



## TECHNICAL DATA INFORMATION

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 topcoat to maintain the appearance and prevent oxidation on metallic powder coatings.

Always coat a sample before any production to determine if this product meets all your requirements.

### Item Code / Color Name:

PMB-10050 Illusion Shocker

### Suggested Cure Time and Temperature:

The cure time starts when the substrate reaches temperature. Always check temperature of thickest part of the substrate.

Flash at 400°F (204°C)

### Special Instructions / Notes:

Each additional coat of powder coating will act as an insulator, which will require extra time for the substrate to reach temperature. Extend cure times as needed.

To achieve the proper color, a clear topcoat must be applied. This color has limited UV and weather stability and should primarily be considered for novelty applications. Inconsistent mil thickness of the base coat or topcoat can lead to uneven color results. For optimal results, the base coat and topcoat should be applied at a mil thickness range of 2.5-3.5 each; flash the Illusion basecoat for 3 minutes after the powder flows to a gloss state with oven temperatures at 400°F. An applicator must visually confirm that this state has been reached, as times will vary. Wait until the part has thoroughly cooled before applying the topcoat. After the topcoat has been applied, fully cure according to the topcoat's recommended cure schedule.

### Powder Properties:

Thermosetting Powder Coating  
Powder Type: Epoxy-Polyester Hybrid (Contains TGIC)  
Gloss: High Gloss: 85+ Gloss Units +/-5  
Recommended Use: Interior Use Recommended \*\* Limited UV stability\*\*  
Adhesion/Crosshatch: 5B  
Mandrel Bend: 95% Resistance  
Indirect Impact: 100 Inch-pounds  
Direct Impact: 100 Inch-pounds  
Pencil Hardness: H  
Specific Gravity: 1.56+/-0.05  
Finish Type: Metallic  
Storage: Store in a cool, dry environment 70° F (21° C)  
Shelf Life: 6-8 Months

## Application:

Pre-treatment and proper prep to substrate before powder coating are critical factors in developing maximum corrosion resistance and maximizing the product's lifetime. Electrostatic spray to a cold substrate. Please see application guide for additional information.

**Recommended Mil Thickness: 2.0-3.0 Mils**

## Equipment Information:

Gun System: Nordson Encore LT  
Fluidized Hopper Recommended  
Not Recommended for Tribo Application  
Suggested Nozzle: Conical Tip with Diffuser  
Alternative tips can be used but may cause color variation.

## Testing parameters are as follows:

- **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-pounds to 160 inch-pounds, with 160 inch-pounds being the highest achievable rating.
- **Type of Substrate:** Mild Steel Q panel/ Aluminum Q panel (Blasted/ Unblasted)

Not all powder coating is recommended for exterior use; it is the buyer's responsibility to ensure they purchase a product 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 topcoats applied to interior finishes may improve UV resistance and durability of the product but DOES NOT ensure a long-lasting exterior finish. Please conduct your own testing to ensure the products you choose meet your requirements.

NIC Industries, Inc. does not warranty the use or application of its manufactured materials or supplies. Our only obligation shall be to replace any defective materials supplied by us after determining them to be faulty. NIC Industries, Inc. assumes no liability for damages of any kind, and the user accepts the product "as is" and without any warranties, expressed or implied. The suitability of the product or intended use shall be the user's sole responsibility.

We believe the information in this bulletin is correct to the best of our knowledge and testing. The recommendations and suggestions herein are made without guarantee or representation of results. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets all your requirements.