



KARUMEL EX8816-SR is an epoxy/polyester resin based thermosetting powder coatings with structure finished appearance. It has excellent appearance, flexibility, corrosion and chemical resistance.

Recommended use	* As a protective and decorative coating for use on electric home appliances, pipe, building materials, automobile parts, office equipment, etc. * Not recommended for exterior.
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Physical Properties

Finish and Color	Gloss, Metallic		
Specific gravity	AIR PYCNOMETER METHOD, 1.3~1.7 according to color		
Spreading rate (Theoretical)	70 μm dry film thickness, 8.0 ~ 10.4 m²/kg		
Film properties	The data are typical for EX8816-SR applied to Cold Rolled Steel panels(thickness 0.7 mm) pretreated with Zinc Phosphate, coated with a thickness of ca. 70 μm, and cured at 180 °C(356 °F) for 10 minutes.		
	Property	Test Description	Result
	Adhesion	Cross-cut 100 / 100, 1 mm tester 100 / 100	100 / 100
	Impact	Dupont Impact Tester(1/2"Φ)	500g / 30 cm
	Bending	6 mm Mandrel at 180°	No cracking
	Salt spray resistance	Salt spray tester, 240 hr	Good
	* Values will vary with color.		

Application details

Surface preparation	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, Zinc Phosphate, Blasting (the surface to Near-White (SSPC-SP10, Swedish Standard Sa2.5, NACE No.2), profile 38~100 μm) * Aluminum: Chromate
Drying time	The following theoretical curing schedules are recommended to achieve the best performance properties. Temperature – 180°C (356°F) / Cure-time – 10 minutes (M.P.T) *The cure time may have deviations influenced by various factors.

Storage and package

Shelf life	Below 25 °C (77 °F) with relative humidity 65% sealed state : Max. 12 months (Cooler temperature and lower humidity are recommended).
Packing Unit	20 kg

Remarks

Handling Precautions	* Do not mix the powder with other powder even if it is small amount. * Recovered powders should be incorporated with virgin powders for re-use, only after sieving and at a recommended maximum of 30%. * Keep the curing condition.
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	* A structure finish requires a recommended increased film thickness of 70~100μm to allow proper coverage. * Exact application and cure conditions need to be followed to maintain consistent structure finish and flat finish.
Note	* The information is believed to be accurate without any obligation to KCC Corporation. * Refer to Material Safety Data Sheet for complete hazard and safety information. * All data are based on laboratory testing and practical experience. * Contact KCC sales representative for further information.
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Revision	

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.

