



Technical Bulletin

HLRS 93724 Bonded Copper Free Vein

Description:	Thermosetting powder coating based on a blend of epoxy and polyester. Hybrids are designed for interior applications where exterior durability is not required. This product uses a simulated metallic that provides increased abrasion and chemical resistance over standard copper veins.		
Typical Applications:	General Metals, interior applications only		
Typical Physical Properties:	Film Thickness (ASTM D)	3.0 - 5.0 mils	
	Gloss 60°angle (Visual)	Semi	
	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)	120 in-lbs	
	Exterior Durability	Poor	
	Chemical Resistance	Good	
	Salt Spray (ASTM B117)	1000Hrs < 1/8"	
	Specific Gravity (calculated)	1.35 +/- 0.05	
Application Data:	Hybrids are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv. Hybrids can also be formulated for tribo or fluid bed application upon request.		
Cure Schedules:	Hybrids can be cured in a direct or indirect gas convection oven, an electric oven, or an Infra red. A combination of any of these ovens is also suitable.		
	Standard Cure: 10 Minutes @ 340f Peak Metal Temperature 15 Minutes @ 325f Peak Metal Temperature		
Storage:	Product should be stored at temperatures below 80 ⁰ f, in a dry area away from any heat source.		
Notes:	All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.		

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.