



Technical Bulletin

PRSF 61288 Wet Red Smooth

Description:	PRSF 61288, Wet Red Smooth is a thermosetting powder coating based on a blend of Polyester-TGIC for exterior and interior applications.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.35±0.05
	Theoretical Coverage	142 sq./lb./mil
	Mass loss during the cure (ASTM D3451-92)	<1.0%
Typical Properties:	Film Thickness (ASTM D)	2.0-3.0+ mil
	Gloss 60'angle (Visual)	90+
	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.
	Salt Spray (ASTM B117, B1000 panels, 1000 hrs.)	ASTM Ratings #7
Application Data:	PRSF 61288, Wet Red Smooth is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv. Hybrids can also be formulated for tribo or fluid bed application upon request.	
Cure Schedules:	PRSF 61288, Wet Red Smooth can be cured in a direct or indirect gas convection oven, an electric oven, or an Infra red. A combination of any of these ovens is also suitable.	
	<u>Standard Cure:</u>	10 Minutes @ 400°F Peak Metal Temperature
Storage:	PRSF 61288, Wet Red Smooth 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. Lower gloss levels may require higher cure temperatures or longer dwell times. Please refer to the SDS for safety information.	

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