İBA KİMYA SAN. ve TİC. A.Ş.
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PS77

Technical Data Sheet

Description

PS77 is a Qualicoat Approved thermosetting TGIC free matt superdurable powder coatings. It is based on advanced polyester resin technology and high performance pigments designed specifically for architectural applications where colour and gloss retention are critical. It has superior gloss and colour retention compared with standard polyester powder coatings.

Characteristics

One coat finishes
Excellent UV resistance
Superdurable powder
Suitable for most exterior environments
20 year guaranteed performance on correctly pre-treated aluminium with Qualicoat (P-1345) approval
Tgic free
Good flow out

Applications

Specially developed for use on extruded architectural aluminium, including window and door frames, and extruded panel work on commercial buildings

Product Properties

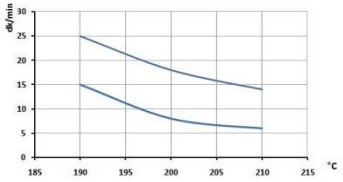
UV Resistance	Excellent UV resistance. Qualicoat Approved (P-1345)
Flow out	Very good
Surface	Matt CM
Specific gravity	1.2-1.7 gr/cm3 (low with dark colours, high with light colours)
Shelf Life	24 months (< 30°C and < 50% RH)

Application Data

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

Curing: 200°C 10 minutes recommended

Metal Temperature (°C)	Time (minutes)
190	15-25
200	8-18
210	5-14



Film Thickness: 60-80 µm (recommended)

Theoretical cons. 9-12 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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Coating Properties

Tests	Colours Tested		
	RAL 3005	RAL 5010	RAL 9010
Adhesion (ISO 2409)	0	0	0
Buchholdz (ISO 2815)	>80	>80	>80
Cupping test (ISO 1520)	No cracking at a diameter of 5 mm	No cracking at a diameter of 5 mm	No cracking at a diameter of 5 mm
Bend test (ISO 1519)	No cracking at a diameter of 5 mm	No cracking at a diameter of 5 mm	No cracking at a diameter of 5 mm
Impact test (ISO 6272-2/ASTM D 2794)	No cracking at 2,5 Nm	No cracking at 2,5 Nm	No cracking at 2,5 Nm
Kesternich (ISO 3231)	No penetration or detachment beyond 1 mm	No penetration or detachment beyond 1 mm	No penetration or detachment beyond 1 mm
Acetic acid salt spray resistance (ISO 9227) / 1000 hrs	Conforming to QUALICOAT specification	Conforming to QUALICOAT specification	Conforming to QUALICOAT specification
Accelerated weathering test (ISO 16474-2)	Residual Value (not less than 10%)	Residual Value (not less than 10%)	Residual Value (not less than 10%)
Resistance to mortar (EN 12206-1)	No defects no detachment	No defects no detachment	No defects no detachment
Resistance to boiling water	No defects no detachment	No defects no detachment	No defects no detachment
Humidity Test (ISO 6270-2)	No defects no detachment	No defects no detachment	No defects no detachment

Application Guide

Surface Preparation
All surfaces should be degreased and pretreated for optimal performance.
Suitable pretreatment includes:
Aluminium Yellow chromate or green chromate/phosphate

Application Procedure and Equipment
PS77 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

PS77 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, PS77 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.
The heat up rate of components in the curing oven may influence gloss difference.
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.