

WHITE AND CLEAR

DESCRIPTION OF THE APPLICATION “ CYCLE 11”

CYCLE 11 IS A 2 POWDER COATING LAYERS AND IT CAN BE GLOSS OR MATT.

▶ **GLOSSY CYCLE 11:**

- **First coat layer of White Polyester, RAL 9010 ;**
+ Second coat layer of Transparent Polyurethane DS 810.

▶ **MATT CYCLE 11:**

- **First coat layer of White Polyester, RAL 9010 ;**
+ Second coat layer of Transparent Polyurethane code DS 407.

“ CYCLE 11”

(2 LAYERS: WHITE + TRANSPARENT (Gloss or Matt)

▶ **FIRST LAYER:**

- **WHITE POLYESTER RAL 9010**

The thickness of the first layer (base) of powder must be of 2 mils.

The base must be cured for 15 minutes with a temperature of 340 ° F in a such way the first layer is not completely cured, in order to help the adherence of the second layer of powder.

▶ **SECOND LAYER (Gloss or Matt):**

For the second layer you can use:

- **GLOSSY TRANSPARENT POLYURETHANE POWDER (90 GLOSS – CODE DS 810)**
or
- **MATT POLYURETHANE POWDER (20 ± 5 GLOSS – CODE DS 407).**

The thickness of the second layer must be of 2 mils. The second layer must be cured for 20 minutes with a temperature of 400 ° F on the piece. Please start counting the 20 minutes when the metal reaches 400°F.

SUBLIMATION:*The process of sublimation must be carried out with a temperature of 400 • F. Decorations: Marbles, Granites, Fantasies.*