



## Technical Data Sheet

### Premium Copper Vein HLRS 90316

<b>Description:</b>	Thermosetting powder coating based on a blend of epoxy and polyester. Hybrids are designed for interior applications where exterior durability is not required. This product is manufactured in a unique way in which the aluminum is homogeneous, producing an extremely consistent product that can be reclaimed.	
<b>Typical Applications:</b>	Shelving, dinette furniture, institutional furniture, toys, displays, beds etc.	
<b>Typical Properties:</b>	Film Thickness (ASTM D)	2.5 – 4.0+ mil
	Gloss 60°angle (ASTM D-523-89)	Semi
	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)	up to 160 in-lbs
	Exterior Durability	Poor
	Chemical Resistance	Good – Very Good
	Salt Spray (ASTM B117)	1000Hrs < 1/8”
	Specific Gravity (calculated)	1.5
<b>Application Data:</b>	Hybrids are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv. Hybrids can be also be formulated for tribo or fluid bed application upon request.	
<b>Cure Schedules:</b>	Hybrids 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 @ 375°f Peak Metal Temperature	
<b>Storage:</b>	Product should be stored at temperatures below 80°f, in a dry area away from any heat source.	
<b>Notes:</b>	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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