



# Technical Bulletin

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## H5 Caribou PLMF 95854PB

<b>Description:</b>	Thermosetting Polyester TGIC powder coating. The product is designed for interior and exterior durability.	
<b>Typical Physical Properties:</b>	Film Thickness	2.0-3.0+ mil
	Gloss 60°angle (ASTM D-523-89)	70-75 (visual)
	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 or B-1000 Panels)	1000 hrs, < 3 mm creep
	Specific Gravity (calculated)	1.48±0.05
<b>Application Data:</b>	Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.	
<b>Cure Schedule:</b>	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.  <u>Standard Cure:</u> 10 Minutes @ 340°F Peak Metal Temperature	
<b>Storage:</b>	Product should be stored at temperatures below 80°F, in a dry area away from any heat source.	
<b>Notes:</b>	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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