

Dedicated marketing material:

- MRK-005-0135



- MRK-005-0264



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Marchi di qualità registrati di Decoral System®



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**PE411 + XXX**

Double-layer coating  
for brighter colors of the decoration



*Information:*

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2. *Technical information*
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MRK-012-0023

# DOUBLE LAYER OF POWDER COATING

Combination of different powders on two layers

## 1. Product features

With a double layer of powder coatings properly chosen (lower coat: colored powder; upper coat: transparent) it is possible to enhance at the best the colors of the sublimated decor. The sublimatic inks, indeed, when penetrating the transparent layer of coat, maintain all the vividness of the colors that would otherwise become dull if heat-transferred into a colored layer of coat, where the pigments of the powder make them dim.

Depending on the product used as top-coat, it is possible to choose between several kinds of surface: matt, textured, glossy, as well as special surface effects like *Saltlake*, *Icetouch*, etc..



A picture of the moon, heat-transferred on single coat DS 434 (upper panel) and on double coat PE411 + DS 407 (lower)

## 2. Technical information

### - Technical data

Type of powder for the first coat	Polyester suitable for over-coating
Type of powder for the top coat	Depending on the desired surface
Class resistance	Depending on the product of the top-coat

### - Mechanical properties

Mechanical properties are generally reduced by the overall thicker coat. All the same, it is possible to bend double-coated surfaces under certain expedients, like pre-heating the material and define a higher radius of curvature.

The durability of the decor depends on the products chosen: so, also under this point of view it is possible to tune the characteristics of the surface that will be decorated.

## 3. Variants and special formulations

The possibility to combine many different products offers a wide range of solutions: indeed, after choosing the base color (generally white, but all colors are available), we can feature the surface with a special powder. Here are only some of the possible solutions:

- DS-0810SA (glossy superdurable antigraffiti)
- Light-001 (photoluminescent)
- Saltlake-025 (special surface)
- Icetouch-023 (special textured surface)

## 4. Product application

The application is carried out in two steps.

For the first coat, the base, white polyester *PE411* is to be used: thickness must be around 50  $\mu\text{m}$  and it is cross-linked for 15 minutes at 170°C; this way, the powder will not be fully cured, thus allowing the following layer of powder to adhere on it.

For the top coat it is possible to use a matt, textured or glossy polyurethane, as well as other products that allow very characteristic surface effects. The application of the second coat must be carried out on coils and objects that have just been coated with *PE411* and where the surface has been maintained carefully clean; thickness must be around 60  $\mu\text{m}$  and time for completing the polymerization of both powders is 20 minutes at 200°C (metal temperature).

## 5. Possible usage

The double-coating technique permit to fully valorize the colors and the shades of a decor. For this reason, it is specially recommended for heat-transfer films with a high black/white contrast and for pictures with flashy and vivid colors, and wherever the brightness and the fullness of the colors are most important.

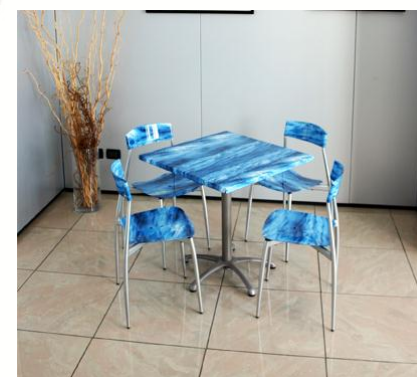


Table and chairs



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