

ELM PLA33

Technical Data Sheet

ELM PLA33 *Super Durable*

ELM PLA33 is a polyester HAA super durable matt powder coating compliant to Qualicoat with excellent weather resistance properties for high performance architectural exterior applications.

Characteristics

- Super durable Matt surface
- TGIC free
- Excellent weather and UV-light resistance
- Good mechanical properties
- Good general resistance properties
- No VOC

Powder specifications

- | | |
|-------------------------|----------------------------|
| - Particle size | < 300 µm |
| - Average particle size | 30-60 µm |
| - Solids | > 99% |
| - Density | 1,3-1,8 gr/cm ³ |
| - Storage stability | min 12 months |
| - Storage Temperature | cool and dry at < 25° C |

Applications

- Facade elements, window profiles
- Doors
- Agricultural machines

Product range

Surface appearance

Smooth matt

Colors

ELM PLA33

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

Product performance

To obtain the following data, ELM PLA33 was coated as follows

Degreased steel 0,5 mm
Coating thickness 70-100 µm
Object temperature 200 °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 PLA33 can be applied by all commercial electrostatic systems both corona.

Curing Schedule

Object temperature	Retention time at object temperature
190 °C	15 min
200 °C	10 min
210 °C	8 min

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