BULLCREM LACK
POWDER COATINGS
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ISO 9001 BUREAU VERITAS Certification

PRODUCT TECHNICAL DATA SHEET

Edition: 02/2026

CODE: **PMZ100450006** | DESIGNATION: **PES IND NERO CANNA DI FUCILE MZ DB.**

Product Description

Thermosetting powder coating based on saturated polyester, additives and selected pigments, specifically for indoor applications.

Fields of Use

Suitable for indoor metal objects and artifacts not subject to heavy wear, scratches, or oxidation. For greater protection over time, applying a protective coat of gloss clear coat (our code QLI100540001) is recommended.

Chemical-Physical Characteristics of the Powder

- **Surface Appearance:** Smooth / Gloss
- **Color:** Black
- **Gloss (60°):** n. a.
- **Theoretical Density:** 1.40 - 1.65 g/cm³
- **Average Particle Size (d50):** 35 - 45 µm (LASER spectrometry method)
- **Fluidity (SAMES):** > 140
- **Storage and Stability:** 24 months in original sealed packaging, stored in a dry environment at a temperature < 30°C and protected from heat sources/direct light.

Theoretical Consumption Calculation:

Consumption (g/m²) = Average Specific Gravity (g/cm³) × Required Thickness (µm)

Coating Performance (Test Conditions)

All application tests are performed under standardized laboratory conditions. Mechanical tests are conducted on AA 5005-H24 aluminium alloy panels (thickness 0.8 - 1.0 mm). Corrosion tests are conducted on AA 6060 alloy panels with a dry film thickness requirement (60 - 80 µm).

1. Mechanical and Adhesion Properties

Test / Property	Reference Standard	Requirement / Result
Adhesion (Cross-Cut)	EN ISO 2409 (2 mm pitch)	Gt0 (No detachment)
Erichsen Cupping Test	EN ISO 1520	PASS ≥ 5 mm
Impact Resistance	EN ISO 6272-2 / ASTM D2794	PASS 2,5 Nm (Indirect Impact, indenter Ø 15,9 mm)

2. Chemical, Corrosion and Weathering Resistance

Test / Property	Reference Standard	Specifications and Acceptance Limits
Moisture Resistance	EN ISO 6270-2	black surface stains
Alkali Resistance	Laboratory test in 5% alkaline solution	Poor resistance, avoid direct contact

Curing Specifications (Effective object temperature)

- **160°C:** 20 – 30 minutes

Technical Notes: In case of using gas-fired direct-flame ovens, please contact our technical support service in advance.

Application Guidelines

- **Surface Preparation:** The metallic substrate must undergo industrial degreasing and deoxidizing cycles. To maximize outdoor corrosion resistance, the application of a suitable chemical conversion treatment.
- **Spraying Techniques:** Suitable for application with automatic or manual electrostatic systems, using only Corona methods.
- **WARNING:** For the metallic product, spray-to-waste application is recommended, as the metallic effect is achieved through a dry-blending process of components with different specific gravities and colour appearances. Depending on the application system used and the possible use of reclaimed powder, finishes may show substantial differences in appearance and colour; spray-to-waste application is recommended.
- **Compatibility:** Do not mix the product with powder coatings of a different nature or different batches to avoid contamination, gloss loss, or cratering.
- **Safety:** Product for professional use only; consult the relevant Safety Data Sheet (SDS).

Legal Notes & Disclaimer

The information provided in this technical data sheet reflects the current state of our knowledge and results from rigorous laboratory testing. The data refer exclusively to the materials described and do not exempt the user from performing preventive checks on their own production line in relation to specific process variables. We reserve the right to modify technical data without prior notice within the framework of continuous product improvement.