



PE74 SERIES

TGIC-free Polyester System



Product Data

The PE74, Polyester TGIC Free formulation is cured with an advanced TGIC Free curative that offers a coating with the following unique properties. These properties include:

- High flow polyester suited for industrial OEM equipment
- Excellent powder transfer and spray characteristics
- Excellent mechanical properties
- Exterior durability
- Uses ECT (Economical Coating Technology)

Uses

The PE74 powder coating is suitable for a wide variety of decorative and functional applications, including:

- Architectural fittings (non-extrusion)
- Automotive underhood and alloy wheels
- Metal furniture
- Garden and Lawn equipment parts
- Craftware products
- Outdoor lighting
- Metal cabinets e.g. filing, lockers, tool boxes

Suitable for general industrial exterior and interior applications. Offers best price/performance point.

Availability

Made to individual order.

Substrates

Cold rolled mild steel (CRS)

Zinc coated steels

Aluminium alloys

Specific Gravity

1.2 to 1.8 dependent on colour

Pre-treatment

CRS: Zinc or iron phosphate

Zinc Coated Steels: Zinc phosphate

Aluminium Alloys: Chromate conversion

Application

Corona or Tribo spray equipment. May be applied using fluidised bed methods.

The recommended film thickness for the cure powder film is between 60 and 90 microns.

Curing

Standard curing conditions are:

7 mins @ 200 deg C, 10 mins @ 180°C (object temp).

It is not recommended that temperatures of less than that stated be used as performance will be impaired.

Film Properties

Mechanical tests carried out on lightweight, zinc phosphate pre-treated panels with 60 micron (DFT) finish film. Panels baked for 10 mins @ 180 deg C (object temp).

Mechanical:

Flexibility (conical mandrill) ASTM D522 Pass < 3mm

Adhesion (crosshatch) BS3900:E6 Pass GTO

Rev impact resistance BS3900-E3 1A 100kg.cm

Pencil hardness AS1580.405.1 H

Chemical:

Salt spray ASTM-B117-95 Pass < 3mm, 1000hrs

Cyclic humidity ASTM D2247-94 Pass. No blistering after 1000hrs

Generally very good resistance to acids, alkalis, oil and most solvents at normal temperatures.

Exterior Durability

Application to be over approved pre-treatment system.
Minimum film thickness to be 60 microns. For continuous exposure to exterior weather conditions please contact your local PPG Industries Technical Sales Representative.

Storage and Packaging

Packaging: Cardboard boxes – 20kg. Bulk packs available to suit your requirements.

Shelf Life: 12 months minimum @ <30° C/dry. All bags must be sealed before storage.

Store in a cool, dry area.

Health & Safety

PPG Envirocron powder coatings can generally be regarded as inherently non-toxic.

Powder on the skin should be washed off using soap and water. Powder in the eyes should be washed out with water for 15 minutes.

Avoid breathing airborne dusts: wear an approved dust mask.

Ovens should be exhausted to atmosphere.

Users should refer to "Code of Safe Practice" as supplied by Paint Makers' Association (UK) and NZ Department of Labour.

For further information, refer to the Material Safety Data Sheet for this product.

CAUTION:

Improper use and handling of this product can be hazardous to health.

This product is to be used by those knowledgeable about proper application methods. PPG Industries makes no recommendation about the types of safety measures that may need to be adopted because these depend on application environment and space, of which PPG Industries is unaware and over which it has no control.

If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.

This product is for professional use only. Not for residential use.

Technical information given verbally or in writing is based on knowledge and research, given in good faith and believed to be reliable, but no guarantee of accuracy is made or implied. Since methods and conditions of use are beyond our control, all merchandise is sold and received subject to the condition that our liability whether express or implied for any defect in quality, or for any lack of fitness for the specified use thereof, is limited to the return of the purchase price if written claim is made within 14 days from date of delivery. It is recommended that the user makes his or her own tests to determine the suitability of the product for his own requirements. Freedom from patent restrictions is not implied.

**PPG Industries NZ Ltd • 5 Monahan Road • Mt Wellington • Auckland • Phone 0800-263 766 • Fax 0800-659 377
PPG Industries Australia Ltd • McNaughton Rd • Clayton • VIC 3169 • Phone 1300 305 699 • Fax 1300 304 214**