

IFS Powder Coatings Cure Schedules

Typical cure schedules

Standard Polyester TGIC	400 °F – 10 minutes
Standard Polyester TGIC Low Cure	340 °F – 10 minutes
Standard Polyester TGIC Free	400 °F – 7 minutes
Standard Polyester TGIC Free Low Cure	340 °F – 7 minutes
Super Durable Polyester TGIC	400 °F – 10 minutes
Super Durable Polyester TGIC Low Cure	340 °F – 10 minutes
Super Durable Polyester TGIC Free	340 °F – 7 minutes
Super Durable Polyester TGIC Free Low Cure	340 °F – 7 minutes
Polyurethane (Standard and Super Durable)	400 °F – 10 minutes
Polyurethane (Standard and Super Durable) Low Cure	340 °F – 10 minutes
Hybrid	400 °F – 10 minutes
Hybrid Low Cure	340 °F – 10 minutes
Epoxy	400 °F – 7 minutes
Epoxy Low Cure	340 °F – 10 minutes
Acrylic Polyester Hybrid	400 °F – 10 minutes
Acrylic Polyester Hybrid Low Cure	340 °F – 10 minutes
Modified Polyester	400 °F – 10 minutes
Modified Polyester Low Cure	340 °F – 10 minutes
High Temperature Resistant Coatings (Modified Silicone)	450 °F – 20 minutes

Custom low cure products also available.

The times and temperatures stated are for minimum metal temperatures.

For more specific cure data, please refer to the cure graphs or talk to your IFS representative.

To place an order or for more information
please call **866.437.2864**
or visit **www.ifscoatings.com**

