



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: Epoxy Wrinkle

ITEM NUMBER: EWS, EWB, E-9000 Series

DESCRIPTION: Wrinkled texture finish

SPECIAL INSTRUCTIONS: For a more uniform appearance, parts should enter the oven at 150° F – then ramp up to 350° F then time to full cure. Wrinkle powders may blister around welded areas on projects with sealed tubes, i.e. fencing, railing, gates, etc. The inherent properties that form a wrinkle finish, cross- link slow during the cure cycle, which can allow gas to be trapped. Drilling vent holes will help minimize this effect. If venting is not feasible, powder other than a wrinkle should be considered.

CURE TIME & TEMP:

15 min. @ 350°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 -	Epoxy
Specific gravity -	1.6
Suggested KV setting -	45
Theoretical Coverage -	25-30 ft ² /lb at 1 mil thickness.

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

GLOSS at 60° (ASTM D523)	10%
IMPACT DIRECT/INDIRECT (ASTM D2794)	60/60 in-lbs
PENCIL HARDNESS (ASTM D3363)	H
UV STABILITY	Poor
SALT SPRAY	

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.