

Product Data Sheet

PHOEPOX® 3314

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Maj 2021



Phoepox® 3314

Is a high performance fusion bonded epoxy powder that is designed as both a stand-alone FBE or as the first layer in a dual layer or multi-layer powder coating systems. Phoepox® 3314 can also be used as a primer in multi-layer polyolefin systems. Phoepox® 3314 is suitable for standard service temperatures.

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 200°C	20-30 sec	ISO 8130-6
	THERMAL PROPERTY	Tg1	60 ± 5°C	ISO 21809-2
		Tg2	101 ± 5°C	
		ΔH	40-80 J/g	
	DENSITY		1.5 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE		99.8% < 250 μm	Laser Scattering
	MOISTURE CONTENT		≤ 0.5 %	CSA Z245.20-14
COLOR		Grey		
PHYSICAL TESTS	CATHODIC DISBONDING *	1-3 mm at -3.5 VDC, 65°C, 24 hours 2-4 mm at -1.5 VDC, 20°C, 28 days 3-5 mm at -1.5 VDC, 65°C, 28 days		CSA Z245.20-14
	ADHESION *	Rating 1 at 75°C, 24 hours		CSA Z245.20-14
	FLEXIBILITY *	Pass, at 3°, -30°C		CSA Z245.20-14
	WATER RESISTANCE	No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870



◀ corrosion protection that stays.

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STORAGE STABILITY

12 months from production date in
 $\leq 23^{\circ}\text{C}$ and $\leq 65\%$ relative humidity.
Cooler temperatures and lower
humidity are recommended.

* The performance will be affected by surface preparation and curing condition.

APPLICATION DATA

SUBSTRATE FBE coated steel

**RECOMMENDED
FILM THICKNESS** 150-600 μm

**APPLICATION
TEMPERATURE** 215-240 $^{\circ}\text{C}$



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