



KARUMEL PX8576(M) is a polyester resin based thermosetting powder coatings with metal finished appearance by mixing metallic pigment.

<b>Recommended use</b>	As a protective and decorative coating for use on exterior product, building materials, automobile parts, etc. * It is recommended to paint clear top to prevent yellowing from moisture, chemicals and thinner.
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### Physical Properties

<b>Finish and Color</b>	Metallic. Colors and patterns are available on request.																		
<b>Dried film Properties</b>	The data are typical for EX8816(M) applied to Cold Rolled Steel panels (thickness 0.7mm) pretreated with zinc phosphate, coated with a thickness of 60 $\mu$ m, and cured at 180 $^{\circ}$ C (356 $^{\circ}$ F) for 10 minutes.																		
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	* Salt spray resistance according to substrate and surface treatment.																		
<b>Specific gravity</b>	Air Pycnometer method 1.2~1.7, according to color																		
<b>Spreading rate (Theoretical)</b>	60 $\mu$ m dry film thickness : 9.3~13.1 $\text{m}^2/\text{kg}$ * There is difference in recovery ratio of powder.																		

### 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 : 50~90 $\mu$ m						
<b>Drying time</b>	The following theoretical curing schedules are recommended to achieve the best performance properties.						
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	* 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 $^{\circ}$ C (77 $^{\circ}$ F) with relative humidity 65% sealed state cool and dry place (Cooler temperature and lower humidity are recommended)
<b>Packing Unit</b>	15kg, 20 kg

Remarks	
<b>Handling</b>	1. Do not mix the powder with other powder even if it is small amount.
<b>Precautions</b>	<p>2. Recovered powders should be incorporated with virgin powders for re-use, only after sieving and at a recommended maximum of 30%.</p> <p>3. Keep the curing condition.</p> <p>1) Exact application and cure conditions need to be followed to maintain consistent metallic finish and properties.</p> <p>2) Colors and patterns could be differed by spray gun or substrate.</p> <p>3) Prevent the inflow of dirt and pollutant, because it is easy to find crater or dirt</p> <p>4. Separation of metallic and mica pigments can take place from the powder during application.</p> <p>5. In principle, it is not recommend to paint metallic powder coating unilaterally.</p> <p>6. Clear top coating is recommended where chemical resistance is required.</p>
<b>1'st issue</b>	2011-02-10
<b>Revision</b>	2018-10-31

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.

