



Polyarmor® G17T Texture

General Description

A functionalized polyethylene copolymer based thermoplastic powder coating designed for maximum mechanical performance, impact resistance and UV-stability. Polyarmor® G17 Texture is a non-skid protective coating.

Surface Preparation

Chemical Pretreatment - Multi-stage phosphate conversion coating may be used

Mechanical Preparation - (SSPC-SP6) 2-3 mil (50-75µm) anchor profile using clean, sharp edged blast media

NOTE: Properly preparing parts before powder coating is essential for a quality finish. This includes cleaning, rinsing, drying and insuring the substrate surface is free and clear of any contaminates.

Fluidized Bed

For fluidized-bed dipping, preheat parts to 450° F (230°C) adjusting for part thickness. Dip parts in fluidized-bed of Polyarmor® G17 Texture for 8-10 seconds. Allow excess powder to stand for 1 minute then carefully blow off the excess material. Post bake coated part @380° F - 400° F (193 - 205°C) for 3 – 4 minutes.

Important: Polyarmor® G17 Texture is designed to texture on the HORIZONTAL surface of the part. There will be slight texturing on vertical surfaces. For best results, do not water quench cool Polyarmor® G17 Texture.

Electrostatic Deposition

Polyarmor® G17T can be applied via electrostatic deposition with or without pre-heat. When not using pre-heat, the powder should be applied to achieve a thickness of 8 – 10mils (203 - 254µm). Recommended voltage setting when using Corona equipment is 40 – 60 kv. Post-baking at 350 - 425°F (175 - 220°C) for 5 to 10 minutes depending on metal thickness, or until desired flow out is achieved. For pre-heated parts, the recommended preheat temperature is 400°F (205°C). Deposit Polyarmor® G17 8-12mils (203 – 300µm) or higher if desired. For improved surface finish, parts may be post-baked for a short period of time if necessary. Times and temperatures in the oven will depend on configuration and thickness of the part.

No Cure Time

Thermoplastic powder coatings need only be heated enough to flow out the coating, nothing more. Overheating may cause degradation or embrittlement of the coating. Coating may be put into service when cooled.

Powder Properties	
Coverage (100% efficiency)	25.65 ft ² per pound @ 8mils (5.24 m ² per kg @ 203µm)
Particle Size	Available in fluid bed & spray grades
VOC Content	ZERO
Thickness (Recommended)	8 - 30mils (203 – 762µm)
Storage Stability	Store in dry area below 90° F, keep container closed with liners sealed and out of direct sunlight and any moisture or external contaminates. Always use good manufacturing practices.

Performance Properties		
Melting Point		221°F (105°C)
Specific Gravity	ASTM D 792	0.95g/cm ³
Adhesion	ASTM D 4541	800psi (5.6MPa)
Impact Resistance	ASTM B 2794	>320 in-lbs (35.8 Joules)
Vicat Softening Point	ASTM D 1525	162°F (72°C)
Tensile Strength	ASTM D 638	3482psi (12MPa)
Elongation (%)	ASTM D 638	13%
Humidity Resistance	ASTM D 2247	No blistering or loss of gloss after 1000 hours
Salt Spray	ASTM B 117	2,000 hrs. no significant change in color or gloss
QUV	ASTM G 53	2,000 hrs. no significant change in color or gloss
Taber Abrasion	ASTM D 4060	26mg loss, CS 17 wheel, 100mg loss, CS 17 wheel
Flexibility (Conical Mandrel Bend)	ASTM D 522	1/8in (3.2mm), no cracks (>32%)
Gloss	ASTM D 523	12
Melt Index	ASTM D 1238	20

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