



KARUMEL PX4331-SR is a polyester resin based thermosetting powder coatings with structure finished appearance. It has excellent appearance, weather resistance and color retention.

<b>Recommended use</b>	As a protective and decorative coating for use on electric home appliances, pipe, building materials, automobile parts, office equipments etc.
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### Physical Properties

<b>Finish and Color</b>	GLOSS * Color and pattern are available on request.	
<b>Dried film Properties</b>	The data are typical for PX4331-SR applied to Cold Rolled Steel panels(thickness 0.7 mm) pretreated with Zinc Phosphate, coated with a thickness of ca. 70 $\mu\text{m}$ , and cured at 180 $^{\circ}\text{C}$ (356 $^{\circ}\text{F}$ ) for 10 minutes.	
	PROPERTY	TEST DESCRIPTION
	Adhesion	Cross-cut 100 / 100, 1 mmtester
	Impact	Dupont Impact Tester(1/2"Φ)
	Bending	6 mm Mandrel at 180 $^{\circ}$
	Salt spray resistance	Salt spray tester, 240 hr
		RESULT
		100 / 100
		500 g/ 30 cm
		No Crack
		Good
	* Salt spray resistance according to substrate and surface treatment.	
<b>Specific gravity</b>	Air pycnometer method, 1.3 ~ 1.7 g/cm $^3$	
<b>Spreading rate (Theoretical)</b>	70 $\mu\text{m}$ dry film thickness : 8.0 ~ 10.4 m $^2$ /kg	

### Application details

<b>Surface preparation</b>	The surface must be clean and free from rust, dust, oil, grease and other contamination. Types of pre-treatment are recommended as follows: Steel : Iron Phosphate or Zinc Phosphate Aluminum : Chromate	
<b>Film thickness</b>	Dry film thickness : 60 ~ 100 $\mu\text{m}$	
<b>Drying time</b>	The following theoretical curing schedules are recommended to achieve the best performance properties.	
	Temperature	Cure time
	180 $^{\circ}\text{C}$ (356 $^{\circ}\text{F}$ )	10 minutes(M.P.T)
	* The cure time may have deviations influenced by various factors. * M.P.T means metal peak temperature.	

### Storage and package

<b>Shelf life</b>	12 months at 25 $^{\circ}\text{C}$ cool and dry place (Cooler temperature and lower humidity are recommended)
<b>Packing Unit</b>	20 kg

Remarks	
<b>Handling</b>	Do not mix the powder with other powder even if it is small amount.
<b>Precautions</b>	Recovered powders should be incorporated with virgin powders for re-use, only after sieving and at a recommended maximum of 30%. A structure finish requires a recommended film thickness of 70~100 $\mu$ m to allow proper coverage. Exact application and cure conditions need to be followed to maintain consistent structure finish and flat finish.
<b>1'st issue</b>	2018-10-31
<b>Revision</b>	

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

