



Technical Data Sheet

KW Epoxy Primer ELSS 72131

Description: Thermosetting powder coating based on an epoxy resin. Epoxies are designed for interior applications where exterior durability is not required. This product has been modified to provide excellent corrosion protection and is recommended for primer applications.

Typical Physical Properties:	Film Thickness (ASTM D)	2.0-3.0 mil
	Gloss 60°angle (ASTM D-523-89)	30-60
	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)	160/160 in/lbs
	Chemical Resistance	Excellent
	Salt Spray (ASTM B117)	2500 hrs, 3 mm creepage
	Abrasion Resistance (ASTM D4060)	40 mg loss after 1000 cycles
	Heat Resistance ASTM D2485	Passes at 270°F
	Specific Gravity	1.60±0.05

Application Data: Epoxies can be applied with either a corona electrostatic powder spray gun at between 60kv – 100 kv or a Tribo gun. Epoxies can also be formulated for fluid bed application upon request.

Cure Schedules: Epoxies 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. Care must be taken with excess heat, as epoxies tend to discolor on overtake.

Cure: 10 minutes @ 340°f Peak Metal Temperature

Storage: Product 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 phosphated panels with a nominal film thickness of 2 mils. Lower gloss levels may require higher cure temperatures or longer dwell times. Please refer to the MSDS for safety information.

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