



Technical Bulletin

Speed Boat Aluminum III PRSS 91020

Description: Thermosetting polyester TGIC powder coating designed for interior or exterior applications.

Typical Applications: Decorative Finishes

Typical Physical Properties:	Film Thickness	2.5-3.5+ mil
	Gloss 60°angle (ASTM D-523-89)	90+
	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)	140/140 in-lbs.
	Salt Spray (ASTM B117)	1000 Hrs. < 1/8'
	Specific Gravity (calculated)	1.33+/- .05

Application Data: Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.

Cure Schedule: Polyester TGIC's 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: 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. Please refer to the MSDS for safety information.

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