



KARUMEL PX4332 is a polyester resin based thermosetting powder coatings with texture finished appearance and weathering resistance and color retention.

Recommended use	As a protective and decorative coating for use on electric home appliances, building materials, automobile parts, office equipment etc.
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Physical Properties

Finish and Color	Semi-gloss, flat		
Specific gravity	AIR PYCNOMETER METHOD 1.3~1.7 according to color		
Spreading rate (Theoretical)	60 μm dry film thickness 9.3 ~ 12.2 m^2/kg		
Film properties	The data are typical for PX4332 applied to Cold Rolled Steel panels(thickness 0.7 mm) pretreated with Zinc Phosphate, coated with a thickness of ca.60 μm , and cured at 180 $^{\circ}\text{C}$ (356 $^{\circ}\text{F}$) for 14 minutes.		
	Property	Test Description	Result
	Adhesion	Cross-cut 100 / 100, 1 mm	100 / 100
	Impact	Dupont Impact Tester(1/2"Φ)	500g / 30 cm
	Bending	6 mm Mandrel at 180°	No crack
	Weathering resistance	Weather-O-Meter, 500 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. 180$^{\circ}\text{C}$(356$^{\circ}\text{F}$), 14 minutes(M.P.T) *The cure time may have deviations influenced by various factors.

Storage and package

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

Remarks

Handling	Do not mix the powder with other powder even if it is small amount.
Precautions	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.

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.
1'st issue	2013-09-01
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.

