Technical Data Sheet

PLFM 10028
Matte Black Texture

Description:

PLFM 10028, Matte Black Texture is a thermosetting Polyester-TGIC powder coating and designed for interior and exterior applications.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.55±0.03
	Theoretical Coverage	124 sq.ft/lb./mil
	Shelf life (at below 80°F in dry condition)	12 months
Typical Physical Properties:	Film Thickness	2.0-3.0 mil
	Gloss 60'angle (ASTM D-523-89)	2-6 (Visual)
	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)	140/140 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 3000 hrs, Chromated Panels)	Rating 7 (creepage)

Application Data:

PLFM 10028, Matte Black Texture is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule:

PLFM 10028, Matte Black Texture 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 @ 340°F Peak Metal Temperature

Storage:

PLFM 10028, Matte Black Texture 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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