



Technical Bulletin

PRMF 97219 Dormant Blue Bonded

Description: *PRMF 97219, Dormant Blue Bonded* is a thermosetting modified Polyester powder coating and designed for interior and exterior durability. When properly applied this product will meet or exceed the AAMA 2603 specification.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.21+/-0.05
	Theoretical Coverage	159 sq./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)	¼-1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	120/120 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 2000 hrs, Alodine panel)	Rating 7 (creepage)

Application Data: *PRMF 97219, Dormant Blue Bonded* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PRMF 97219, Dormant Blue 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 @ 400°F Peak Metal Temperature

Storage: *PRMF 97219, Dormant Blue Bonded* should be stored at temperatures below 80°F, in a dry area away from any heat source.

Notes: All tests were performed on B-1000 iron phosphated panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the MSDS for safety information.

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