# Technical Bulletin

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Polychem
A DIVISION OF IFS COATINGS, INC.

## Fed Std. 33446 Beige
## PRSL 41341PT

**Description:** Thermosetting polyester TGIC powder coating designed for interior and 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) | Visual - 46 |
| 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) | 1.45+/-.05 |

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

**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 @ 400$^{o}$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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3601 North Interstate 35
Gainesville
Texas 76240

Tel: (940) 668 1062
Fax: (940) 668 1061
Email: info@ifscos.com

www.polychemcoatings.com