

ELM PLA35

Technical Data Sheet

ELM PLA35 *Outdoor quality*

ELM PLA35 is matt 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.

Characteristics

- Matt surface
- TGIC free
- **Approved by Qualicoat (P-1842)**
- Very good weather and light resistance
- Excellent 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/cm³
- Storage stability min 24 months (min 12 months for metallic color)
- Storage Temperature cool and dry at < 25° C

Applications

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

Product range

ELM PLA35

Surface appearance

Smooth matt, wrinkle effect

Colors

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

Product performance

To obtain the following data, ELM PLA35 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 PLA35 can be applied by all commercial electrostatic systems both corona.

Curing Schedule

Object temperature	Retention time at object temperature
190 °C	15-17 min
200 °C	10-12 min
210 °C	8-10 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.