Technical Bulletin

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Polychem
A DIVISION OF IFS COATINGS, INC.

F/T WINDING RIVER
PLFL21072PB

Description: Thermosetting polyester TGIC powder coating designed for interior and exterior use

Typical Applications: Decorative finishes.

Typical Physical Properties:

Film Thickness	2.0-3.0+ mil
Gloss 60'angle (ASTM D-523-89)	VISUAL
Hardness (ASTM D-3363-92A)	H – 2H
Flexibility (ASTM D-1737-89)	1/8 inch
Adhesion (ASTM D-3359-95A)	5B (100%)
Impact Direct/Indirect (ASTM D-2794-93)	160 in-lbs
Salt Spray (ASTM B117)	1000 Hrs < 1/8’
Specific Gravity (calculated)	1.69+/-0.05

Application Data: Polyester TGIC’s are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.

This product is post blended and reclaiming is not recommended.

Cure Schedule: Polyester TGIC’s can be cured in a direct or indirect gas convection oven, an electric oven, or an Infrared. A combination of any of these ovens is also suitable.

Standard Cure: 10 Minutes @ 340^{o}f Peak Metal Temperature

Storage: Product should be stored at temperatures below 80^{0}f, in a dry area away from any heat source.

Notes: All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.

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