

PRODUCT DATA SHEET
MEDIUM HEAT RESISTANT
POWDER COATING
GLOSS SMOOTH BLACK
1PC-673-2701

DESCRIPTION

This formula is based on a high-temperature system developed from a proprietary blend of resins and pigments to provide service up to 572°F (300°C). This is designed to be a gloss black smooth coating for steel and aluminum substrates.

Product Benefits

- Enhanced charging and handling characteristics
- Excellent surface hardness and chemical resistance
- Good long-term performance at 550°F (288°C) while maintaining color, gloss and film integrity.
- Excellent UV resistance for outdoor use on aluminum or aluminized substrates
- This coating is resistant to animal fats

SPECIFICATIONS

Cure cycle [Substrate temperature]	15 minutes at 400°F (204°C)
Specific Gravity	1.37 +/- 0.05
Theoretical coverage for 1 mil	141 ft² per pound
Film builds between	1.80mils - 3.20 mils
Recommended at	2.50 mils
Coverage at target mils	~ 55 ft² per pound

Heavier film builds are not recommended.

TYPICAL PROPERTIES

Adhesion (ASTM D3359)	5B
Gloss at 60° (ASTM D523)	85+
Impact Resistance (ASTM D2794-90)	80D/20R
Pencil Hardness (ASTM D3363)	>3H
Salt spray* (ASTM B117/D1654)	1000 hours
Humidity* (ASTM D2247)	1000 hours
UV Resistance (ASTM D4587)	>1000 hrs. UV-B

**Bonderite 1000 and aluminum panels*

PERFORMANCE TESTING

Continuous testing at 550°F (288°C) of this product shows little or no change in gloss, color and physical integrity at this service temperature. Testing at various temperatures indicates this product can withstand short or intermittent service at up to 600°F (315°C) while maintaining coating integrity. Testing meets specific performance requirements for several barbeque manufactures.

SURFACE PREPARATION

High temperature 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

Electrostatic application to room temperature substrate is recommended. Reduced voltages can improve coating film thickness uniformity. This product may be applied to warm substrate for increased film thickness.

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. Adequate health and safety precautions should be observed during storage, handling, use and curing periods. **We recommend testing for compatibility with other products that you use before purchasing.*

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.

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 product for 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 circumstance are we liable for incidental and consequential damages.