



# Technical Bulletin

## 2604 Light Blue SRSS 21708

**Description:** Thermosetting superdurable polyester TGIC powder coating designed for interior and exterior use where long term color and gloss retention is required. When properly applied over an appropriate substrate, this product will meet or exceed the requirements of the AAMA 2604-05 specification.

**Typical Applications:** General architectural finishing.

<b>Typical Powder Properties</b>	Specific Gravity (ASTM D5965-96, C)	1.60±0.05
	Theoretical Coverage	126 sq./lb./mil

<b>Typical Physical Properties:</b>	Film Thickness	2.0-3.0 mil
	Gloss 60°angle (ASTM D-523-89)	30-40
	Hardness (ASTM D-3363-92A)	H – 2H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	100/100 in-lbs
	Salt Spray (ASTM B117, 1000 hrs, B 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 3000 hrs, Chromated panel)	Rating 7 (creepage)

**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. Lower gloss products may require a longer cure time and/or higher cure temperature to achieve minimum gloss. Please refer to the MSDS for safety information.

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