

BASEPOX[®] PE 50-1091 YELLOW 3L PRIMER L.C.

Created on 29.06.2011
Revision 09 of 22.05.2015

THERMODYNAMIC CHARACTERISTICS

Differential Scanning Calorimeter

According with norm ISO 21809-2 (clause A.8) equivalent to ISO 11357-2

Tg 1 (powder, inflection point)	62 ± 5° C / 143 ± 9 °F
Tg 2 (cured film, inflection point)	102 ± 5° C / 215 ± 9 °F
Delta H (Enthalpy)	42 ± 4 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 50-7791 as primer in multi-layer application is typically 75 - 200 µm (3 - 8 mils).

THEORETICAL YIELD

110 g /m² at 70 µm dry film thickness
9.1 m²/kg at 70 µm dry film thickness
122 ft² / lbs / mil

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Certificato n.187

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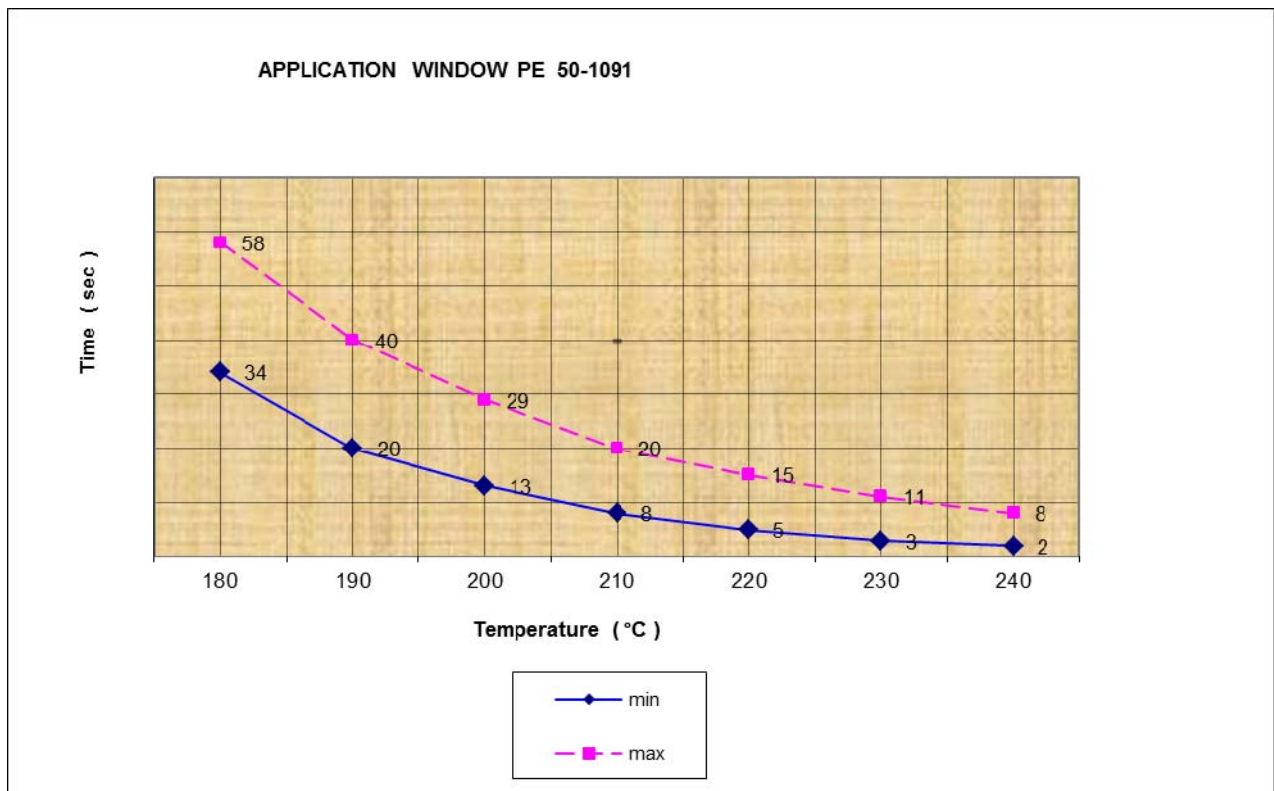
THEORETICAL CURING SCHEDULE

To achieve maximum performance properties the following application window is recommended for Basepox® PE 50-1091.

at 232°C (450°F)	90 sec.
at 238°C (460°F)	80 sec.
at 243°C (470°F)	70 sec.

MULTILAYER APPLICATION RECOMMENDED INTERCOATING TIME PRIMER - ADHESIVE

To achieve maximum performance properties the following application window is suggested .



The above figures are provided for guidance only; exact timing should be verified by testing in line .
 Recommended thickness is 100 - 150 µm (4 - 6 mils) , as per our internal laboratory trials .

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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)

IMPACT RESISTANCE

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

> 1.5 J at -30°C (-22°F)

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)

BUCHHOLZ HARDNESS

UNI EN ISO 2815

Min. 91

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