Product Number and Name: PWB 10629 Desert Lights

Suggested Cure Time and Temperature: 15 Minutes at 375°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-Free Polyester
Specific Gravity: 1.32+/-0.5
Storage: Store in cool dry environment 70° F
Shelf Life: 6-8 Months

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.
Electrostatic spray to cold substrate
Recommended Mil Thickness: 3.0-3.5 Mils

Equipment information:
Fluidized Hopper Recommended
Not Recommended for tribo application
Suggested Nozzle: No specific tip required

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.

Testing Results

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

Cure Method: 15 Minutes at 375°F

Nozzle type used for testing: Conical

Average Mil Thickness of panels: 3.0-3.5 Mils

KV settings- 50

- **UV and Weather Resistance**　　　　**Excellent UV Resistance**
- **Gloss Unit**　　　　**0-6 GU**
- **Gloss Level**　　　　**Flat**
- **Adhesion**　　　　**4B Average Adhesion**
- **Flexibility or Conical Mandrel Bend**　　　　**95% Resistance**
- **Impact Performance Direct**　　　　**120 Inch-pounds**
- **Impact Performance Indirect**　　　　**60 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: 8/2/2021
Revisions: