



X-MP SERIES

HYBRID POWDER COATING

- many different types
- high energy-saving potential
- excellent flexibility

These powder coatings are based on polyester and epoxy resins. Due to their excellent all-round properties, our hybrid powder coatings are the most used powder coatings in the coatings sector. They are versatile in use and meet many requirements for indoor goods.

APPLICATION

Metal office furniture, shelves, household appliances, stoves and kitchen hoods, camping articles, radiators, heating plates, water heaters, household articles, machinery, computer cabinets and any metal object for indoor.

PROPERTIES

| | |
|----------------------|--|
| Colour shade: | all RAL (on request NCS, Pantone or other) |
| Finish: | smooth, fine texture, rough texture and special effects in Dryblend and Bond version |
| Gloss: | from matt to glossy |
| Density: | from 1.25 to 1.80 g/cm ³ , depending on colour shade and quality |
| Yield: | depends on the applied film thickness, c.f. formula |
| Storage life: | depends on the formulation reactivity (from 3 to 36 Months at temperatures lower than 30 °C) |

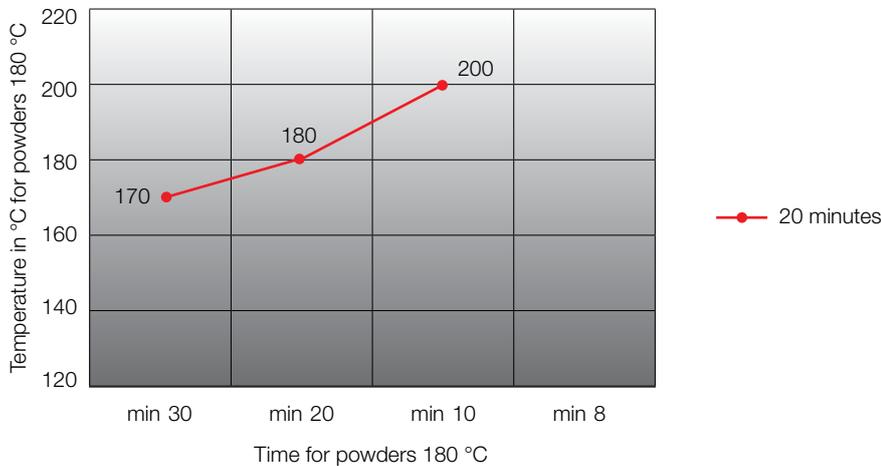
HYBRID POWDER COATING

COATING PROPERTIES

| | |
|-------------------------------|--|
| Adhesion test: | Gt 0 DIN 53151 |
| Impact test: | >50 cm/Kg ASTM D 2794 |
| Erichsen cupping test: | >8 mm ISO 1520 |
| Mandrel bend test: | 5 mm ISO 1519 |
| Pencil hardness test: | H-2H ASTM D 3363 |
| Salt spray test: | 500 hours 1 mm ASTM B 117-94 |
| Humidity resistance: | 500 hours unaffected ASTM 9870 |
| Q.U.V-B test: | 100 hours -50% gloss loss |
| Chemical resistance: | good regarding lyes and acids diluted and at room temp. |

CURING CONDITIONS

HYBRID POWDER COATING – Curing conditions



Light colour shades can cause a shift. The maximum temperature is around 210 °C. All data refer to object temperature.

THEORETICAL SPREADING RATE

Multiply the average specific gravity by the requested thickness in microns. The obtained value is the consumption in grams per square meter. Formula: Specific gravity x thickness = yield (g/m²)

These data are based on empirical values for the completeness of which we do not assume any guarantee. Since we cannot influence in any way the processing of the product, the purchaser is responsible for ensuring that the product is suitable for the intended purpose before using the product. Any change in the processing procedure, environmental conditions, or the non-observance of instructions can influence the result negatively. Status 07/2015.

PROCESSING

Surface pretreatment:

Before coating, metal surfaces must be clean and free from greases, oils, rust and any other material that might cause adhesion loss of the product to surfaces.

Aluminium: chromatising or Cr-free cycles

Galvanised steel: chromatising

Steel: sand blasting or/and iron or zinc phosphatising

Application:

all common processes (Tribo, Corona)

Thickness:

From 60 µm to 120 µm, depending on colour shade and finish type

Curing conditions:

Depends on the formulation reactivity (from 15 min. at 140 °C to 20 min. at 180 °C object temp.)

Overcoatability:

Can be overcoated with the same product or with special repair coatings.