



Technical Bulletin

HRSF 73338 Robust Primer

Description:	HRSF 73338, Robust Primer is a thermosetting Polyester-Epoxy powder coating and modified to provide excellent chemical resistance and corrosion protection and for the substrates where out-gassing is a problem, such as castings or galvanizing.	
Applications:	Automotive Aluminum and Steel wheels and general industrial applications	
Typical Powder Properties:	Specific Gravity (ASTM D5965-96, C)	1.54±0.05
	Theoretical Coverage	125 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)	80-90
	Hardness (ASTM D-3363-92A)	2H-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, 2000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
Application Data:	HRSF 73338, Robust Primer is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	HRSF 73338, Robust Primer can be cured in a direct or indirect gas convection oven, an electric oven, or an Infrared. A combination of any of these ovens is also suitable with air-temperatures not exceeding 420°F. It should be partially cured using the recommended stoving schedules, before application of the topcoat. The object temperature must not below 260°F or above 420°F.	
	Standard Cure:	9 minutes @ 400°F Peak Metal Temperature 14 minutes @ 380°F Peak Metal Temperature
Storage:	HRSF 73338, Robust Primer 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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