



IFS 350SP

Technical Data Sheet

ORSS 84121 MG White II

Description:	<i>ORSS 84121, MG White II</i> is a thermosetting Polyester-TGIC Free powder coating and is designed for exterior durability.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.58±0.05
	Theoretical Coverage	122 sq./lb./mil
	Shelf life (at below 80°F in dry condition)	12 months
Typical Physical Properties:	Film Thickness	2.5-3.5 mil
	Gloss 60°angle (ASTM D-523-89)	45-55
	Hardness (ASTM D-3363-92A)	H-2H
	Flexibility (ASTM D-1737-89)	1/4 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct (ASTM D-2794-93; No removal of paint)	80/80 inch-lbs.
	Humidity (ASTM D-2247, 1500 hrs)	Rating 8 (Blisters)
	Salt Spray (ASTM B117, 2000 hrs, Chromated Panels)	Rating 7 (creepage)
Application Data:	<i>ORSS 84121, MG White II</i> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	<i>ORSS 84121, MG White II</i> 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.	
	Standard Cure:	10 minutes @ 400°F Peak Metal Temperature
Storage:	<i>ORSS 84121, MG White II</i> should be stored at temperatures below 80°F, in a dry area away from any heat source.	
Notes:	All tests were performed on B-1000 iron phosphated and Alodine panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.	

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