



KARUMEL PX8583(H) is a polyester resin based thermosetting powder coatings with hammertone finished appearance. It has excellent weathering resistance and color retention.

Recommended use	As a protective and decorative coating for use on electric home appliances, pipe, building materials, automobile parts, office equipment, etc. * It is recommended to paint clear top to prevent yellowing from moisture, chemicals and thinner.
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Physical Properties

Finish and Color	Gloss, Hammertone, Metallic Hammertone * Color and pattern are available on request																			
Dried film Properties	The data are typical for PX8583(H) applied to Cold Rolled Steel panels(thickness 0.7mm) pretreated with Zinc Phosphate, coated with a thickness of ca. 100 μ m, and cured at 200 $^{\circ}$ C (392 $^{\circ}$ F) for 10 minutes.																			
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	* Values will vary with color.																			
Specific gravity	Air Pycnometer method 1.3~1.7, according to color																			
Spreading rate (Theoretical)	90 μ m dry film thickenss : 6.2~8.1 m^2/kg * There is difference in recovery ratio of powder.																			

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 or Zinc Phosphate * Aluminum : Chromate					
Drying time	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

Shelf life	12 months at 25 $^{\circ}$ C (77 $^{\circ}$ F) cool and dry place (Cooler temperature and lower humidity are recommended)
Packing Unit	20 kg

Remarks	
Handling	1. Do not mix the powder with other powder even if it is small amount.
Precautions	<p>1) If the powder mixed with other powder, the properties is falling-off.</p> <p>2) Particularly, hammertone powder could not be formed pattern.</p> <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 hammer finish and flat finish.</p> <p>2) A hammer fishi requires a recommended increased film thickness of 90~120μm to allow proper coverage.</p> <p>4. Separation of metallic and mica pigments can take place from the powder during application.</p> <p>5. Clear top coating is recommended where chemical resistance is required for metallic hammertone powder.</p>
1'st issue	2018-10-31
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.

