



Technical Bulletin

PLSS 10029 Semi Gloss Black

Description:	PLSS 10029, Semi Gloss Black is a thermosetting Polyester-TGIC powder coating and designed for interior and exterior durability.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.57±0.03
	Theoretical Coverage	122 sq.ft/lb./mil
	Mass loss during the cure (ASTM D3451-92)	<1.0%
Typical Physical Properties:	Film Thickness	1.8-3.5 mil
	Gloss 60°angle (ASTM D-523-89)	50-60
	Hardness (ASTM D-3363-92A)	H ¹ -2H ²
	Flexibility (ASTM D522, Mandrel Bend)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	160/160 in-lbs ³
	Accelerated Weathering, 500 hrs, (ASTM G154)	60% Gloss retention ⁴
	Humidity (ASTM D2247, 1000 hrs)	No blisters
	Salt Spray (ASTM B117, 1000 hrs., B-1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 1500 hrs., Alodine panel)	Rating 7 (creepage)
³ no loss of adhesion		
Application Data:	PLSS 10029, Semi Gloss Black is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	PLSS 10029, Semi 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:	PLSS 10029, Semi 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 Alodine panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the MSDS for safety information.	

¹Hardness rating of H at 1.0 mil. The hardness rating depends on the film thickness. Thinner the coatings are lower the hardness rating.

²Hardness rating of 2H at 1.8 mil+. The hardness rating depends on the film thickness. Thicker the coatings are higher the hardness rating.

⁴QUV-A 340 lamps, cycle 6

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