

<b>Part. No.</b>	<b>69BG1702130 - GREY RAL 7021 - COARSE STRUCTURE - GLOSS</b>	
<b>Product description</b>	Polyester Industrial product formulated especially to ensure high light and weather resistance with good mechanical properties. Suitable for decorative and protection of metal components for use on exteriors.	
<b>Chemical composition</b>	TGIC-free polyester.	
<b>Finish</b>	• Smooth flow > 89* <b>Serie 69L</b>	• Rough texture, <b>Serie 6_R</b> , gloss visual.
	• Smooth flow 80÷89* <b>Serie 68L</b>	• Coarse-structure, <b>Serie 6_B</b> , gloss visual.
	• Smooth flow 45÷79* <b>Serie 65L/ 66L/ 67L</b>	• Hammertone, <b>Serie 6_M</b> , gloss visual.
	• Smooth flow 15÷40* <b>Serie 62L/ 63L/ 64L</b>	• Antique, <b>Serie 6_A</b> , gloss visual. (**)
	• Smooth metallic-effects, gloss visual (**)	

(\*): gloss level, ISO 2813/60° - (\*\*): Only for Corona application; for details consult RIPOL Guidelines Mod. 83-1008 and Mod. 83-1009.

<b>Curing conditions</b> (Object Temperature)	<b>30-40 min. @ 170 °C   10-20 min. @ 180 °C   8-15 min. @ 190 °C</b>
<b>Application method</b>	Corona and Tribo.
<b>Storage, shelf life</b>	36 months from date of manufacture, if stored under dry (Humidity 20÷70%) and cool (max 30°C) conditions.
<b>Density</b>	1,69 Kg/dm <sup>3</sup> ± 0,05
<b>Theoretical yield</b>	May be calculated using the formula: $m^2/Kg = 1000 / (S \times P)$ where, S = film thickness in µm; P = density.
<b>Pre-treatment</b>	Scale, oil, grease or other residue must be thoroughly cleaned from the surface to obtain the best corrosion resistance. Aluminum substrate require appropriate Chrome-free pretreatment. For steel is recommended: degreasing, phosphating followed by passivation, final rinse and dry-off. For hot-dip galvanized steel we recommend sweeping with a maximum zinc layer thickness reduction of 5÷10µm. (To delete outgassing phenomena, additives can be added to the powder coating). On steel and galvanized steel, corrosion resistance can be improved by using our <i>CORROCARE ABP</i> primer.

<b>Test Conditions</b>	The technical data provided below have been carried out under laboratory conditions. Substrate: 0,8mm Steel, zinc-phosphated+passivation. Coating thickness: 70±10µm. Curing: 180°C / 20 min.
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### Mechanical, Chemical and Durability tests

Cross-cut adhesion test: Gt 0	ISO 2409
Erichsen cupping: ≥ 6 mm	ISO 1520
Hardness Buchholz: ≥ 80	ISO 2815
Reverse and Direct Impact: ≥ 2.5 Nm	ISO 6272
Bend test (cylindrical mandrel): Pass 5 mm	ISO 1519
Resistance to humidity - Part 2: Condensation, 1000h: no blistering, no loss of gloss.	ISO 6270-2
Corrosion tests - Salt spray, 500h: no corrosion creep more than 3 mm from scribe.	ISO 9227
External durability: Excellent color and gloss stability.	
Good resistance to diluted acids and alkalis and oils at ambient temperatures. Certain chemicals or cleaning materials can cause surface painted modifications. We recommend to carry out preliminary tests on a small non-visible area of the coating.	
In case that coating will be subject to additional processes (eg. serigraphs, overcoating, sealants or other auxiliary products, any mechanical post treatment), an appropriate test must be carried out to confirm the suitability.	

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69BG1702130	GREY RAL 7021	2	14/03/2022