

# IBAMOIRE\_PU37

## Technical Data Sheet

### Description

**IBAMOIRE\_PU37** is special effect thermosetting powder coatings based on polyurethane resins designed for interior and exterior applications. It has high UV and chemical resistance and very good mechanical properties.

### Characteristics

Available for all RAL colour  
 One coat finishes  
 Suitable for most environments  
 Less waste and pollution to the environment  
 Hide substrate imperfections with slight texture effect  
 Very good mechanical properties  
 Hard wearing/serviceable finish  
 Very good chemical resistance  
 Resists solvents and detergents

### Applications

Office furniture  
 Garden tools  
 Computer equipment  
 Lighting equipment

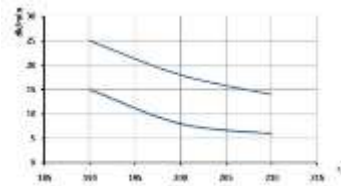
### Product Properties

**UV Resistance** Good UV resistance  
**Surface** Moire (MR) effect  
**Specific gravity** 1.2-1.8 gr/cm<sup>3</sup> (low with dark colours, high with light colours)  
**Shelf Life** 12 months (< 30°C and < 50% RH)

### Application Data

**Application** Corona (Can be applied by tribo guns if product code has "T" for the 6th character)  
**Curing** 200°C 15 minutes recommended  

Metal Temperature (°C)	Time (minutes)
190	15-25
200	8-18
210	5-14



**Film Thickness** 70 – 90 µm\*

**Theoretical cons.** 8-11 m<sup>2</sup>/kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

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*\* Effect changes may occur below or above the recommended film thickness values. Nodes may occur for thicker applications.*

### Coating Properties

Test results shown below are based on 0.5 mm steel with 60µ applied powder coatings.

<b>Direct Impact</b>	>20 kgcm	(ISO 6272-2)
<b>Reverse Impact</b>	>20 kgcm	(ISO 6272-2)
<b>Conical Mandrel</b>	0 mm	(ISO 6860)
<b>Cross Hatch Adhesion</b>	Gt:0	(ISO 2409)

### Application Guide

#### Surface Preparation

All surfaces should be degreased and pretreated for optimal performance.

Suitable pretreatment includes:

Aluminium	Yellow chromate or green chromate/phosphate
Ferrous metals	Zinc phosphate or Iron phosphate
Zinc Coated Metals	Zinc phosphate or chromate

#### Application Procedure and Equipment

**IBAMOIRE\_PU37** series powder coatings charging properties are optimized when powder is free-flowing and moisture-free. Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.

If storage room temperature is lower than the application area, powder coatings, which are hygroscopic, should be acclimated in unopened containers prior to adding into the spray hopper. For optimum performance, It should be applied and stored at air-conditioning area. Storage temperatures should be kept below 30 °C.

Powder should not be stored in hoppers for long periods of time. If moisture condensation occurs, fluidize powder to dry-out or replace moisture-laden powder with virgin powder.

Powder coatings are finely ground particulates. Respirators or dust masks should be used by workers exposed to powder in order to avoid dust inhalation.

Compressed air to the gun must be oil and moisture free.

Silicone should not be used in application area.

For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.

Contact points should be maintained to ensure metal-to-metal ground.

Apply by electrostatic spray. Relative humidity should be 50-60% for corona system, lower than 40% for tribo system.

Cure as per recommendations outlined above.

Reclaim-to-virgin ratios should be carefully monitored to maintain spray consistency.

Sieving powder before adding to hopper eliminates potential clumping or foreign matter.

Test for cure of the coating by impact test.

### Care and Maintenance

**IBAMOIRE\_PU37** should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse to maintain the attractive appearance of the powder cured film.

the use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

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## Health and Safety

The SDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed. It is recommended to contact to Sales and Customer Service Offices for further information.

## Precautions and Limitations

As a result of possible wide application variations and stoving conditions, **IBAMOIRE\_PU37** may show variation, between İBA Kimya Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.

For optimum performance ensures recommended dry film thickness is obtained.

Not recommended for use in highly corrosive environments.

Maximum reclaim to be added is recommended at 15%

Heating rate fluctuation may change the surface effect.

## Transport and Storage

<b>Packaging</b>	15-20-25 kgs. Heavy polyethylene bag in a corrugated carton
<b>Shipment</b>	Not dangerous goods. No special transport requirements.
<b>Storage Conditions</b>	Storage temperatures should be kept below 30 C° and 50% relative humidity. Powder should be stored in closed containers.



*DISCLAIMER: All the information given in this Data Sheet is the result of our research work experience. It is given in good faith and with every belief in its accuracy but cannot be considered as a formal warranty. In accordance with İBA KİMYA, policy of product development, this specification is subject to change without notice.*