

**Technical Data Sheet**
**MARRONE PIEGA SERIE 400**
**Cod. DS 413**

Powder Coatings:	TGIC FREE POLYURETHANE
Use:	Outdoor
Suggested for:	Base coat for heat transfer process
Application	Corona Charging
Curing Cycle:	25' X 195°C ( Metal Temperature )      25' X 383 °F 20' X 200°C ( Metal Temperature )      20' X 392 °F 15' X 205°C ( Metal Temperature )      15 X 401°F

**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 - 95°F for 12 months		
3 - Specific weight	1.27 ± 0.03 g/cm <sup>3</sup>		
4 – Yield m <sup>2</sup> /Kg. considering 60 microns film thickness	13,1 m <sup>2</sup> /Kg		
5 - Appearance	Rough		
	<b>RIF Standard</b>	<b>Miniumum Tollerance Limit</b>	<b>Result</b>
6 - Gloss ( Gardner 60°)	ISO 2813	19 ± 5	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	mandrino 5 mm mandrel 5mm	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

Note importanti:

**Important information:**

La brillantezza del film di vernice è influenzata dalla spessore della polvere applicata e dalle condizioni di polimerizzazione.

**Brightness of powder coating layer could change by applied thickness and by the curing process.**

Per ottenere le migliori performance di resistenza ai raggi uv il valore di brillantezza del film di vernice deve rispettare i valori indicati nella scheda tecnica.

**To obtain best UV ray resistance performance, the powder coating brightness must comply technical data sheet value.**

\* 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

This technical information is reliable to the best of our and our customers' experience but non warranty or guarantee is implied. Users will assume responsibility for the application of the product testing its characteristics on their own equipment and carriers.

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