C291 - GN20
POLYESTER POWDER COATING
SEMI GLOSS TEXTURE
PATINA

POWDER PROPERTIES
SPECIFIC GRAVITY: 1.65  CALCULATED
COVERAGE: 58.55 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 @ 350 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>10% +/-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>
</tr>
<tr>
<td>FLEXIBILITY (CONICAL MANDREL)</td>
<td>D1737/D522</td>
<td>100%</td>
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CHEMICAL AND CORROSION EXPOSURE TESTS
CHEMICAL RESISTANCE: Good to excellent resistance to most solvents, oils, acids, and alkalis.
OVERBAKE RESISTANCE: Slight yellowing is evident, especially in white and pastel colors.

All tests were performed on 24 gauge Bonderite 1000 panels.

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 minimize gassing.
Aluminum (Chromate): 5 stage system is normally needed.
Aluminum (phosphate): 5 stage system is normally needed.

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