



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. Always coat a sample prior to any production, to determine if this product meets all your requirements.

PRODUCT LINE/NAME: Illusion Shocker

ITEM NUMBER: PMS 10050

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. Illusion base coat should be allowed to bake for approximately 2 minutes past the point when the powder flows all the way 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 and cured.** 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.

CURE TIME & TEMP: Illusion base coats should be partially cured at 400°F (see above for special instructions). After the base coat is partially cured, follow the cure schedule for the top coat that is used. The top coat and base coat will cure together when the top coat is cured. 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. Check part metal temp and extend cure times as needed.

POWDER CHARACTERISTICS:

Powder type -	Polyester
Specific gravity -	1.2-1.5
Suggested KV setting -	45 (less if coating over base coat)
Theoretical Coverage -	25-30 ft ² /lb at 1 mil thickness.

CURED COATING CHARACTERISTICS: (Tested at 2 - 3.5 mils coating thickness per coat)

GLOSS at 60° (ASTM D523 modified)	95% (after Clear Vision is applied)
IMPACT DIRECT/INDIRECT (ASTM D2794)	100/80 in-lbs (direct/indirect)
PENCIL HARDNESS (ASTM D3363)	H-2H
UV/WEATHER RESISTANCE	LIMITED
ADHESION	5B

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.