

Technical Bulletin

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PRMF 94191PB AUTO ANTHRACITE

Description:	thermosetting modified 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 Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.40±0.05
	Theoretical Coverage	137 sq.ft./lb./mil
	Shelf life (at below 80°F in dry condition)	12 months
Typical Physical Properties:	Film Thickness	2.5-3.5 mil
	Gloss 60°angle (ASTM D-523-89)	Visual
	Hardness (ASTM D-3363-92A)	H – 2H
	Flexibility (ASTM D-1737-89)	1/4 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	up to 80/80 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
Application Data:	is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.	
Cure Schedule:	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.	
	<u>Standard Cure:</u> 10 Minutes @ 400°F Peak Metal Temperature	
Storage:	should be stored at temperatures below 80°F, in a dry area away from any heat source.	
Notes:	All tests were performed on Bonderite 1000 (Iron phosphate) panels with a nominal film thickness of 2 mils. Please refer to the SDS for safety information.	

(updated on 10-19-2022)

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