



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.

Due to the specific formulation of this powder, an occasional black speck may be visible in the cured finish. Shadowed banding may also occur against raised surfaces or sharp edges. It is recommended that a clear top coat be applied for exterior use. A clear top coat can cause the finish to darken, to prevent darkening apply top coat to a half or fully cured finish†

PRODUCT LINE/NAME: Ultra Black Chrome

ITEM NUMBER: USS-5204

DESCRIPTION: Single tone (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 -	Polyurethane
Specific gravity -	1.5
Suggested KV setting -	45 or less
Theoretical Coverage -	25-30 ft ² /lb at 1 mil thickness.

CURED COATING CHARACTERISTICS: (Tested at 1.8 to 3.5 mils coating thickness)

GLOSS at 60° (ASTM D523)	60%-100%
IMPACT DIRECT/INDIRECT (ASTM D2794)	160/160 in-lbs
PENCIL HARDNESS (ASTM D3363)	H-2H
UV STABILITY	Excellent
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.

†Top coats applied to a fully cured finish may be at greater risk of delaminating†