Technical Bulletin

PLRS 90138
Exterior Silver Vein

Description:	***PLRS 90138, Exterior Silver Vein*** is a thermosetting Polyester-TGIC powder coating and designed for interior and exterior durability. This product does not require clear coat as top coat for exterior applications.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.55±0.05
	Theoretical Coverage	124 sq.ft/lb./mil
	Shelf life (at below 80°F in dry condition)	12 months
Typical Physical Properties:	Film Thickness	2.5+ mil
	Gloss 60'angle (ASTM D-523-89)	Visual (70±5)
	Hardness (ASTM D-3363-92A)	H-2H
	Flexibility (ASTM D-1737-89)	¼-1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	up to 160/160 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 2000 hrs, Alodine panel)	Rating 7 (creepage)
Application Data:	***PLRS 90138, Exterior Silver Vein*** is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	***PLRS 90138, Exterior Silver Vein*** 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:	***PLRS 90138, Exterior Silver Vein*** 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 panels with a nominal film thickness of 2.5-3.5 mils. Please refer to the MSDS for safety information.	

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