



Technical Bulletin

PRMF 97223 Dormant Red Bonded

Description: *PRMF 97223, Dormant Red 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.

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| Typical Powder Properties | Specific Gravity (ASTM D5965-96, C) | 1.21+/-0.05 |
| | Theoretical Coverage | 159 sq./lb./mil |

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| 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 97223, Dormant Red Bonded* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PRMF 97223, Dormant Red 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 97223, Dormant Red 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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