

DESCRIPTION

This medium heat resistant coating is designed to provide continuous service between 350°F and 400°F (177°C to 204°C) and intermittent service up to 450°F (232°C).

This product was formulated to be a full gloss smooth red finish and it is suitable for steel and aluminum substrates.

Product Benefits

- Excellent flow, flexibility and electrostatic application properties.
- Good color and gloss retention at service temperature.
- Good UV resistance for outdoor use.

SPECIFICATIONS

Cure Cycle [substrate temperature]	10 minutes @ 400°F 15 minutes @ 375°F
Specific Gravity	1.35 +/- 0.05
Theoretical coverage for 1 mil	143 ft. ² / lb.
Film builds between	2.0 and 3.0 mils
Recommended at	2.50 mils
Coverage at recommended film	57 ft. ² / lb.

Heavier film builds are not recommended.

TYPICAL PROPERTIES

Adhesion (ASTM D3359)	5B
Salt Spray* (ASTM B117/D1654)	1000+ hours
Humidity* (ASTM D2247)	1000 + hours
Gloss @ 60° (ASTM D523)	80+
Impact Resistance (ASTM D2794-90)	60 D & R
Pencil Hardness(ASTM D3363)	>2H

*Bonderite 1000 panels

PERFORMANCE TESTING

Continuous testing at 400°F (204°C) indicates these products hold gloss, color and physical integrity at this service temperature. Intermittent testing at 428°F (220°C) indicates good performance with some color change at extended times and higher temperatures.

SURFACE PREPARATION

Powder coatings require cleaner substrates to maintain a good bond between metal and coating. Abrasive media blast is an excellent method of surface preparation. Chemical pretreatments are effective, but must be rinsed to a clean surface with no dirt or cleaner residue. *Phosphate pretreatments have their own temperature limits that must be observed.* Contact your chemical pretreatment supplier. Also substrates have limits that must be observed.

APPLICATION

Room temperature 77°F (25°C) electrostatic application is recommended. Reduced voltages (45 – 60kV) can improve coating film thickness uniformity.

STORAGE

This product should be stored at temperatures below 77°F (25°C) for up to 6 months. Under carefully controlled conditions, shelf life may be extended.

PRECAUTIONS

Read and understand the MSDS before using. This product is more temperature sensitive than normal powders and should be used at temperatures below 77°F (25°C). This product is more susceptible to moisture than other powder products. Because of the electrostatic properties of this powder a fluidizing feed hopper with higher air flow must be used.

LIMITATIONS

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstances are we liable for incidental and consequential damages.