

# WHITE AND CLEAR DS 810

## 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 810

### “ 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):**

- **GLOSSY SMOOTH DS 810 POLYURETHANE POWDER (90 ± 3 GLOSS – CODE DS 810).**

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.*