TECHNICAL INFORMATION

CEWEPOL

BASE: POLYESTER EPOXY RESIN

BASICS

CEWEPOL powder coatings are based on high quality polyester / epoxy resin systems that, stoved appropriately, will harden during chemical crosslinking. The products are characterized in particular by their variety of applications at an economic price -/performance ratio. Depending on requirements the following stoving conditions are possible: 10 min./150°C -10min./180°C (object temperature).

FIELDS OF APPLICATION

Recommended for indoor use:

- Such as air conditioning, heating, switch gear, shop fitting, shelving, steel furniture, wire goods, machines, tools, fittings, steel construction, car components, glass, ceramic, sanitary appliances, sport and camping items, etc.

PROPERTIES

- Good chemical resistance
- Good corrosion protection
- Good mechanical properties
- High surface hardness
- Simple and secure processing

RANGE OF PRODUCTS

- Depending on customer needs specific products can be developed
- Numerous color shades are available

GLOSS AND SURFACE

The following gloss and surface varieties exist:

Surface	Gloss according ISO 2813, angle of reflectance: 60°					
	deep flat (0-9*)	flat (10-29*)	satin (30-49*)	semi gloss (50-79*)	glossy (80-95*)	high gloss (> 95*)
Smooth	■	■	■	■	■	■
River Texture	–	■	■	■	■	–
Fine Texture	■	■	–	–	–	–

SUBSTRATES

- Steel, alloyed steel. Stainless steel should be chemically or mechanically etched. (adhesion has to be checked)
- Galvanized steel, aluminum and aluminum alloy (adhesion needs to be checked)
- Other metal substrates
- Ceramic / glass

PRETREATMENT

- Substrate must be free of scale, dirt and oil, for example through an alkaline degreasing process
- Blasting
- Sweeping
- Iron phosphating
- Chrome free conversion systems such as titanium or zirconium based compounds that build nano ceramic conversion layers
- Zinc phosphate
- Chromate

Depending on the substrate one of the above mentioned pretreatments will be suitable.

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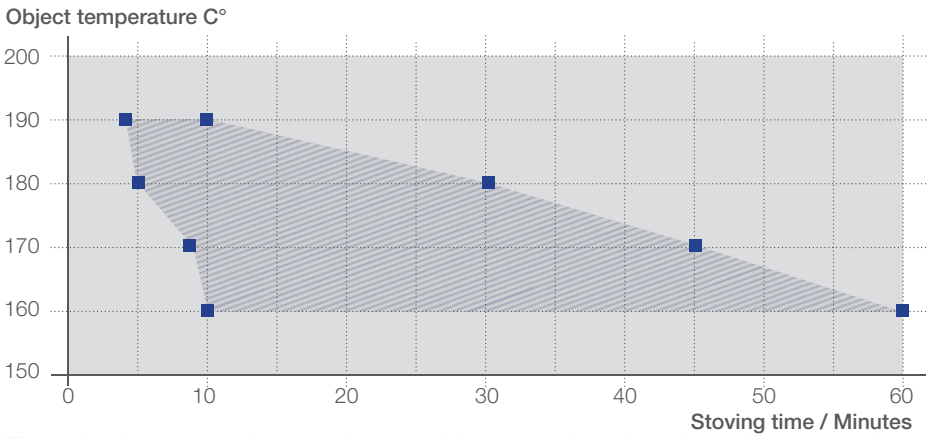
APPLICATION

Electrostatic powder coating, corona and tribo**

STOVING CURVE

Stoving conditions
(160°C-Versions)



TECHNICAL DATAS

The following properties have been achieved on zinc phosphated steel panels, 0,75mm, Gardobond 26T/60/OC:

	Standard, glossy	Standard, flat
Filmthickness ISO 2360	(70 ± 10) µm	(70 ± 10) µm
Reflection value Reflection angle 60°, ISO 2813	80 – 95 (glossy)	10 – 29 (flat)
Crosscut ISO 2409, Multi-Cross Cutter, 2 mm	Characteristic 0	Characteristic 0
Film hardness according Buchholz ISO 2815	> 90	> 90
Cupping test ISO 1520	≥ 9 mm	≥ 2 mm
Mandrel ISO 1519	≤ 3 mm	≤ 8 mm
Salt spray test ISO 9227	1000 hours Creepage at cut ≤ 1mm	1000 hours Creepage at cut ≤ 1mm
Condense water test according ISO 6270-2	1000 hours Creepage at cut ≤ 1mm	1000 hours Creepage at cut ≤ 1mm

SPECIFIC GRAVITY ACCORDING (ISO 8130-2)

1,2 - 1,7g/cm³ depending on quality and color

PACKAGING

- 20kg-carton 18 on a pallet
- Welltainer (packed with 20 kg-Plastic bags: 340-500kg)
- Super Bag (350 - 700kg)
- Tote (450 - 750kg)

POWDER CONSUMPTION

$$\text{Material price per m}^2 = \frac{\text{price per kg x spec.gravity in g/cm}^3 \text{ x film thickness in µm}}{1000}$$

STORAGE STABILITY

At least 12 months when stored dry and cool at max. 25°C

* reflected at 60° angle
** tribo modified powdercoatings belong to a special product group.

Date: 10/2011