

Technical Data Sheet

ELM HYB 24 *Indoor quality*

ELM HYB 24 is ultra low cure thermosetting powder coating based on polyester and epoxy resins. It has good yellowing resistance combined with good overall performance.

Characteristics

- Ultra low cure
- Good mechanical properties
- Good overall performance
- No VOC

Powder specifications

- Particle size < 300 µm
- Average particle size 30-60 µm
- Solids > 99%
- Density 1,3-1,8 gr/cm³
- Storage stability min 12 months
- Storage Temperature cool and dry at < 25° C

Applications

- Factory equipment
- Office furniture
- Ceiling panels
- Household appliances
- Radiators
- Lighting systems
- Shelving components
- Machine elements

Product range

Surface appearance

ELM HYB 24

Smooth gloss, Smooth semigloss, wrinkle and texture effect

Colors

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

Product performance

To obtain the following data, ELM HYB 24 was coated as follows

Degreased steel 0,5 mm
Coating thickness 60-80 µm
Object temperature 140 °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 HYB 24 can be applied by all commercial electrostatic systems both corona and tribo

Curing Schedule

Object temperature Retention time at object temperature

120 °C	30 min
130 °C	17 min
140 °C	10 min
150 °C	8 min

DISCLAIMER: All the information given in this technical data sheet is the result of our experience. Application, use and processing of the products take place outside our ability to supervise and therefore exclusively applicator's responsibility. The policy of product development, this specification is subject to change without notice.