TECHNICAL DATA SHEET

T005 - BK78
POLYESTER T GIC POWDER COATING
SEMI GLOSS SMOOTH
BLACK

POWDER PROPERTIES
SPECIFIC GRAVITY: 1.68 CALCULATED
COVERAGE: 57.5 SQ.FT./LB. @ 2 MILS (100% EFFICIENCY)
PARTICLE SIZE: 25 - 50 MICRONS AVERAGE
STORAGE: STORE BELOW 80 DEGREES F, IN COOL DRY ENVIRONMENT
SHELF LIFE: MINIMUM OF 1 YEAR
CURE SCHEDULE: (METAL TEMPERATURE) 10 MINUTES @ 400 DEGREES F.

CURED FILM PROPERTIES
ALL TESTS WERE PERFORMED AT A FILM THICKNESS OF: 2.0 to 3.5 mils

<table>
<thead>
<tr>
<th>TEST</th>
<th>METHOD</th>
<th>RANGE</th>
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<tbody>
<tr>
<td>GLOSS @ 60 DEGREES</td>
<td>D523</td>
<td>50% +/-5%</td>
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<tr>
<td>DIRECT IMPACT (INCH LBS.)</td>
<td>D2794</td>
<td>100 in Lbs.</td>
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<tr>
<td>INDIRECT IMPACT (INCH LBS.)</td>
<td>D2794</td>
<td>100 in Lbs.</td>
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<tr>
<td>PENCIL HARDNESS</td>
<td>D3363</td>
<td>2H</td>
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<tr>
<td>CROSS HATCH ADHESION</td>
<td>D3359B</td>
<td>4B</td>
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<tr>
<td>FLEXIBILITY (CONICAL MANDRELL)</td>
<td>D1737/D522</td>
<td>100%</td>
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CHEMICAL AND CORROSION EXPOSURE TESTS
SALT SPRAY RESISTANCE: 1000 hours (ASTM Method B117) with < 1/8 in. creep from scribe.
HUMIDITY RESISTANCE: 1000 hours (ASTM Method D2247) no loss of adhesion or blistering.
CHEMICAL RESISTANCE: Good to excellent resistance to most solvents, oils, acids, and alkalies.
OVERBAKE RESISTANCE: Slight yellowing is evident, especially in white and pastel colors.

All tests were performed on 24 gauge bonderite 1000.

APPLICATION
This product was designed to be applied by electrostatic spray, on steel, galvanized steel, or aluminum.
Most powders can be reclaimed, sieved and recycled, if proper housekeeping is maintained.

PRE TREATMENT
The substrate pretreatment prior to powder coating is a critical factor in developing maximum corrosion resistance and maximizing the lifetime of the product.

C.R.S. (Iron phosphate): 2 to 5 stages depending upon soil level, and quality desired.
C.R.S. (Zinc phosphate): 5 to 9 stages depending upon soil level, and quality desired.
Galvanized steel (Zinc phosphate): 5 to 7 stages depending on soil level, and quality desired. Galvanized steel must be degassed at 5 degrees above cure temperature to minimise gassing.
Aluminum (Chromate): 5 stage system is normally needed.
Aluminum (phosphate): 5 stage system is normally needed.

D10MS