

# Powder Coating Data Sheet

## Polyester TGIC-Free

### Description

Polyester TGIC-Free coatings have excellent weatherability combined with excellent mechanical properties. Charging characteristics of these powders are excellent, making hard to coat parts much easier. Additionally, these products are TGIC Free, and have very fast curing rates, making them excellent coatings for temperature sensitive or heavy gauge substrates.

### Applications

Typical application of polyester TGIC-Free coatings includes usage on patio furniture, sporting gear, fencing, automotive trim, door and window frames, playground equipment and tire rims.

Properties noted below are based on typical powder coatings, applied on Bonderite CRS panels

### Powder Properties

Cure Schedule	6' - 8' at 375°F metal temperature
Storage Stability	Excellent - 6 months minimum at less than 25C
Specific Gravity (calculated)	1.2 to 1.8 depending on formulation
Particle Size Distribution	55-65% > 32 microns (Alpine Jet Sieve)

### Cured Film Properties

Gloss	Gardner 60 deg.	40-100
Impact	ASTM D-2794	Up to 160 in lbs
Pencil Hardness	ASTM D3363	H to 2H
Cross Hatch Adhesion	ASTM D-3359	Full pass (5B)
Flexibility - Conical Mandrel	ASTM D522	180 degrees 1/4 " Mandrel
Overbake Resistance	200 % Overbake	Good to excellent

Note: This information is given in good faith based upon information believed to be true at the time of issue. However, no warranty expressed or implied can be given as results may vary due to application and other conditions. This table is not intended to give exact specifications for any particular product but to be used only as a general guide.

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