



## Technical Bulletin

### ELSS72131 KW Primer

|                                     |                                                                                                                                                                                                                                                                                                                                                                             |                                          |
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| <b>Description:</b>                 | <b>ELSS 72131, KW Primer</b> is a thermosetting Epoxy based powder coating which is designed for interior and primer applications. This product is modified to provide excellent corrosion protection.                                                                                                                                                                      |                                          |
| <b>Typical Powder Properties</b>    | Specific Gravity (ASTM D5965-96, C)                                                                                                                                                                                                                                                                                                                                         | 1.60±0.03                                |
|                                     | Theoretical Coverage                                                                                                                                                                                                                                                                                                                                                        | 120 sq./lb./mil                          |
|                                     | Mass loss during the cure (ASTM D3451-92)                                                                                                                                                                                                                                                                                                                                   | <1.0%                                    |
| <b>Typical Physical Properties:</b> | Film Thickness                                                                                                                                                                                                                                                                                                                                                              | 2.0-3.0 mil                              |
|                                     | Gloss 60°angle (ASTM D-523-89)                                                                                                                                                                                                                                                                                                                                              | 50-80                                    |
|                                     | Hardness (ASTM D-3363-92A)                                                                                                                                                                                                                                                                                                                                                  | 3H                                       |
|                                     | Flexibility (ASTM D-1737-89)                                                                                                                                                                                                                                                                                                                                                | 1/8 inch                                 |
|                                     | Adhesion (ASTM D-3359-95A)                                                                                                                                                                                                                                                                                                                                                  | 5B (100%)                                |
|                                     | Impact Direct/Indirect (ASTM D-2794-93)                                                                                                                                                                                                                                                                                                                                     | 160/160 in-lbs.                          |
|                                     | Salt Spray (ASTM B117, 4000 hrs, Bonderite 1000 panel)                                                                                                                                                                                                                                                                                                                      | Rating 7 (creepage)                      |
|                                     | Salt Spray (ASTM B117, 4000 hrs, Alodine panel)                                                                                                                                                                                                                                                                                                                             | Rating 7 (creepage)                      |
|                                     | Cyclic Corrosion (ASTM G-85, 1500 hours, Alodine panel)                                                                                                                                                                                                                                                                                                                     | Rating 7 (creepage)                      |
| <b>Application Data:</b>            | <b>ELSS 72131, KW Primer</b> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.                                                                                                                                                                                                                                                        |                                          |
| <b>Cure Schedule:</b>               | <b>ELSS 72131, KW Primer</b> can be cured in a direct or indirect gas convection oven, electric oven, an Infrared, or combination of any of these, with air-temperatures not exceeding 420°F. It should be partially or fully cured using the recommended stoving schedules, before application of the topcoat. The object temperature must not below 280°F or above 420°F. |                                          |
|                                     | <b>Standard Cure:</b>                                                                                                                                                                                                                                                                                                                                                       | 10 minutes @380°F Peak Metal Temperature |
| <b>Storage:</b>                     | <b>ELSS 72131, KW Primer</b> should be stored at temperatures below 80°F, in a dry area away from any heat source.                                                                                                                                                                                                                                                          |                                          |
| <b>Notes:</b>                       | All tests were performed on Bonderite 1000, Iron Phosphate panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the MSDS for safety information.                                                                                                                                                                                                           |                                          |

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