



**PEKA  
CHEMIE**  
INDUSTRIAL COMPANY

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## Letter Of Transmittal

Date: Sept 27<sup>th</sup> 2018

Reference:

We are sending you:

- Letter     Attached     Order     Prints     Samples  
 Specifications     Others

Item	Date	Revision	Description
1	Sept 27 <sup>th</sup> 2018	Rev. 2	PE 111A- a range of QualiCoat (class1) approval matt thermosetting powder coating based on polyester/TGIC.

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 111A

#### Product Description

PE 111A is a range of QualiCoat (class 1) approval matt thermosetting powder coating based on polyester/TGIC. PE 111A designed for exterior application with very good weathering resistance.

- \* **Excellent surface leveling**
- \* **Good mechanical properties**
- \* **Very good weathering resistance**
- \* **Very Good corrosion resistance**

#### Uses

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

#### Powder properties

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

#### Film properties

<b>Film Thickness</b>	<b>ISO 2360</b>	60-80 µm
<b>Gloss</b>	<b>ISO 2813 (°60)</b>	≤ 30
<b>Buchholz Hardness</b>	<b>ISO 2518</b>	≥ 80
<b>Direct Impact</b>	<b>ASTM D2794</b>	25 N.m
<b>Reverse Impact</b>	<b>ASTM D2794</b>	25 N.m
<b>Adhesion</b>	<b>ISO 2409 (2 mm Crosshatch)</b>	Gt 0
<b>Cupping test</b>	<b>ISO 1520</b>	≥ 5 mm
<b>Salt Spray</b>	<b>ASTM B117 (1000 hr )</b>	Blistering < 1mm
<b>Constant Humidity</b>	<b>ISO 6270-1 (1000 hr )</b>	Blistering < 1mm
<b>Accelerated weathering</b>	<b>ISO 11341 (1000 hr)</b>	Gloss retention ≥ 50 %
<b>Bend test</b>	<b>ISO 1519</b>	≤ 4mm
<b>Kesternich-test</b>	<b>ISO 3231 (30 cycles)</b>	No infiltration exceeding 1 mm
<b>Machu test</b>	<b>Qualicoat 2.11</b>	No infiltration exceeding 0.5 mm
<b>Mortar resistance</b>	<b>ASTM D3260</b>	No defects no detachment

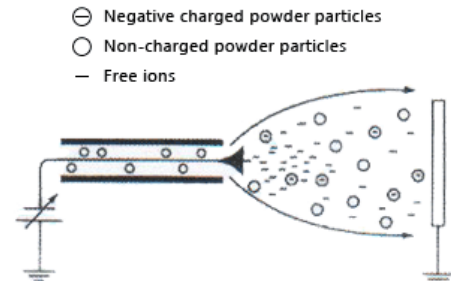


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### PEKACOAT PE 111A

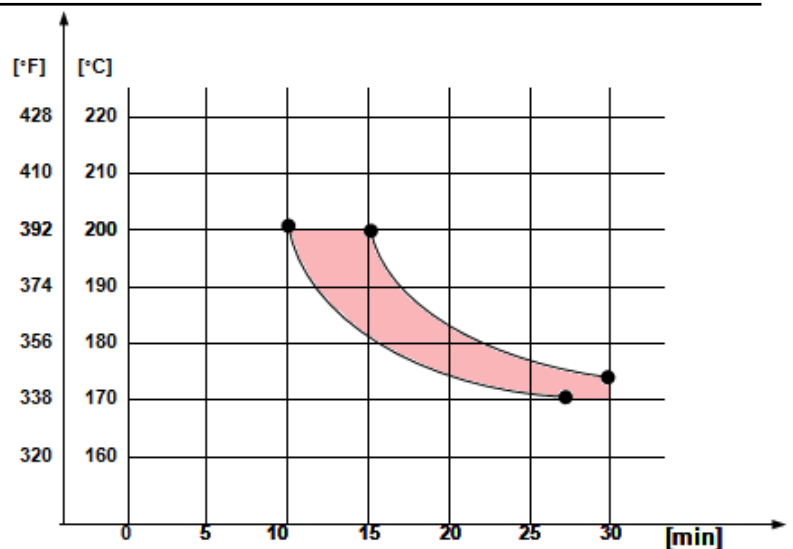
#### Application Method

PEKACOAT PE 111A 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.