TECHNICAL DATA SHEET

T009 - OG01
POLYESTER TGIC POWDER COATING
FULL GLOSS SMOOTH
FS#12473 ORANGE

POWDER PROPERTIES
SPECIFIC GRAVITY: 1.64 CALCULATED
COVERAGE: 58.9 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: 1.5 to 3.0 mils

TEST | METHOD | RANGE
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GLOSS @ 60 DEGREES: | D523 | 90% +/-5%
DIRECT IMPACT (INCH LBS.): | D2794 | 120 in.lbs.
INDIRECT IMPACT (INCH LBS.): | D2794 | 120 in.lbs.
PENCIL HARDNESS: | D3363 | 2H
CROSS HATCH ADHESION: | D3359B | 4B
FLEXIBILITY (CONICAL MANDREL): | D1737/D522 | 100%

CHEMICAL AND CORROSION EXPOSURE TESTS
CHEMICAL RESISTANCE: Good to excellent resistance to most solvents, oils, acids, and alkaies.
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.

IMPORTANT: Warranty and Disclaimer – The performance characteristics of these products vary according to the product application, operating conditions, materials applied to or used. Since these factors can affect results, we strongly recommend that you make your own tests to determine your satisfaction whether the product is of acceptable quality, has not been affected by storage or transportation and is suitable for your particular purpose under your own operating conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.

www.cardinalpaint.com

Southern California
Corporate Headquarters
1329 Potrero Avenue
South El Monte, CA 91733
tel 626.444.9274 fax 626.444.0382

Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 626.937-6767

Arizona
Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 602.437.2401

Colorado
Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 303.286.1876

Missouri
Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 314.878.3010

Pennsylvania
Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 814.728.0721

Washington State
Powder Coating Manufacturing
1329 Potrero Avenue
South El Monte, CA 91733
tel 425.483.5665