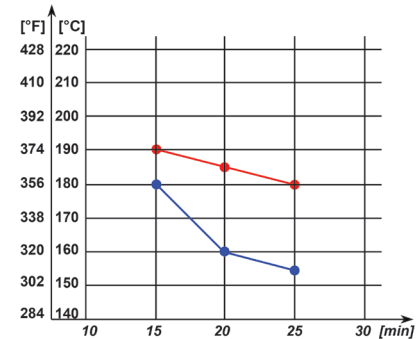


SERIES 250/00108 clear – wheel line (optical brightened)

typical application	automotive
chemistry	acrylic (GMA)
surface	smooth
gloss	>100 - according to ISO 2813 at 20° angle
recommended film thickness	2.5-3.5 mils (60-80 µm) - according to EN ISO 2360
recommended cure parameters	15 minutes at 374 °F (190 °C) substrate temperature
application type	electrostatic spray
specific gravity	1.15±0.03 g/ml
storage stability	3 months at no more than 59-68 °F (15-20 °C)

Cure parameters

(substrate temperature versus curing time)



Test results

The film properties were determined on aluminum test panels with chromate-free conversion.

test method	test	test result
ISO 2409	cross cut	value 0
EN ISO 20567-1 method B	determination of stone-chip resistance (multi-impact test)	value 1-2
EN ISO 11341 method 1	weathering in humid-warm climate 3,200 hours	ISO 2813 at 60° angle gloss retention >80%
5° from the horizontal south	exterior durability 36 months Florida exposure at 26° N	ISO 2813 at 60° angle gloss retention >75%

test method	test	test result
EN ISO 6270-2-CH	condensation atmosphere with constant humidity 240 hours	degree of blistering - EN 4628-2 degree of rusting - EN 4628-3 0 (S0) Ri 0
EN ISO 9227	copper-accelerated acid salt spray test (CASS) 240 hours	corrosion - EN 4628-8 delamination - EN 4628-8 degree of blistering - EN 4628-2 degree of rusting - EN 4628-3 c ≤5/64 inches (2 mm) d ≤5/64 inches (2 mm) 0 (S0) Ri 0
VDA 621-415	cyclic corrosion test 10 cycles	corrosion - EN 4628-8 delamination - EN 4628-8 degree of blistering - EN 4628-2 degree of rusting - EN 4628-3 c ≤5/64 inches (2 mm) d ≤5/64 inches (2 mm) 0 (S0) Ri 0

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