



**PEKA
CHEMIE**
INDUSTRIAL COMPANY

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Letter Of Transmittal

Date: Sept 27th 2018

Reference:

We are sending you:

- Letter Attached Order Prints Samples
 Specifications Others

Item	Date	Revision	Description
1	Sept 27 th 2018	Rev. 2	PE 231A- a range of QualiCoat (class 3) approval (Ultra-durable) matt thermosetting powder coating based on TGIC FREE polyester.

Transmitted as filled below:

- For your use For review Approved as submitted
 Other

Copy to: Research & Development

Signature:



Hamed Fakharzadeh
Central Laboratory Manager



TECHNICAL DATA SHEET

PEKACOAT PE 231A

Product Description

PE 231A is a range of QualiCoat (class 3) approval (Ultra durable) matt thermo-setting powder coating based on TGIC FREE polyester with excellent weathering resistance.

- * **Good surface leveling**
- * **Good mechanical properties**
- * **Excellent weathering resistance**
- * **Good corrosion resistance**

Uses

- * **Aluminum profile**
- * **Automotive wheels**
- * **Air conditioners**
- * **Lawn furniture**
- * **Light fixtures**
- * **Lawn and garden equipment**
- * **Electrical enclosures**

Powder properties

Specific gravity	ASTM D5965	1.2-1.7 gr/cm ³
Color and pattern	RAL K7	A wide range of color and pattern
Particle Size	laser particle size analyzer	Suitable for electrostatic spray
Shelf life	-	12 months
Theoretical Coverage	at 60 µm film thickness	9.8 –13.8 m ² /Kg

Film properties

Film Thickness	ISO 2360	60-80 µm
Gloss	ISO 2813 (°60)	≤ 30
Buchholz Hardness	ISO 2518	≥ 80
Direct Impact	ASTM D2794	25 N.m
Reverse Impact	ASTM D2794	25 N.m
Adhesion	ISO 2409 (2 mm Crosshatch)	Gt 0
Cupping test	ISO 1520	≥ 5 mm
Salt Spray	ASTM B117 (1000 hr)	Blistering < 1mm
Constant Humidity	ISO 6270-1 (1000 hr)	Blistering < 1mm
Accelerated weathering	Florida test (3years)	Gloss retention ≥ 80 %
Bend test	ISO 1519	≤ 4mm
Kesternich-test	ISO 3231 (30 cycles)	No infiltration exceeding 1 mm
Machu test	Qualicoat 2.11	No infiltration exceeding 0.5 mm
Mortar resistance	ASTM D3260	No defects no detachment



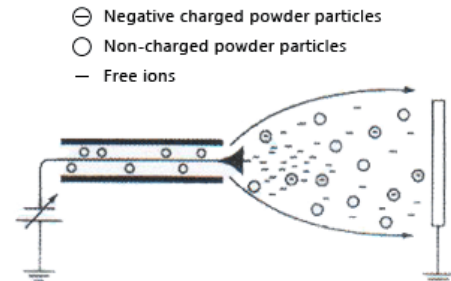
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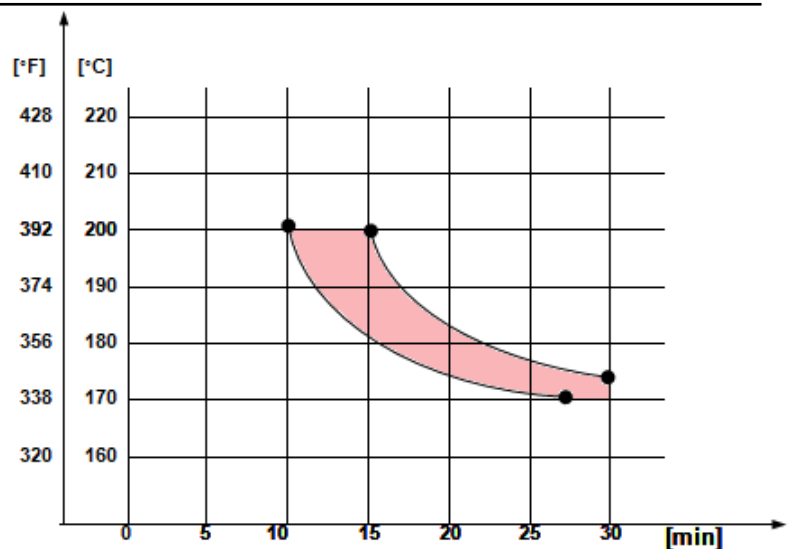
Application Method

PEKACOAT PE 231A can be applied by electrostatic spray equipment which can provide a negative tension of 70-100 Kv (corona) and tribo guns (If the seventh character of code is T).



Cure Schedule

Metal T (°C)/ Time (min)
200(°C)/ 10 (min)
190(°C)/ 13 (min)
180(°C)/ 15 (min)



Storage

The recommended optimum conditions for powder storage are:

- Temperature < 25°C
- Relative humidity 50 - 65%
- Away from direct sunlight

Health and Safety

Safety Phrases:

Do not breathe dust. Avoid contact with skin and eyes. Wear suitable protective clothing and eye/face protection.

Skin Contact:

If skin or hair contact occurs, immediately remove any contaminated clothing and wash skin and hair thoroughly with running water. If swelling, redness, blistering or irritation occurs seek medical assistance.

Eye Contact:

If in eyes, hold eyelids apart and flush the eye continuously with running water. Continue flushing until advised to stop by a Poisons Information Centre or a doctor, or for at least 15 minutes.