



As with all powder coatings, this product may vary between lot numbers, KV settings, mil thickness, oven temperatures, application equipment and technique. We recommend a clear top coat to maintain the appearance and prevent oxidation on metallic powder coatings. We do not recommend clear coating textures, casts and wrinkles. Always coat a sample prior to any production, to determine if this product meets all your requirements.

**PRODUCT LINE/NAME:** Illusion Series

**ITEM NUMBER:**

**DESCRIPTION:**

The Prismatic Powders Illusion Series is a two coat system requiring the use of a Prismatic Powders Illusion base coat along with a Prismatic Powders clear top coat.

**SPECIAL INSTRUCTIONS:**

For optimal results the base coat should be applied at a thickness of 2.0-3.0 mils. Optimal flash time, 2 mins. after gel out. Top coat should be applied after the part has cooled. *Please note, color will not be correct until the top coat has been applied.* The base coat must cure with the top coat to achieve the proper color. Less than 100% top coat coverage will yield inconsistent results in color. Illusion base coat is not tribo compatible.

**FLASH TIME PRIOR TO TOP COAT**

**2 min. after powder flows to a gloss @ 400°F**

**CURE TIME & TEMP:** If no top coat is desired.

**10 min. @ 400°F**

As always, the cure time starts when the substrate reaches temperature.

**Note:** Each additional coat of powder coating will act as an insulator, which will require additional time for the substrate to reach temperature. Extend cure times as needed.

**POWDER CHARACTERISTICS:**

Powder type -	TGIC polyester
Specific gravity -	1.7±0.05
Suggested KV setting -	45-60
Theoretical Coverage -	25-30 ft <sup>2</sup> /lb at 1 mil thickness.

**CURED COATING CHARACTERISTICS:** (Tested at 3 mils coating thickness)

GLOSS at 60° (ASTM D523)	85%
IMPACT DIRECT/INDIRECT (ASTM D2794)	160/160 in-lbs
PENCIL HARDNESS (ASTM D3363)	2H+
UV STABILITY (With Top Coat)	Excellent
SALT SPRAY (With Top Coat)	Excellent

**RECOMMENDED STORAGE / SHELF LIFE:**

Temperature: (Store in cool dry environment)	70° F
Time:	6-8 months

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The information contained in this bulletin we believe to be correct to the best of our knowledge and testing. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets all your requirements.