



Technical Bulletin

Statuary Bronze SRSL 41738

Description:	Ecoset 04 is a superdurable polyester powder coating designed specifically for major architectural applications where long term color and gloss retention is desired. Ecoset 04 is formulated with proven high performance raw materials to conform to the performance requirements of AAMA2604-05 (Newly released AAMA specification Superior Performing Organic Coatings). Ecoset 04 will give superior gloss and color retention when a 5-10 year color and gloss warranty is required. Length of warranty is color dependent.	
Typical Applications:	The Architectural industry. This product will meet the performance requirements of the AAMA 2604-05 (formerly 605.2-92) specification.	
Typical Physical Properties:	Film Thickness (ASTM D1400)	2.0 – 3.2 mil
	Gloss 60°angle (ASTM D-523-89)	20 - 30
	Hardness (ASTM D-3363-92A)	H – 2H
	Flexibility (ASTM D-1737-89)	3mm (.1")
	Impact Direct/Indirect (ASTM D-2794-93)	120/120 in-lbs
	Abrasion Resistance (ASTM D968)	Coefficient >40
	Chemical Resistance	Good
	Humidity (ASTM D2247)	3000 Hrs
	Salt Spray (ASTM B117)	3000 Hrs
	Weathering (Florida)(AAMA 2604-05)	Color delta E < 5 color change
	Weathering (Florida)(AAMA 2604-05)	Chalk rating No. 8 (colors)
		Chalk rating No. 6 (whites)
	Weathering (South Florida)(ASTM D523)	>30% gloss retention
	Specific Gravity (calculated)	1.51 +/- 0.05
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 @ 410 ^o f Peak Metal Temperature	
Storage:	Product should be stored at temperatures below 80 ^o 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 SDS for safety information.	

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