



Technical Bulletin

ELSS 73127 OGF Primer II

Description:

ELSS 73127, OGF Primer II is a thermosetting Epoxy based powder coating which is designed for interior and primer applications, where exterior durability is not required. This product contains Zinc compound for excellent corrosion protection and superior long term exterior performance when used as primer with a suitable exterior durable topcoat. It also possesses excellent sanding characteristics. This product has been modified to provide excellent corrosion protection and for parts where out-gassing is a problem, such as castings or galvanizing.

Typical Powder Properties

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%

Typical Physical Properties:

Film Thickness	2.0-3.0 mil
Gloss 60°angle (ASTM D-523-89)	30-60
Hardness (ASTM D-3363-92A)	2H+
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)

Application Data:

ELSS 73127, OGF Primer II is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule:

ELSS 73127, OGF Primer II 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.

Standard Cure: 10 minutes @340°F Peak Metal Temperature
15 minutes @320°F Peak Metal Temperature

Storage:

ELSS 73127, OGF Primer II should be stored at temperatures below 80°F, in a dry area away from any heat source.

Notes:

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 SDS for safety information.

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