

TECHNICAL DATA SHEET

POLYURETHANE POWDER COATING

Provides excellent leveling, smoothness and gloss. Superior hardness can be achieved (usually one "pencil" more than TGIC) and is designed for relatively low film build. Certain chemical resistances can be developed to a high level. This product is sensitive to cure parameters; they must be closely followed for optimum results.

Typical Applications: Typical uses for polyurethane products include automotive trim parts, garden fixtures and equipment, sporting goods, exterior furniture, and farm implements.

Typical Physical Properties:

Specific Gravity:	1.2 to 1.8 (Depending on colour)
Adhesion:	GT=0/100
Gloss:	40-90%@60°
Pencil Hardness:	H-4H
Impact:	40 kg.cms to 120 kg.cms.
Flexibility / Bending:	5 mm -no fracturing
Particle Size:	Suitable for electrostatic spray
Salt Spray:	500 hours

Application Data: Polyurethane can be applied with a corona electrostatic powder spray gun—40 to 100 KV. Over spray powder can be reclaimed using suitable equipment and recycled through the coating system.

Stoving Schedule: Polyurethane can be cured in a direct or indirect gas convection oven or an electric oven. A combination of any of this oven is also suitable.

Standard Stoving: 10 Minutes@200°C (EMT)

Storage: Product should be stored at room temperature below 25°C, in a dry area away from any heat source. Open boxes must be resealed

Notes: All tests were performed on Bonderite 1000, iron phosphate panels with a nominal film thickness of 2 mils.