

# selac®

Code : Y130G01 - GREY RAL 7035

## SEMIGLOSS POLYESTER STRUCTURED POWDER COATING

### ● Description

Y130G01, is a structured thermosetting powder coating formulated using carboxylated saturated polyester resins crosslinked with HAA. .

### ● Specific uses

This product is suitable for the coating of the goods exposed outdoor being formulated with the resins, pigments and fillers resistant to yellowing and chalking under the effect of UV light.

### ● Surface preparation

In relation to the support to be coated a chemical conversion treatment is strongly recommended .

It is possible to use iron or zinc salts conversion or chromatation procedure .

At least a careful chemical or mechanical degreasing must be done .

Adhesion , anticorrosive properties and time duration of the coating are greatly influenced by the pre-treatment .

### ● Application

The application is made by using manual or automatic systems , based on corona ( minimum voltage 40KV ) charging .

### ● Curing conditions

Curing time depends not only on the resins reactivity , but also on the oven efficiency and on the mass of the parts to be coated .

Typical curing conditions for the product are :

180° = 20'                      190° = 15'                      200° = 10'

These are the times and temperatures at which the object must be kept in the oven for a complete curing of the coating.

### ● Technical features

Specific gravity Kg/l                      = 1.66 - 1.68  
 Gloss 60° (ISO 2813)                      = Visual  
 Thickness                                      = 80 - 100 µm  
 Theoretical coverage                      = 6.00 - 7,40 m<sup>2</sup>/kg  
 Theoretical Yield Formula: m<sup>2</sup>/kg = 1000/(spec.gravity x thickness)

### ● Mechanical properties

Bending test	( ISO 1519 )	= < 5 mm
ERICHSEN cupping test	( ISO 1520 )	= > 8 mm
Direct impact test	( ISO 6272 )	= > 5 Nm
Adhesion ( cross cut )	( ISO 2409 )	= GT 0
Pencil Hardness Wolf-Wilborn	( ASTM D 3363 )	= H - 2H
Hardness BUCHHOLZ	( ISO 2815 )	= 80-100

These values are obtained using UNI 5961 – 0,6 mm thick cold rolled steel panels , cleaned with solvent and covered with a powder coating film of approximately 80-100 µm .

### ● Corrosion resistance

Salt spray test	(ISO 3768)	= 1000 hrs.
Humidity test	(ISO 6270)	= 1000 hrs.
Kesternich test	(ISO 3231)	= 30 cycles.
UV-CON test	(ASTM G 53-88)	= 300 hrs*

\*After test the gloss is 50% of initial value.

These values are obtained using UNI 5961 – 0,5 mm thick cold rolled steel panels , treated with zinc phosphate conversion and covered with a powder coating film of approximately 100 µm . Curing cycle: 200°C – 10'

### ● Storage stability

This product , if kept in sealed boxes stored in a dry place at a temperature not exceeding 30° C , is guaranteed for 12 months .

### ● Safety

Powder coatings can be considered combustible but not inflammable .

The ignition temperature of the mixture powder / air is 450-600° C .

For further safety informations please refer to specific " Safety Data Sheet " prepared according to 91/155/UE directive.

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The a. m. informations come from our experience , as well as that of specialized laboratories ; the user , according to his requirements , undertakes full responsibility of application and testing products .