



Technical Bulletin

Your business. Your coating. Your choice.

PLSF 94190PB Auto Clear

Description: **PLSF 94190PB, Auto Clear** is 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)	1.26±0.05
	Theoretical Coverage	152 sq.ft./lb./mil
	Shelf life (at below 80°F in dry condition)	12 months

Typical Physical Properties:	Film Thickness	2.0-3.0 mil
	Gloss 60°angle (ASTM D-523-89)	100+
	Hardness (ASTM D-3363-92A)	2H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	up to 100/100 in-lbs.

Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel) Rating 7 (creepage)

Application Data: **PLSF 94190PB, Auto Clear** is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.

Cure Schedule: **PLSF 94190PB, Auto Clear** 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°F Peak Metal Temperature

Storage: **PLSF 94190PB, Auto Clear** 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.

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.