



Technical Bulletin

URSS 90072 OB Gold Bonded

Description: *URSS 90072, OB Gold Bonded* is a thermosetting, modified polyurethane powder coating designed for superior scratch, mar resistance, excellent hardness and chemical resistance for appliances.

**Typical
Powder Properties**

Specific Gravity (ASTM D5965-96, C)	1.56±0.05
Theoretical Coverage	123 sq.ft/lb./mil

**Typical
Physical Properties:**

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

Application Data:

URSS 90072, OB Gold Bonded is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule:

10 min @ 400°F Peak Metal Temperature

Storage:

URSS 90072, OB Gold Bonded 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, Alodine panels with a nominal film thickness of 2.0 -3.0 mils. Please refer to the SDS for safety information. Bonded metallic and effect powder coatings can be recycled and this is one of their big advantages over dry blended powder. However there is still a need for some caution. The amount of reclaimed powder needs to be carefully monitored and ideally reclaim should be automated. It is recommended that recycled powder should be no more than 30% at all times. If the recycled powder level fluctuates too much, this could potentially lead to color inconsistency over a large project. It is best practice to keep the hopper well charged and to maintain a 70:30 ratio of virgin powder to reclaim at all times. Reclaim can of course be less but should never be higher than 30%.

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