

WHITE AND CLEAR DS 707

DESCRIPTION OF THE APPLICATION “CYCLE 11”

CYCLE 11 IS A 2 STEP POWDER COATING LAYERS: WHITE+ CLEAR COAT.

▶ **MATTE TEXTURED CYCLE 11:**

- **First coat layer of white PE 411;**
+ Second coat layer of Transparent Polyurethane DS 707

“ CYCLE 11”

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

▶ **FIRST LAYER:**

- **WHITE POLYESTER PE 411**

The thickness of the first layer (base) of powder must be of 40 microns (1.57 mils).

The base coat 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:**

- **MATT TEXTURED POLYURETHANE POWDER (8 ± 3 GLOSS – CODE DS 707).**

The thickness of the second layer must be 60 microns (2.36 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 195°C (383°F).
Decorations: Marbles, Granites, Fantasies.*