

BASEPOX® PE 50-7191 GREY 3L PRIMER 1

Created on 18.09.2003
Revision 21 of 16.06.2014

THERMODYNAMIC CHARACTERISTICS

Differential Scanning Calorimetry (TA Instruments Q10)
According with norm ISO 21809-2 (clause A.8) equivalent to ISO 11357-2

Tg 1 (powder, inflection point)	58 ± 5° C / 135 ± 7 °F
Tg 2 (cured film, inflection point)	104 ± 3° C / 219 ± 5 °F
Delta H (Enthalpy)	45 ± 5 J/g

SHELF LIFE

According with ISO 8130-8 : 12 months at 25°C (77° F) and 65 % relative humidity.
Lower temperature and humidity are recommended. **Do not exceed 30°C (86°F)**.

SURFACE PREPARATION

Surface preparation by abrasive blast cleaning shall, as a minimum, meet the requirements of ISO 8501-1, Sa 2 ½ grade. The blast cleaned surface shall have a roughness RZ between 40 and 110 µm (1.6 – 4.4 mils) as measured in accordance with ISO 4287-1.
The surface shall be dry and free from contamination.
Chemical pretreatment is allowed .

APPLICATION

This powder performs best when applied through electrostatic spraying.
For fluidized bed application special grades are available.

RECOMMENDED FILM THICKNESS

Thickness of Basepox® PE 50-7191 as primer in multi-layer application is typically
75 - 200 µm (3 - 8 mils).

THEORETICAL YIELD

104 g /m² at 70 µm dry film thickness
9.6 m²/kg at 70 µm dry film thickness
129 ft² / lbs / mil

DIVISIONE VERNICI IN POLVERE

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Certificato n.187

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THEORETICAL CURING SCHEDULE

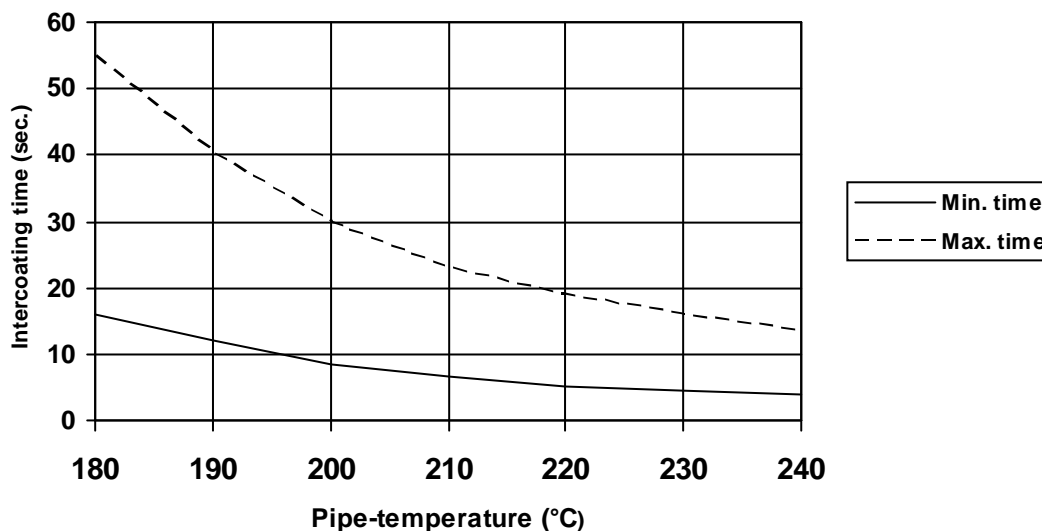
To achieve maximum performance properties the following application window is recommended for Basepox® PE 50-7191.

Minimum time before quenching	
at 180°C (356°F)	240 s
at 200°C (392°F)	150 s

MULTILAYER APPLICATION RECOMMENDED INTERCOATING TIME PRIMER - ADHESIVE

To achieve maximum performance properties the following application window is recommended. The above figures are provided for guidance only. The exact timing should be verified by testing in line.

Application window



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PROPERTIES OF CURED FILM **(Typical values)**

FLEXIBILITY

ISO 21809-2 (clause A.12)
CAN /CSA 245.20-06 (clause 12.11)
BG-CW 6

Pass 2.0° at 0°C (32°F)
Pass 3.0° at -30°C (-22°F)
Pass at 23°C (73°F) and - 30°C (- 22°F)

TENSILE STRENGTH

ASTM D-2370

> 600 kg / cm² (8400 psi)

IMPACT RESISTANCE

ISO 21809-2 (clause A.13)
CAN/CSA 245.20-06 (clause 12.12)

> 1.5 J at -30°C (-22°F)

SPECIFIC ELECTRICAL INSULATION RESISTANCE

DIN 30670

$R_s > 10^9 \text{ Ohm} \cdot \text{m}^2$

CATHODIC DISBONDMENT

ISO 21809-2 (clause A.9)
CAN/CSA 245.20-06 (clause 12.8)

20°C (68°F) , 28 days
65°C (149°F) , 24 hours
65°C (149°F) , 28 days

≤ 8 mm disbonded radius
≤ 6.5 mm disbonded radius
≤ 15 mm disbonded radius

RESISTANCE TO STRAIN POLARIZATION

28 days , BG CW6 pt. 1
ISO 21809-2 (clause A.14)
CAN/CSA 245.20-06 (clause 12.13)

Pass (No cracking)

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BUCHHOLZ HARDNESS

UNI EN ISO 2815

Min. 91

REMARKS

Basepox[®] PE 50-7191 is also available as

_ Basepox[®] PE 50-7190 with higher reactivity and reduced gel time

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