

CYCLE 11

DESCRIPTION OF THE APPLICATION “ CYCLE 11”

Cycle 11 is dual strate coating process with different potential output (smooth, textured, glossy, matt). It is used mainly for decoration with marble, fancies, tailor-made patterns and pictures.

WHICH POWDER COATINGS?

► GLOSSY CYCLE 11:

- First coating layer: White Polyester, code PE-411
- + Second coat layer: Transparent Polyurethane DS-810.

► MATT-SMOOTH CYCLE 11:

- First coat layer: White Polyester, code PE-411;
- + Second coat layer: Transparent Polyurethane code DS-407.

► MATT-TEXTURED CYCLE 11:

- First coat layer: White Polyester, code PE-411;
- + Second coat layer: Transparent Polyurethane code DS-707.

HOW DOES THE PROCESS WORKS?

► FIRST LAYER:

- WHITE POLYESTER CODE PE 411

The thickness of the first layer (base) of powder must be of 50 microns. The powder must be cured for 15 minutes with a temperature of 170°C in a way that the first layer is not completely cured, in order to help the adherence of the second layer of powder.

► SECOND LAYER:

For the second layer you can use:

- GLOSSY TRANSPARENT POLYURETHANE POWDER (90 GLOSS – CODE DS 810)
- MATT POLYURETHANE POWDER (20 ± 5 GLOSS – CODE DS 407).
- TEXTURED MATT POLYURETHAN POWDER (8± 5 GLOSS – CODE DS-707).

The thickness of the second layer must be of 50 – 60 microns. The second layer must be cured for 20 minutes with a temperature of 200°C on the piece.

SUBLIMATION: The process of sublimation must be then carried out at a temperature of 200°C. Decorations: Marbles, Granites, Fantasies.

STANDARD PRODUCT USED ABOVE ARE SUITABLE FOR INDOOR USE.

FOR OUTDOOR APPLICATION IT IS RECOMMENDED THE USE OF SERIES SUPERDURABLE
IN THE SECOND LAYER:

- DS-407 S
- DS-810 S
- DS-707 S