



APPLICATION GUIDE

WITH TECHNICAL DATA INFORMATION

PRISMATIC POWDERS | 7050 SIXTH STREET | WHITE CITY, OR 97503 | 866-774-7628 | PRISMATICPOWDERS.COM

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: URETHANE SOLID TONE

ITEM NUMBER: USS, USB

DESCRIPTION: Smooth solid single tone color (Thermosetting Powder Coating).

SPECIAL INSTRUCTIONS: NONE

CURE TIME & TEMP:

10 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 -	Urethane
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)	60%-90%
IMPACT DIRECT/INDIRECT (ASTM D2794)	140/140 in-lbs
PENCIL HARDNESS (ASTM D3363)	2H-3H
UV RESISTANCE	Good to Excellent (color specific)
SALT SPRAY	Excellent

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.