

Protection from Heat & Humidity

SolEpoxy coating powders are affected by heat and moisture. That is why we package the material in plastic bags or pails and recommend refrigeration during shipping and handling.



Heat (room temperature or warmer) will cause the coating powder to slowly begin to react, increasing the material's viscosity, which may lead to coating defects.

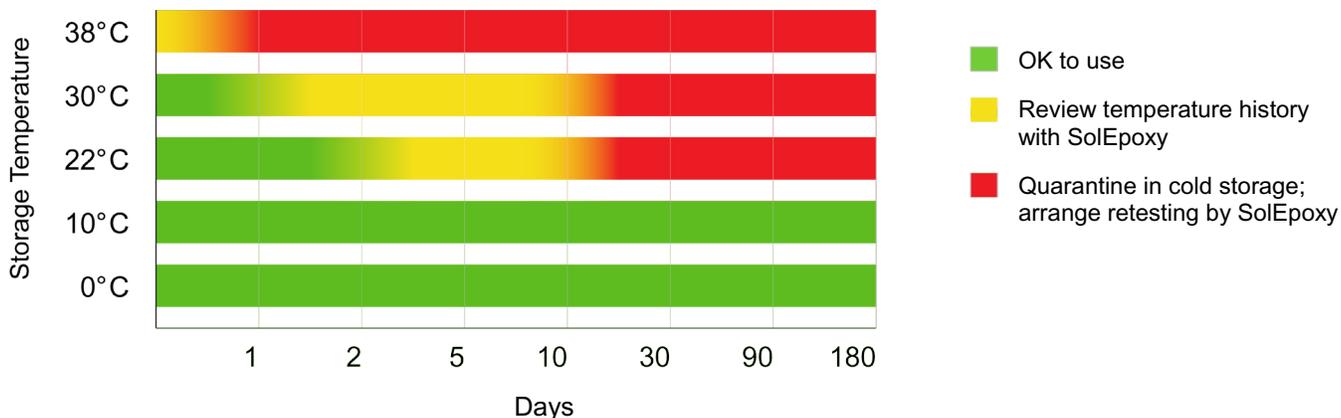


Condensation or high humidity (> 50%) will cause the plastic to cure slower, reducing the material's viscosity, which may lead to defects or reduce the physical properties and potential cracking of parts.

When you receive your product, it should be **placed into cold storage** as soon as possible. SolEpoxy recommends that materials be stored cold, < 10°C (< 50°F).

- ▶ Plan ahead. Take the material out of refrigeration early so it comes to room temperature **before you open the bag or pail**. If you open the packaging while the material is colder than room temperature, moisture will condense on the product surface and this may cause molding issues.
- ▶ The **time for temperature equilibration depends on the mass of material** being prepared for use. For example, 5 kg will take about 4 hours to warm-up, whereas a 15 kg will require about 12 hours to equilibrate.
- ▶ When coating is done, **re-seal the bag or pail**, and then return the material to cold storage.

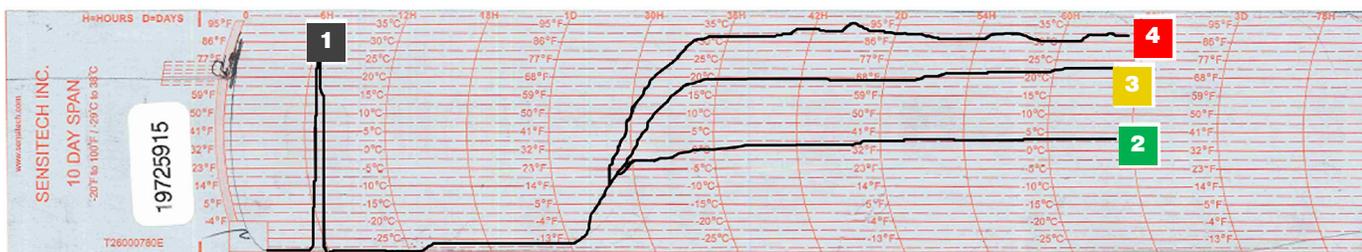
Maximize Shelf Life by Utilizing Cold Storage



1. SolEpoxy recommends storing coating powders at or below 10°C (50°F) to maximize shelf life up to 6 months.
2. During shipment, the temperature chart recorder may experience brief high-temperature excursions when packaging is opened by inspectors at transit points. Additionally, deep-frozen material will slowly warm to ambient conditions during air shipment. Short-period exposure to heat is normal and it will not damage the product. **Long-term exposure to heat will degrade shelf-life, reducing viscosity, which could necessitate changing your molding parameters.**

Instructions for interpreting shipping temperature recorders

Use the chart recorder data and the following instructions as a guide. If material is exposed to heat above “room temperature,” you may need to have SolEpoxy retest the flow characteristics prior to use.



- 1** Ignore a narrow, short-duration peak like this; it will not affect product performance.
- 2** If your chart looks like this, your material should be fine to use.
- 3** If your chart looks like this, your material needs to be evaluated before use.
- 4** If your chart looks like this, your material may not work as intended.

Has the temperature recorder been with the material for the entire time? If no, contact SolEpoxy. If **yes**, follow these directions:

- ▶ Remove the paper strip chart from the recorder and unroll it;
- ▶ If the temperature pen line drawn on the chart is **not over the 10°C / 50°F mark**, the product is fine to use.
- ▶ If the drawn pen line is **over the 20°C / 68°F mark**:
 - ▶ Count the total number of vertical (up and down) division lines the pen line crosses—each one represents a day.
 - ▶ If the number of lines crossed is **more than 2**, the material and temperature history need to be reviewed before use. *Contact SolEpoxy before using.*
 - ▶ If the number of lines crossed is **more than 4**, the material and temperature history need to be reviewed before use. The material may be damaged. *Contact SolEpoxy. We may need to re-test a sample before your use.*
- ▶ If the drawn pen line is **over the 30°C / 86°F mark**:
 - ▶ Count the total number of vertical (up and down) division lines the pen line crosses—each one represents a day.
 - ▶ If the number of lines crossed is **more than 1**, the material and temperature history need to be reviewed before use. *Contact SolEpoxy before using.*
 - ▶ If the number of lines crossed is **more than 2**, the material and temperature history need to be reviewed before use. The material may be damaged. *Contact SolEpoxy. We may need to re-test a sample before your use.*

* These instructions apply to reactivity groups:

DK15-02B DK15-0606 DK15EG-05
DK18-05 BLUE DK52 GRAY