

# Product Data Sheet

## PHOEPOX® 3314

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April 2022



### 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	
<b>POWDER PROPERTIES</b>	<b>GEL TIME</b>	at 205°C	18-35 sec	ISO 8130-6
	<b>THERMAL PROPERTY (Powder)</b>	Tg1	60 ± 5°C	ISO 11357-1
		Tg2 ΔH	103 ± 4°C 40-80 J/g	
	<b>(Film)</b>	ΔTg	≤ 5 °C	
		Percentage conversion	> 99%	
	<b>DENSITY</b>		1.45±0.05 g/cm <sup>3</sup>	ISO 8130-2
	<b>PARTICLE SIZE</b>		97% < 150 μm 99.8% < 250 μm	ISO 8130-1
<b>MOISTURE CONTENT</b>		≤ 0.5 %	ISO 15512	
<b>COLOR</b>		Grey		
<b>PHYSICAL TESTS</b>	<b>CATHODIC DISBONDING *</b>	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	
	<b>ADHESION *</b>	Rating 1 at 75°C, 24 hours	CSA Z245.20-14	
	<b>FLEXIBILITY *</b>	Pass, at 3°, -30°C	CSA Z245.20-14	
	<b>WATER RESISTANCE</b>	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 PREPARATION

Surface must be free from contamination

### SUBSTRATE ROUGHNESS

50-100  $\mu\text{m}$

### RECOMMENDED FILM THICKNESS

200-400  $\mu\text{m}$

### APPLICATION TEMPERATURE

215-240 $^{\circ}\text{C}$

### TEMPERATURE TIME TO QUENCH

$\geq 90$  sec at 225 $^{\circ}\text{C}$  metal temperature



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