



Technical Bulletin

Purecoat Hybrid Matte Clear HRSL 98544

Description: *HRSL 98544, Purecoat Hybrid Matte Clear* is a thermosetting powder coating based on a blend of epoxy and polyester for interior applications where exterior durability is not required.

Typical Applications: Shelving, dinette furniture, institutional furniture, toys, displays, beds etc.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.20±0.05
	Theoretical Coverage	160 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)	Visual
	Hardness (ASTM D-3363-92A)	2H
	Flexibility (ASTM D-1737-89)	1/4 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	140/140 in-lbs
	Salt Spray (ASTM B117)	1000 hrs < 3 mm

Application Data: *HRSL 98544, Purecoat Hybrid Matte Clear* 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: *HRSL 98544, Purecoat Hybrid Matte Clear* 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: 20 Minutes @ 325°F Peak Metal Temperature

Storage: *HRSL 98544, Purecoat Hybrid Matte Clear* 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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