



# Technical Bulletin

## HLRS 93724 Bonded Copper Free Vein

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|-------------------------------------|---|--|
| <b>Description:</b>                 | Thermosetting powder coating based on a blend of epoxy and polyester. Hybrids are designed for interior applications where exterior durability is not required. This product uses a simulated metallic that provides increased abrasion and chemical resistance over standard copper veins. |  |
| <b>Typical Applications:</b>        | General Metals, interior applications only  |  |
| <b>Typical Physical Properties:</b> | Film Thickness (ASTM D)   | 3.0 - 5.0 mils   |
|                                     | Gloss 60°angle (Visual)   | Semi   |
|                                     | Hardness (ASTM D-3363-92A)  | 2H   |
|                                     | Flexibility (ASTM D-1737-89)  | 1/8 inch   |
|                                     | Adhesion (ASTM D-3359-95A)  | 5b (100%)  |
|                                     | Impact Direct/Indirect (ASTM D-2794-93)   | 120 in-lbs   |
|                                     | Exterior Durability   | Poor   |
|                                     | Chemical Resistance   | Good   |
|                                     | Salt Spray (ASTM B117)  | 1000Hrs < 1/8"   |
|                                     | Specific Gravity (calculated)   | 1.35 +/- 0.05  |
| <b>Application Data:</b>            | Hybrids are 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.  |  |
| <b>Cure Schedules:</b>              | Hybrids 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.  |  |
|                                     | Standard Cure:  | 10 Minutes @ 340f Peak Metal Temperature<br>15 Minutes @ 325f Peak Metal Temperature |
| <b>Storage:</b>                     | Product should be stored at temperatures below 80 <sup>0</sup> f, in a dry area away from any heat source.  |  |
| <b>Notes:</b>                       | 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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