



Technical Bulletin

PLSF 10641 Tube Black II

Description:	PLSF 10641, Tube Black II is a Polyester-TGIC Powder coating designed for interior or exterior applications.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.45±0.05
	Theoretical Coverage	132 sq.ft/lb./mil
	Shelf life (at below 80°F in 50% humidity)	18 months
Typical Physical Properties:	Film Thickness	2.0-3.0 mils
	Gloss 60°angle (ASTM D-523-89)	80+
	Hardness (ASTM D-3363-92A)	H-2H
	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.
	Accelerated Weathering (ASTM D523/G154, 500 hrs)	>30% Gloss retention
	Salt Spray (ASTM D1654, 1000 hrs.)	Rating 6 (Creepage)*
	* Bonderite 1000 panel	
Application Data:	PLSF 10641, Tube Black II can be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV or fluidized bed.	
Cure Schedule:	PLSF 10641, Tube Black II 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.	
	Std. Cure:	10 minutes @ 340°F Peak Metal Temperature
Storage:	PLSF 10641, Tube Black II 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 2.0-3.0 mils. Please refer to the SDS for safety information.	

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