PRISMATIC POWDERS

APPLICATION GUIDE
WITH TECHNICAL DATA INFORMATION

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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 Number and Name: PSS 10399 Cotton Candy Blue

Suggested Cure Time and Temperature: 10 Minutes at 400°F

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

Special Instructions / Notes:

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 Properties :

Thermosetting Powder Coating
Powder type: TGIC Polyester
Specific Gravity: 1.60 +/- 0.05
Storage: Store in cool dry environment 70° F
Shelf Life: 6-8 Months

Application :

Electrostatic spray to cold substrate
Recommended Mil Thickness: 2.0-3.5 Mils

Equipment information :

Fluidized Hopper Recommended
Not Recommended for tribo application

Pretreatment and proper prep to substrate prior to power coating is a critical factor in developing maximum corrosion resistance and maximizing the lifetime of the product.

Testing parameters are as follows :

- **UV and Weather Resistance** The test panel undergoes several cycles of UV exposure, followed by condensation exposure. All cycles are repeated continually until analysis is stopped.
- **Gloss Units and levels** are measured at a 60° angle
- **Adhesion** is measured on a scale of 0B, 1B, 2B, 3B, 4B, 5B, with 5B being the highest achievable rating.
- **Flexibility or Conical Mandrel Bend**: "100% Resistance" is the highest achievable rating and indicates that the coating did not crack or spall.
- **Impact Performance Direct/ Indirect** is measured on a scale of 0 inch-lbs. to 160 inch-lbs., with 160 inch-lbs. being the highest achievable rating.
- **Salt Spray** Corrosion testing is used to evaluate the relative corrosion resistance of coated panels exposed to a salt spray or fog at an elevated temperature. Coated panels are placed in an enclosed salt spray chamber at a15-30 degree angle and subjected to a continuous indirect spray of a neutral (pH 6.57.2) salt water solution. The chamber/cabinet is kept at an operating temperature of 95°F and fogging a 5% salt solution at the required 1.0-2.0mL/hr.

Testing Results

Type of Substrate: Mild steel Q panel/ Aluminum Q panel

Cure Method: 10 Minutes at 400°F

Average Mil Thickness of panels: 2.0-3.5 Mils

KV settings- 50 or less

Gloss Unit	**71-85 GU**
Gloss Level	**Gloss**
Adhesion	**4B Average Adhesion**
Flexibility or Conical Mandrel Bend	**100% Resistance**
Impact Performance Direct	**120 Inch-pounds**
Impact Performance Indirect	**120 Inch-pounds**
Pencil Hardness	**2H-H**

PLEASE NOTE

Not all powders are recommended for exterior use, it is the buyer's responsibility to ensure they are purchasing a product that is best suited for the intended application. Certain pigment types, such as those found in the Illusion Series and Transparent powders do not have the same level of UV resistance as those found in Solid Tone finish types.

Exterior tops coats applied to interior finishes may prolong the fading process but DOES NOT ensure a long lasting exterior finish. Please conduct your own testing to ensure the products you choose meet your requirements.

Applicable for product manufactured after 12/29/2020

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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.