

## ELM PLI36

# Technical Data Sheet

## ELM PLI36 *Outdoor quality*

ELM PLI36 is thermosetting powder coating with TGIC free based on saturated polyester resin base, the corresponding hardener plus special heat, light and chalk resistant pigments. Thanks to special resin technology they have very good outdoor quality and flow. It has good yellowing resistance combined with excellent overall performance.

### Characteristics

- TGIC free
- Low cure
- Very good weather and light resistance
- Excellent mechanical properties
- Good general resistance properties
- No VOC

### Powder specifications

- Particle size < 300  $\mu\text{m}$
- Average particle size 30-60  $\mu\text{m}$
- Solids > 99%
- Density 1,3-1,8 gr/cm<sup>3</sup>
- Storage stability min 12 months
- Storage Temperature cool and dry at < 25° C

### Applications

- Facade elements, window profiles
- Doors
- Agricultural machines
- Garden and Camping furniture
- Lights
- Office furniture
- Bicycle frames

### Product range

## ELM PLI36

Surface appearance

Smooth gloss, smooth semigloss, smooth semimatt, wrinkle and texture effect.

Colors

Mainly RAL, Pantone and NCS shades, special shades on request

### Product performance

To obtain the following data, ELM PLI36 was coated as follows

Degreased steel 0,5 mm  
Coating thickness 70-100 µm  
Object temperature 160 °C 10 min

Test	Method	Result
Impact	ASTM D2794	> 20 kgcm
Erichsen cupping	ISO 1520	> 5 mm
Buchholz hardness	ISO 2815	> 90
Mandrel bending		< 5 mm
Cross-cut adhesion	ISO 2409	GT 0

Condensed water and salt spray test results depend on pre-treatment of metal  
> 400 hrs condensed water test DIN 50017; no infiltration, no blisters for zinc fosfate steel  
> 400 hrs nautral salt spray test ISO 9227; no infiltration, no blisters for zinc fosfate steel

### Application instructions

The substrate to be coated must be free of dirt, oil, rust etc.

For aluminium depending on intended purpose, degreasing or chromatising

For steel metal depending on intended purpose, degreasing, Fe –phosphating or Zinc phosphating

ELM PLI36 can be applied by all commercial electrostatic systems both corona.

### Curing Schedule

Object temperature	Retention time at object temperature
150 °C	15 min
160 °C	10 min
170 °C	8 min

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