



PRODUCT DATA SHEET

1PC-107-9145

TRANSPORTATION GRAY 6334

POLYESTER POWDER COATING

GENERAL INFORMATION

The formula 1PC-107-9145 is an exterior grade TGIC-FREE Polyester Powder Coating product that matches DuPont #6334 Charcoal Gray in a full gloss, smooth, finish.

The product has passed 3rd party testing for use in transportation applications for passenger compartments.

Benefits

- Provides excellent film quality, leveling and flow
- Excellent electro-static properties
- Great U.V. and weather resistance
- Great chemical resistance and flow

SPECIFICATIONS

Cure schedule (substrate temp)	8 mins at 400 °F (204 °C) 12 mins at 375 °F (190 °C)
Specific Gravity	1.49+/-0.05
Theoretical Coverage for 1 mils	129 ft ²
Film Build Between	1.8 – 3.0 mils
Recommended Film Build	2 mils

TYPICAL PROPERTIES

Gloss at 60° (ASTM D523)	> 80
Adhesion (ASTM D3359)	5B
Salt spray* (ASTM B117/D1654)	1000+hours
Humidity* (ASTM D2247)	1000+hours
Pencil Hardness (ASTM D3363)	>H
Impact Resistance (ASTM D2794-90)	80
Solvent Resistance (ASTM D5402-06)	Pass

*Bonderite 1000 panels

SURFACE PREPARATION

Standard iron and zinc phosphate on clean steel is appropriate. High humidity or severe environmental resistance requires cleaner substrates to maintain a good Standard iron and zinc phosphate on clean steel is appropriate. High humidity or severe environmental resistance requires cleaner substrates to maintain a good bond between metal and coating.

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.

STORAGE

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

CAUTION

Adequate health and safety precautions should be observed during storage, handling, use and curing periods.

READ MATERIAL SAFETY DATA SHEETS BEFORE USING THIS PRODUCT

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 circumstances are we liable for incidental or consequential damages.