



Product	BR803729G BS 00-A-05 GOOSE GREY POLYESTER GLOSS
Curing	10 MINS @ 180C Metal Temperature
Brilliance	85-100
Approvals	

## PRODUCT DESCRIPTION

The InverRAL stock range is a polyester powder coating recommended for use in both interior and exterior applications. InverRAL meets the full requirements of BS6496/7. Inver UK's attention to particle size control and formulation ensures optimum transfer efficiency.

### **Storage Life:**

Store in dry, cool conditions, preferably below 30°C. Shelf life under these conditions will be approx 24 months.

## CHARACTERISTICS

**Spec. Gravity (kg/l):** 1,40 – 1,80, depending on color, gloss, etc.

**Theoretical Coverage (m<sup>2</sup>/Kg @60μ):** 9 – 12

**Gloss:** Two gloss levels available (@60°)  
Gloss 80+, Semi-Matt 30 ± 5. Some Semi-Gloss 70+/-5 available.

**Color:** Wide range of RAL colors available.

**Recommended film thickness:**

Dry: 50 - 80 μm

## APPLICATION

Suitable for automatic and manual electrostatic application  
Please contact your Sherwin-Williams representative to discuss tribo-static application

### **Curing Cycle:**

**Gloss and semi-gloss:** 180°C/10 mins object temperature.

**Matt:** 200°C/10 mins object temperature.

## SUBSTRATE PREPARATION

The surface to be coated must be free from oil, grease and flash rust. A good quality pre-treatment process is recommended for optimum performance.

Conversion coating is essential in all cases. The metal must be thoroughly degreased with alkaline or acid cleaner. The conversion coating shall be applied by treatment with a solution of chromate or chromate/phosphate ions as active ingredients.

## PERFORMANCE DATA

### **Adhesion:**

Gt 0  
ISO2409:1992 (2mm)

### **Buchholz indentation test:**

Min 80  
UNI EN ISO 2815:1973

### **Impact test(cm.kg):**

No cracking or detachment  
ASTM D2794: 1969 (2.5Nm)

### **Mandrel Bend test (5mm):**

No cracking or detachment  
ISO1519:1995

### **Kesternich:**

Max 1mm corrosion creep from scribes  
ISO3231:1993 (0.21.S02-24 cycles)

### **Crosscut adhesion (2mm) (GT):**

Class 0  
UNI EN ISO 2409:1992

### **Acetic Acid Salt Spray:**

1000 hours  
Max 16mm<sup>2</sup> over 10cm length of scribe  
UNI ISO 9227

### **Accelerated Weathering**

Loss of gloss max 50% of original value  
ISO1 1341-1994 Luminous intensity 550  
W/m<sup>2</sup> (290-800Nm)

### **Weathering**

Residual gloss >50% of original (min)  
Florida 5° south facing 1 year  
(ISO2810:1974)

### **Resistance to Mortar**

No residue after removal  
ASTM B3260 (24hrs)

### **Resistance to boiling water**

No defects or detachment  
2 hrs de-ionised water or 1 hr pressure  
cooker

### **Condensed water**

No blistering  
DIN50017:1982 (1000 hrs) Max 1mm  
under film creep

### **Sawing, Milling, Drilling**

No cracking or chipping

### **Cupping Test**

(typically 7-9 min)  
ISO1 520: 1995 5 mm min

Substrate used for these tests was  
aluminium alloy AA5005-H24 with a  
thickness of 0.8mm pre-treated  
according to DIN 50939: 1988

InverRAL also complies with  
requirements for Class 0 as defined in  
Approved Document B, "fire Safety" to  
the Building Regulations 2000.

## CAUTION

### **FOR INDUSTRIAL SHOP APPLICATION**

Thoroughly review product label and  
Safety Data Sheet (SDS) prior to using this  
product.

A Safety Data Sheet is available from your  
local Sherwin-Williams facility or  
distributor

**Note:** Product Data Sheets are  
periodically updated to reflect new  
information relating to the product. It is  
important that the user obtain the most  
recent Product Data Sheet for the  
product being used. The information,  
rating, and opinions stated here pertain  
to the material currently offered and  
represent the results of tests believed to  
be reliable. However, due to variations in  
user handling and methods of application  
which are not known or under our  
control, The Sherwin-Williams Company  
cannot make any warranties as to the end  
result.

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### BR803729G - BS 00-A-05 GOOSE GREY POLYESTER GLOSS

Attributes	
Chemical Type	Polyester
Specific Gravity (Theoretical) (kg/l)	1.65 +/-0.10
Coverage @ 60 µm DFT m <sup>2</sup> /kg	9-12
Technical Features	
Film Properties	Range/Value
Recommended Film Thickness	60-80 microns
Flexibility (Cylindrical Mandrel)	
Flexibility (Conical Mandrel)	
Adhesion	
Gloss (60 degrees)	85-100
Gloss (20 degrees)	
Direct Impact (cm/kg)	
Reverse Impact (cm/kg)	
Erichsen Cupping Test (mm)	
<b>Cure Cycle</b>	10 MINS @ 180C Metal Temperature
<b>Appearance</b>	
<b>Application</b>	Suitable for automatic and manual electrostatic application. Please check with your sales representative for Tribo.
<b>Pretreatment</b>	The surface to be coated must be free from oils, grease, and flash rust. A good quality pre-treatment process is recommended for optimum performance.
<b>Substrate</b>	Suitable for metal substrate.
<b>Approval</b>	
<b>Version</b>	

**Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.**

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