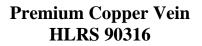
Technical Data Sheet



IFS

oa

gs

Description:	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. Shelving, dinette furniture, institutional furniture, toys, displays, beds etc.	
Typical Applications:		
Typical	Film Thickness (ASTM D)	2.5 – 4.0+ mil
Properties:	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
Application Data:	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.	
Cure Schedules:	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 @ 275° f Deek Metal Temperature	
Storegat	Standard Cure: 10 Minutes @ $375^{\circ}f$ Peak Metal Temperature	
Storage:	Product should be stored at temperatures below 80 ⁰ f, in a dry area away from any heat source. All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness	
Notes:	of 2 mils.	
	Lower gloss levels may require higher cure temperatures or longer dwell times.	
	Please refer to the MSDS for safety information.	

Any recommendations contained herein or any information given by any IFS COATINGS representative is based on tests and information believed to be accurate. However, since we have no control over the conditions under which our products are transported, stored, handled, or used by purchasers, all recommendations and sales are made on condition that IFS COATINGS will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.

> 3601 North Interstate 35 Gainesville Texas 76240 Tel. (940) 668 1062 Fax. (940) 668 1061 www.ifscos.com Email: info@ifscos