



Technical Bulletin

PLSF 12221 ESD Gloss Black

Description:	<i>PLSF 12221, ESD Gloss Black</i> is a thermosetting Polyester powder coating which is designed for interior or exterior applications. This product designed to provide surface resistance in the static dissipative range (10^5 to 10^{11} ohms at 100V). Increased film thickness will reduce the conductivity of the coatings. Pre-treatment will reduce conductivity.	
Typical Powder Properties	Specific Gravity (ASTM D5965-96, C) Theoretical Coverage Mass loss during the cure (ASTM D3451-92)	1.44±0.05 133 sq.ft/lb./mil <1.0%
Typical Physical Properties:	Film Thickness Gloss 60'angle (ASTM D-523-89) Hardness (ASTM D-3363-92A) Flexibility (ASTM D-1737-89) Adhesion (ASTM D-3359-95A) Impact Direct/Indirect (ASTM D-2794-93) Salt Spray (ASTM B117, 1000 hrs. Bonderite 1000 panel) Salt Spray (ASTM B117, 1000 hrs, G-60 Galvanized Steel) Surface Resistivity (ASTM D257, in ohms)	2.0-3.0 mil 85-95 H 1/8 inch 5B (100%) 80/80 in-lbs. Rating 7 (creepage) Rating 7 (creepage) 10^5 to 10^{11}
Application Data:	<i>PLSF 12221, ESD Gloss Black</i> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	<i>PLSF 12221, ESD Gloss Black</i> 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:	<i>PLSF 12221, ESD Gloss Black</i> should be stored at temperatures below 80°F, in a dry area away from any heat source.	
Notes:	All tests were performed on non-treated panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.	

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