



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 LINE/NAME: POLYESTER METALLIC

ITEM NUMBER: PMS, PMB

DESCRIPTION: Smooth solid single tone heavy or light metallic color (Thermosetting Powder Coating).

SPECIAL INSTRUCTIONS: NONE

CURE TIME & TEMP:

12 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 -	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)

GLOSS at 60° (ASTM D523)	10%-90% (depending on specific color)
IMPACT DIRECT/INDIRECT (ASTM D2794)	80/80-140/140 in-lbs
PENCIL HARDNESS (ASTM D3363)	H-2H
UV STABILITY	Excellent
SALT SPRAY	Excellent (with top coat)

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.