



Technical Bulletin

HLRS 92915 PC031 Silver Vein Bonded

Description: *HLRS 92915, PC031 Silver Vein Bonded* is a thermosetting Polyester-Epoxy based powder coating which is designed for interior applications where exterior durability is not required. This product is manufactured in a unique way in which the aluminum is homogenous, producing an extremely consistent product that can be reclaimed.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.26±0.05
	Theoretical Coverage	152 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 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/Indirect (ASTM D-2794-93)	120/120 in-lbs.
	DOT 4 Brake Fluid Resistance (IFS TM 001-14; 48 hrs.)	Pass (No softening)
Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)	

Application Data: *HLRS 92915, PC031 Silver Vein Bonded* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *HLRS 92915, PC031 Silver Vein Bonded* 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: *HLRS 92915, PC031 Silver Vein 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, Iron Phosphate 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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