



Technical Bulletin

TUBE BROWN PLSF 40105

Description:	Thermosetting polyester TGIC powder coating designed for interior or exterior applications.		
Typical Applications:	General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.		
Typical Physical Properties:	Film Thickness		1.7 – 3.0 mil
	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
	Exterior Durability		Very Good
	Chemical Resistance		Good
	Salt Spray (ASTM B117)		1000 Hrs < 1/8'
	Specific Gravity (calculated)		1.59 +/- 0.05
	Coverage (Sq/ft/lb/mil @100% efficiency)		120.94
Application Data:	Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.		
Cure Schedule:	Polyester TGIC's 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.		
	<u>Standard Cure:</u> 10 Minutes @ 340°f Peak Metal Temperature		
Storage:	Product should be stored at temperatures below 80°f, in a dry area away from any heat source.		
Notes:	All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.		

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