



Product	BR410468G BS 08-E-51 YELLOW POLYESTER GLOSS
Curing	10 MINS @ 180C Metal Temperature
Brilliance	80-95
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.

Printed Date: Oct-22

### BR410468G - BS 08-E-51 YELLOW POLYESTER GLOSS

Attributes	
Chemical Type	Polyester
Specific Gravity (Theoretical) (kg/l)	1.66 +/-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)	80-95
Gloss (20 degrees)	
Direct Impact (cm/kg)	
Reverse Impact (cm/kg)	
Erichsen Cupping Test (mm)	
Cure Cycle	10 MINS @ 180C Metal Temperature
Appearance	
Application	Suitable for automatic and manual electrostatic application. Please check with your sales representative for Tribo.
Pretreatment	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.
Substrate	Suitable for metal substrate.
Approval	
Version	

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

Environmental Data Sheet (EDS), Product (SDS) please visit your local Sherwin-Williams facility or [www.PaintDocs.Com](http://www.PaintDocs.Com). Please direct any questions or comments to your local Sherwin-Williams facility. **Note:** All purchases of products from Sherwin-Williams are exclusively subject to Sherwin-Williams' terms and conditions of sale which can be found at [www.Sherwin.Com](http://www.Sherwin.Com). Please review these terms and conditions prior to the purchase of the products. Sherwin-Williams warrants the product to be free of manufacturing defect in accordance with Sherwin-Williams' quality control procedures. Except for the preceding sentence, due to factors that are outside of Sherwin-Williams' control, including substrate selection, and customer handling, preparation, and application, Sherwin-Williams cannot make any other warranties related to the product or the performance of the product. **SHERWIN-WILLIAMS DISCLAIMS ALL WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.** Liability for products proven to be defectively manufactured will be limited solely to replacement of the defective product or the refund of the purchase price paid for the defective product, as determined by Sherwin-Williams. Under no circumstances shall Sherwin-Williams be liable for indirect, special, incidental or consequential damages, lost profits or punitive damages arising from any cause whatsoever.

Internal Use-IU-COR-00047