

<b>Part. No.</b>	<b>22LN1900510</b> - ZWART RAL 9005 AG. - SMOOTH - MATT			
<b>Product description</b>	Powder coating system for interior applications. Suitable for high corrosion protection and excellent chemical resistance.			
<b>Chemical composition</b>	Epoxy resin.			
<b>Finish</b>	• Smooth flow > 82*	<b>Serie 29L</b>	• Rough texture,	<b>Serie 2_R</b> , gloss visual.
	• Smooth flow 55÷80*	<b>Serie 26L/ 27L/ 28L</b>	• Coarse-structure,	<b>Serie 2_B</b> , gloss visual.
	• Smooth flow 30÷55*	<b>Serie 24L/ 25L</b>	• Hammertone,	<b>Serie 2_M</b> , gloss visual.
	• Smooth flow 10÷30*	<b>Serie 21L/ 22L/ 23L</b>	• Antique,	<b>Serie 2_A</b> , gloss visual. (**)
	• Smooth metallic-effects, gloss visual (**)			

(\*): gloss level, ISO 2813/60° - (\*\*): Only for Corona application; for details consult RIPOL Guidelines Mod. 83-1008 and Mod. 83-1009.

<b>Curing conditions</b>	<b>15-25 min. @ 180 °C / 10-12 min. @ 190 °C / 6-10 min. @ 200 °C</b> (Object Temperature)
<b>Application method</b>	Corona and Tribo. For Tribo powder coating please confirm before ordering.
<b>Storage, shelf life</b>	24 months from date of manufacture, stored under dry conditions and temperature max 30 °C and Relative Humidity between 20÷70%.
<b>Density</b>	1,61 Kg/dm <sup>3</sup> ± 0,05
<b>Theoretical yield</b>	May be calculated using the formula: $m^2/Kg = 1000 / (S \times P)$ where, S = film thickness in µm; P = density.
<b>Pre-treatment</b>	The overall performance of the coating system is dependent on the nature of the substrate and the type and quality of the pretreatment. Steel or galvanised sheet must be free of oxidation products, or residue from scale, oil, grease. For any ferrous substrates, a zinc-based phosphating improves corrosion resistance.

<b>Test Conditions</b>	The technical data provided below are typical for this product when applied as follows: Substrate: Steel panel (0,8 mm) zinc-phosphated. Coating thickness: 80±10 µm. Curing: 180°C / 20 min.
------------------------	--

## Mechanical, Chemical and Durability tests

Gloss: 15 (± 5) GU (60° - 20'@180°C)	ISO 2813
Cross-cut adhesion test: Gt 0	ISO 2409
Erichsen cupping: ≥ 4 mm	ISO 1520
Hardness Buchholz: ≥ 80	ISO 2815
Reverse and Direct Impact: ≥ 2.5 Nm	ISO 6272
Bend test (cylindrical mandrel): Pass 3 mm	ISO 1519
Resistance to humidity - Part 2: Condensation, 1000 h: blistering max.1 mm	ISO 6270-2
Corrosion tests - Salt spray, 500 h: infiltration, blisters < 1 mm / 1000 h: infiltration, blisters < 3 mm	ISO 9227
Optimal resistance to diluted acids and alkalis and oils at ambient temperatures. Certain chemicals or cleaning materials can cause surface painted modifications. We recommend to do preliminary tests.	
In case that coating will be subject to additional processes (eg. serigraphs, overcoating, sealants or other auxiliary products, any mechanical post treatment), an appropriate test must be carried out to confirm the suitability.	
Powder coating Ripol Serie 2 if exposed to the outside, will show a color change after a few months, keeping the protective properties intact. Therefore exterior use is not recommended.	

**Disclaimer** – The information reported herein is not exhaustive. Use of the product for purposes or uses other than those it was designed for, without prior written authorization of RIPOL S.r.l., is done solely under the user's responsibility. RIPOL S.r.l. takes all care to verify that all advice and directives concerning the product indicated in the relevant reports or verbally conveyed by its personnel are correct and applicable. Nevertheless, RIPOL S.r.l. is not responsible for the conditions of the substrate or of numerous other factors that may affect the final performance of the product. Without a prior written agreement, we cannot accept any responsibility on any of our products for damage or loss (including personal injury of any entity) due to improper use of the product. All information contained in the report is subject to future modifications consequent to continuous development of our expertise and to our policy of constantly improving our products and therefore is not binding.

Part. No.:	Description	Edition	Edition date
22LN1900510	ZWART RAL 9005 AG.	4	7-2-2023

**RIPOL S.r.l.**

Via Donatori del Sangue 25/A, I-20010 SANTO STEFANO TICINO (Milan)  
Ph +39 02 974841.1 - Fax +39 02 974841.70 - [www.ripol.com](http://www.ripol.com)