



Technical Bulletin

PLSF 12221 ESD Gloss Black

Description:	PLSF 12221, ESD Gloss Black is a thermosetting Polyester powder coating which is designed for interior or exterior applications. This product designed to provide surface resistance in the static dissipative range (10^5 to 10^{11} ohms at 100V). Increased film thickness will reduce the conductivity of the coatings. Pre-treatment will reduce conductivity.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.44±0.05
	Theoretical Coverage	133 sq.ft/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)	85-95
	Hardness (ASTM D-3363-92A)	H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	80/80 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs. Bonderite 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 1000 hrs, G-60 Galvanized Steel)	Rating 7 (creepage)
	Surface Resistivity (ASTM D257, in ohms)	10^5 to 10^{11}
Application Data:	PLSF 12221, ESD Gloss Black is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	PLSF 12221, ESD Gloss Black 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:	PLSF 12221, ESD Gloss Black should be stored at temperatures below 80°F, in a dry area away from any heat source.	
Notes:	All tests were performed on non-treated panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.	

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