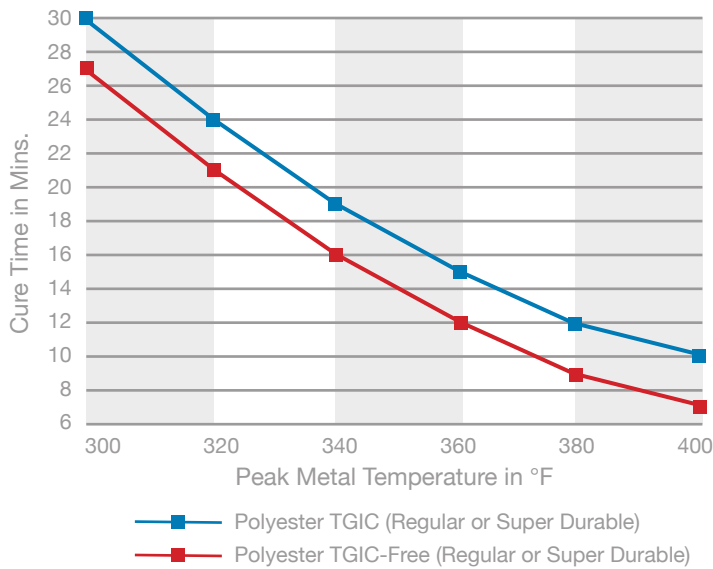


IFS Powder Coatings Cure Charts

Standard Cure Polyester TGIC & Polyester TGIC-Free



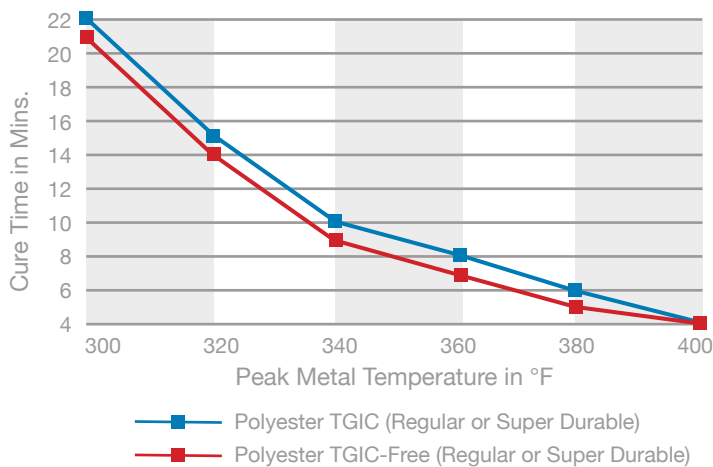
Lower gloss products may require a higher cure temperature and/or a larger dwell time to achieve minimum gloss. Please refer to the SDS for safety information.

This cure graph represents the minimum temperature the substrate must reach for the time stated.

The substrate weight and subsequent heat up rate and the efficiency of your oven should also be taken into consideration when calculating oven temperature settings and dwell times. Specialty finishes, functional coatings and lower gloss levels may require higher cure temperatures and/or longer dwell times.

Any recommendations contained herein or any information given by any IFS Coatings representative is based on tests and information believed to be accurate. However, since we have no control over the conditions under which our products are transported, stored, handled, or used by purchasers, all recommendations and sales are made on condition that IFS Coatings will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.

Low Cure Polyester TGIC & Polyester TGIC-Free



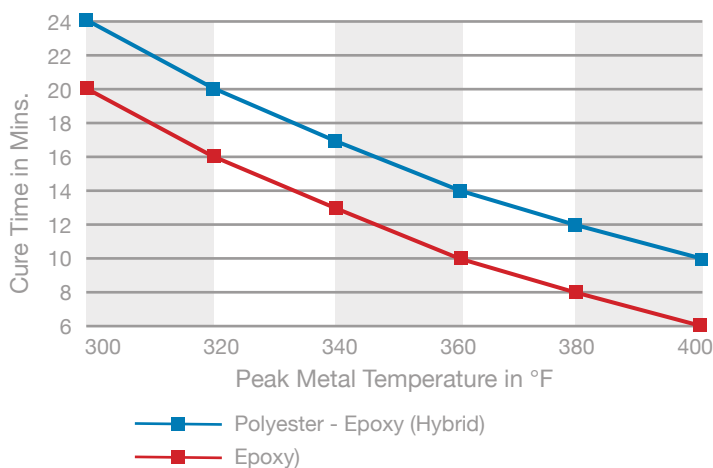
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Standard Cure Hybrid & Epoxy



IFS Powder Coatings Film Coverage

Theoretical powder coverage is calculated as follows:

$192.3 / (\text{specific gravity} \times \text{film thickness}) = \text{square feet per pound with dry film thickness (DFT) in mils}$

For example, if specific gravity is 1.45 with a film thickness of 1.2 the square feet per pound is:

$192.3 / (1.45 \times 1.2) = 110.5$

If specific gravity is 1.6 with a film thickness of 2.5 the square feet per pound is:

$192.3 / (1.6 \times 2.5) = 48.1$

Please see the below chart for more theoretical coverage examples:

		Film Thickness											
		0.6	0.8	1.0	1.2	1.4	1.6	1.8	2.0	2.5	3.0	3.5	4.0
Specify Gravity	1.2	267.1	200.3	160.3	133.5	114.5	100.2	89.0	80.1	64.1	53.4	45.8	40.1
	1.25	256.4	192.3	153.8	128.2	109.9	96.2	85.5	76.9	61.5	51.3	44.0	38.5
	1.3	246.5	184.9	147.9	123.3	105.7	92.5	82.2	74.0	59.2	49.3	42.3	37.0
	1.35	237.4	178.1	142.4	118.7	101.7	89.0	79.1	71.2	57.0	47.5	40.7	35.6
	1.4	228.9	171.7	137.4	114.5	98.1	85.8	76.3	68.7	54.9	45.8	39.2	34.3
	1.45	221.0	165.8	132.6	110.5	94.7	82.9	73.7	66.3	53.0	44.2	37.9	33.2
	1.5	213.7	160.3	128.2	106.8	91.6	80.1	71.2	64.1	51.3	42.7	36.6	32.1
	1.55	206.8	155.1	124.1	103.4	88.6	77.5	68.9	62.0	49.6	41.4	35.4	31.0
	1.6	200.3	150.2	120.2	100.2	85.8	75.1	66.8	60.1	48.1	40.1	34.3	30.0
	1.65	194.2	145.7	116.5	97.1	83.2	72.8	64.7	58.3	46.6	38.8	33.3	29.1
	1.7	188.5	141.4	113.1	94.3	80.8	70.7	62.8	56.6	45.2	37.7	32.3	28.3
	1.75	183.1	137.4	109.9	91.6	78.5	68.7	61.0	54.9	44.0	36.6	31.4	27.5
	1.8	178.1	133.5	106.8	89.9	76.3	66.8	59.4	53.4	42.7	35.6	30.5	26.7

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IFS Powder Coatings Cure Schedules

Typical cure schedules

Standard Polyester TGIC	400 °F – 10 minutes
Standard Polyester TGIC Low Cure	340 °F – 10 minutes
Standard Polyester TGIC Free	400 °F – 7 minutes
Standard Polyester TGIC Free Low Cure	340 °F – 7 minutes
Super Durable Polyester TGIC	400 °F – 10 minutes
Super Durable Polyester TGIC Low Cure	340 °F – 10 minutes
Super Durable Polyester TGIC Free	340 °F – 7 minutes
Super Durable Polyester TGIC Free Low Cure	340 °F – 7 minutes
Polyurethane (Standard and Super Durable)	400 °F – 10 minutes
Polyurethane (Standard and Super Durable) Low Cure	340 °F – 10 minutes
Hybrid	400 °F – 10 minutes
Hybrid Low Cure	340 °F – 10 minutes
Epoxy	400 °F – 7 minutes
Epoxy Low Cure	340 °F – 10 minutes
Acrylic Polyester Hybrid	400 °F – 10 minutes
Acrylic Polyester Hybrid Low Cure	340 °F – 10 minutes
Modified Polyester	400 °F – 10 minutes
Modified Polyester Low Cure	340 °F – 10 minutes
High Temperature Resistant Coatings (Modified Silicone)	450 °F – 20 minutes

Custom low cure products also available.

The times and temperatures stated are for minimum metal temperatures.

For more specific cure data, please refer to the cure graphs or talk to your IFS representative.

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IFS Powder Coatings Product Key

An explanation of the IFS Coatings coding system.

Check your product code against the below:

Letter 1 = Type of Product

P = Polyester TGIC
S = Super Durable Polyester
A = Acrylic
H = Hybrid
U = Urethane
E = Epoxy
O = Polyester TGIC Free
F = Fluoropolymer
V = Super Durable Polyester TGIC Free
T = High Heat

Letter 2 = Type of Cure

R = Regular
L = Low Cure

Letter 3 = Type of Finish

S = Smooth
A = Antique (Vein Metallic)
R = River (Structured)
M = Metallic Smooth
F = Fine Texture (Sandtex)
H = Hammertone
W = Wrinkle
B = Speckle (Multi-Colored)

Letter 4 = Gloss Range

F = Full
S = Semi
L = Low-gloss
M = Matte

Number = Color Group (4+Digits)

1 = Black
2 = Blue
3 = Green
4 = Beige
5 = Yellow
6 = Red
7 = Gray
8 = White
9 = Specialties

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