

Technical Data Sheet

PUR-TRA SERIE 400	Orange Base	Cod. DS 429
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Powder Coatings: TGIC FREE POLYURETHANE

Use: Outdoor

Suggested for: Base coat for heat transfer process

Application: Corona Charging

Curing Cycle: 20' X 200°C (Metal Temperature)

Chemical and Mechanical Properties

1 - Packing: 20 Kg. Boxes with PE-bag, palletized and shrink-wrapped

2- Shelf-life: In a dry place with a temperature lower than 35 °C
for 12 months

3 - Specific weight: 1.25 ± 0.05 g/cm³

4 – Yield m²/Kg. considering 60 microns film thickness: 13 m²/Kg

60 microns film thickness

5 - Appearance: Semimatt

	RIF Standard	Miniumum Tollerance Limit	Result
6 - Gloss (Gardner 60°)	ISO 2813	20 ± 5 gloss	OK
7 - Buchholz hardness	ISO 2815	minimum 80	OK
8 - Adhesion	ISO 2409	No loss of Adhesion	OK
9 - Thickness (Minim. thickness)	ISO 2360	60 microns	OK
10 - Direct Impact Test *	ASTM D2794	2,5 N/m	No Coating detaching
11 - Reverse Impact Test	ASTM D2794	2,5 N/m	No Coating detaching
12 - Erichsen Identation *	ISO 1520	5 mm	No Coating detaching
13 - Bending *	ISO 1519	5 mm diameter	No Coating detaching
14 - Kesternich Test	ISO 3231	No Coating detaching or penetration higher than 1 mm.	OK
15 - Humidity Test**	DIN 50017	No blistering/coating detaching	OK
16 - Acetic acid - Salt Spray Test **	ISO 9227	Corrosion lower than 4 mm.	OK
17 - Accellerated weathering Test	ISO 11341	Rit. di Brill. >50% ΔE < 2	OK
18 - Pressure Cooker Test	Cap.Qualicoat	No blistering/coating detaching	OK
19 - Lime Resistance	Cap.Qualicoat	No blistering/coating detaching	OK

* Tests carried out on 1 mm. thickness alloy AA5005 H24 chromate aluminium sheets and 60 microns coating layer .

** Tests carried out on AA6060 extruded alloy

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Users will assume responsibility for the application of the product testing its characteristics on their own equipment and carriers.