Technical Bulletin

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Polychem
A DIVISION OF IFS COATINGS, INC.

Ral 1036 Pearl Gold
PLSF 93377PB

Description: Thermosetting polyester TGIC powder coating designed for interior or exterior applications.

Typical Applications: General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.

Typical Physical Properties:

Film Thickness	2.0-3.0+ mil
Gloss 60'angle (ASTM D-523-89)	75±5 (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)	120/120 in-lbs
Salt Spray (ASTM B117)	1000 Hrs < 1/8’
Specific Gravity (calculated)	1.55+/-.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.

Any recommendations contained herein or any information given by any IFS COATINGS representative is based on tests and information believed to be accurate. However, since we have no control over the conditions under which our products are transported, stored, handled, or used by purchasers, all recommendations and sales are made on condition that IFS COATINGS will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.

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