



# IE Polyester Powder

## Introduction:

Recommended for use on exterior fittings where high resistance to weathering is required. This product is suitable for Tribo application. With Corona guns it will give a high transfer efficiency, therefore some reduction in powder emission rates may be necessary to achieve the desired film thickness. Can give rise to micropinholing at very high film thickness (>150µ). This product is free of TGIC.

### Colour:

To customer's requirements.

### Gloss Level:

Full gloss: 80-95%

Semi-gloss: 60-75% or to customer's requirements

Semi-matt: 30±5%

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### Film Properties:

Adhesion	BS3900 E6	- No detachment
Scratch	BS3900 E2	- Pass 4kg
Impact	ASTM D2794	- Pass 40in/lbs
Bend	BS3900 E1	- Pass _"
Humidity	BS3900 F9	- No blistering after 1,000 hours (Zinc Phosphated Steel).
Salt Spray	ASTM B117	- 2-4mm creep after 1,000 hours (Zinc Phosphated Steel).
Heat Stability		- No yellowing on continuous exposure up to 110°C or intermittent exposure up to 130°C.
Weathering	Florida 5'S	- Minimum 50% gloss retention after 12 months exposure.

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### Specific Gravity:

1.3 - 1.7 depending on colour and gloss.

### Coverage:

9 - 13 sq meters/kilo @ 60 microns at 100% powder utilisation. Variable with colour and gloss.

### Film Thickness:

Recommended 50-70 microns.

### Storage:

24-36 months shelf life in dry and cool conditions.

### Stoving Schedule: (Refer to label)

Gloss/Semi-gloss - 10'@180°C metal temperature

Matt - 10'@180°C - 200°C metal temperature

### Handling:

Precautions should be taken to avoid inhalation of airborne particles. Reference should be made to the Guide Lines laid down in the "Code of Safe Practice" issued by the British Coatings Federation and to the individual safety data sheet for the product.

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