

Technical Bulletin

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Auto Bike Green PLSF31967PB

Description: Thermosetting Polyester TGIC powder coating. The product is designed for interior and exterior durability, and will meet or exceed AAMA 2603.

Typical Physical Properties:	Film Thickness	2.0-3.0 mil
	Gloss 60°angle (ASTM D-523-89)	85-95
	Hardness (ASTM D-3363-92A)	2H-3H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	160/160 in-lbs
	Salt Spray (ASTM B117, Alodine Panels)	1000 hrs, < 3 mm creep
	Specific Gravity (calculated)	1.50±0.05

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 @ 350°F Peak Metal Temperature

Storage: Product 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 phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.

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