temperature is lower than the application area, powder coatings, which are hygroscopic, should be acclimated in unopened containers prior to adding into the spray hopper. For optimum performance, It should be applied and stored at air-conditioning area. Storage temperatures should be kept below 30 °C.
Powder should not be stored in hoppers for long periods of time. If moisture condensation occurs, fluidize powder to dry-out or replace moisture-laden powder with virgin powder.
Powder coatings are finely ground particulates. Respirators or dust masks should be used by workers exposed to powder in order to avoid dust inhalation.
Compressed air to the gun must be oil and moisture free.
Silicone should not be used in application area.
For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.
Contact points should be maintained to ensure metal-to-metal ground.
Apply by electrostatic spray. Relative humidity should be 50-60% for corona system, lower than 40% for tribo system.
Cure as per recommendations outlined above.
Reclaim-to-virgin ratios should be carefully monitored to maintain spray consistency.
Sieving powder before adding to hopper eliminates potential clumping or foreign matter.
Test for cure of the coating by impact test.

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Care and Maintenance

PE54 should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse to maintain the attractive appearance of the powder cured film.
The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

Health and Safety

The SDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed. It is recommended to contact to Sales and Customer Service Offices for further information.

Precautions and Limitations

As a result of possible wide application variations and stoving conditions, PE54 may show variation, between İBA Kimya Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
For optimum performance ensures recommended dry film thickness is obtained.
Not recommended for use in highly corrosive environments.
Due to water release during curing process, pin hole problem can be seen above 100 μm.

Transport and Storage

Packaging	15-20-25 kgs. Heavy polyethylene bag in a corrugated carton
Shipment	Not dangerous goods. No special transport requirements.
Storage Conditions	Storage temperatures should be kept below 30 C° and 50% relative humidity. Powder should be stored in closed containers.

DISCLAIMER: All the information provided in this data sheet depends on our knowledge and experience up to date and may be subject to revision as new technology and experience evolve. Since the conditions of application may vary depending on the substrate, physical conditions and other variables, users should conduct necessary tests to determine the conformity of the product for its intended use. We do not accept liability since the application, use and processing of the products take place beyond our control and supervision. Moreover, our liability for breach of warranty is exclusively limited to replacement of the product or refund of its price and we are not liable for incidental, indirect or consequential damages under any circumstances.