



Technical Bulletin

PLRF 90355 PC855 Nu-Silver Hammertone

Description: *PLRF 90355, PC855 Nu-Silver Hammertone* is a thermosetting Polyester based powder coating which is designed for interior and exterior applications.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.24±0.05
	Theoretical Coverage	155 sq.ft./lb./mil
	Shelf life (at below 80°F in dry condition)	12 months
	Mass loss during the cure (ASTM D3451-92)	<1.0%

Typical Physical Properties:	Film Thickness	2.0-3.0 mils
	Gloss 60°angle (ASTM D-523-89)	Visual
	Hardness (ASTM D-3363-92A)	H-2H
	Flexibility (ASTM D-1737-89)	¼-1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	120/120 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)

Application Data: *PLRF 90355, PC855 Nu-Silver Hammertone* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PLRF 90355, PC855 Nu-Silver Hammertone* 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: *PLRF 90355, PC855 Nu-Silver Hammertone* 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 Phosphate panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

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