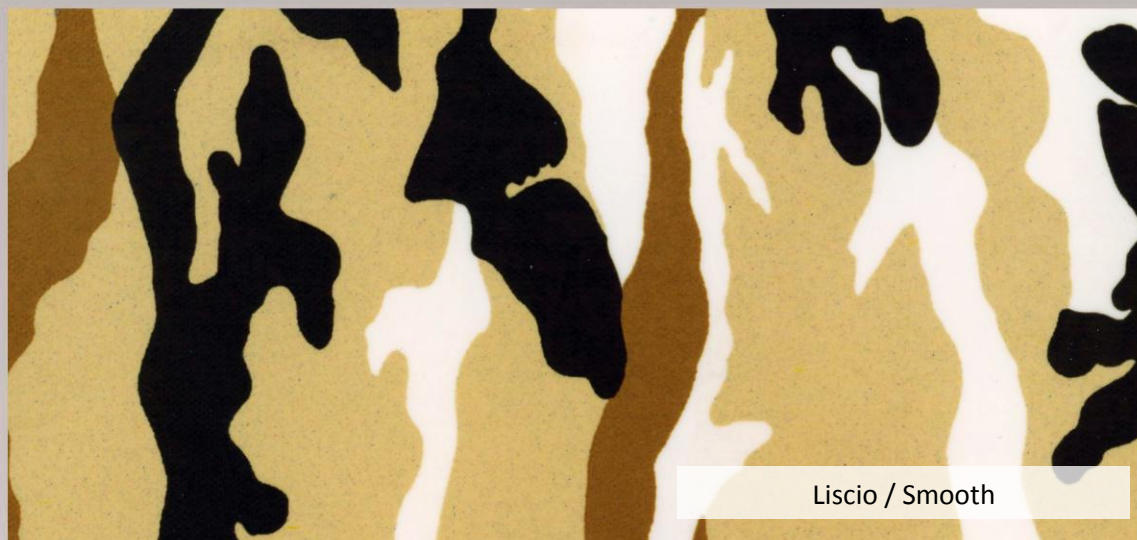


Polvere per verniciatura
Powder Coating
Pintura en polvo
Couleur en poudre



Double Layer Powder Coating Systems



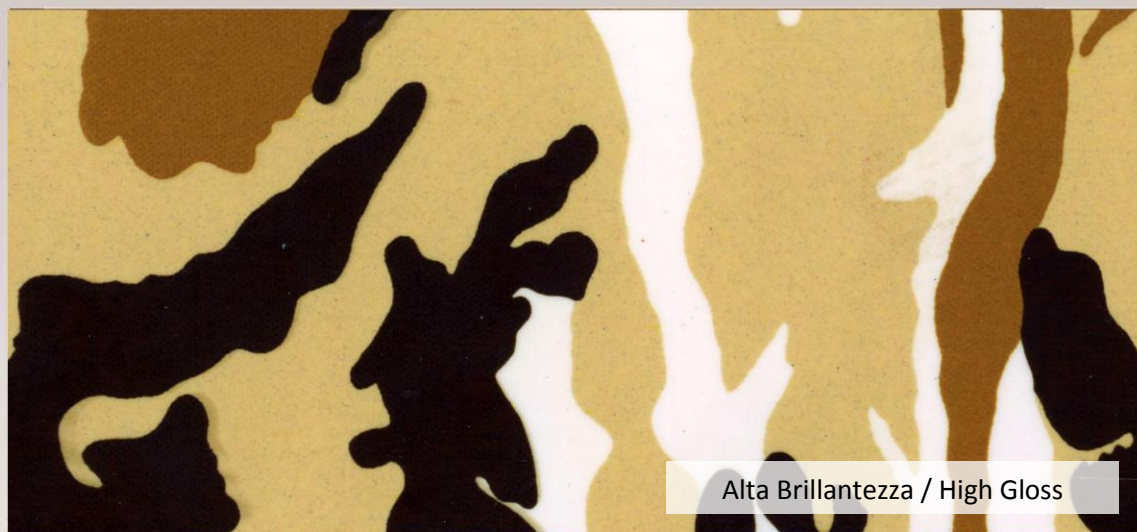
Liscio / Smooth

Powder Coating: PE411 + DS 407 Heat Transfer Film: 6010/56



Raggrinzato / Textured

Powder Coating: PE411 + DS 707 Heat Transfer Film: 6010/56



Alta Brillantezza / High Gloss

Powder Coating: PE411 + DS 810 Heat Transfer Film: 6010/56



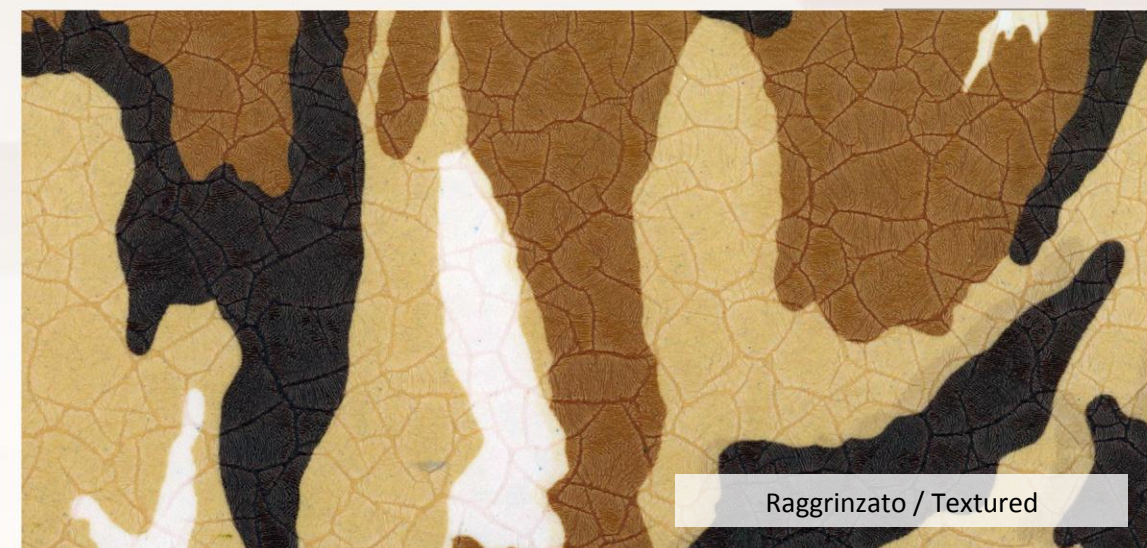
Fotoluminescente / Photoluminescent

Powder Coating: PE411 + DS LIGHT-001 Heat Transfer Film: 6010/56



Raggrinzato / Textured

Powder Coating: PE411 + ICETOUCH-023 Heat Transfer Film: 6010/56



Raggrinzato / Textured

Powder Coating: PE411 + SALT LAKE-025 Heat Transfer Film: 6010/56



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First layer of PE 411

Thickness of the first layer, **special powder base** (PE411), must be around 50 microns. It must be under-cured for 15 minutes at 170°C. In such way the first layer is not fully cross-linked; this helps the adhesion of the clear powders second layer.

Second layer of clear coat

Clear layer could be made by using **several different powder coating**, for example:

- **Glossy Polyurethane** (glossy surface 85±10 gloss)
- **Mat Polyurethane** (mat surface 19±5 gloss)
- **Textured polyurethane** (rough surface 8±3 gloss)
- **Ice Touch** (pearlescent surface)
- **Salt Lake** (random cracked surface)
- **Light Series** (photoluminescent)

Thickness of these second layers needs to be around 60 microns.
The two layers system must be cured for 20 minutes at 200°C (peak metal temperature).

Now, these systems are ready to be decorated with heat transfer technology by using standard films, custom made films or digital printed films.

Advantages:

- Big contrast (white background)
- No colour mixing
- High quality printing
- Structured surfaces

Variants and special formulations:

- Antigraffiti
- Antimicrobial
- Low curing Temperature



**Double Layer Powder
Coating Systems**

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