



POWDER COATING

Technical Data Sheet

Highlights

PPG's Envirocyl™ and Envirocron™ powder coatings are aesthetically pleasing, produce a durable uniform finish and can be custom formulated with finishes from high gloss to low gloss, and in a variety of textures.

PPG's "World Class" Polyester Powder Coatings provide a combination of good physical and chemical resistance properties. This extensive line of Polyester Powders is manufactured to meet the increasing requirement demands of the appliance and industrial markets. These sophisticated Polyesters are the solution to your smoothness, low-bake, durability and physical property requirements. An unsurpassed application development program enables consistently friendly use on a variety of substrates.

- Available in a wide range of colors and glosses
- Exterior durability
- Good chemical resistance
- Low cure capabilities

PRODUCT APPROVALS

UL Approved
NSF 51 Approved for Food Zone

TEST CONDITIONS

| Property | Test method | Value |
|-----------------------|-------------------|-------------------------|
| Substrate | | Pretreated steel panels |
| Recommended Thickness | ASTM D 7091 | 2.0 - 3.0 mils |
| Curing Conditions | Metal Temperature | 10 min @ 350 °F |

PRODUCT PROPERTIES

| Property | Test method | Value |
|----------------------|---------------------|---|
| Appearance | Visual Inspection | Smooth |
| Gloss 60° | ASTM D 523 | 85 Minimum |
| Adhesion | ASTM D 3359 | 100% (5B Pass) |
| Hardness | ASTM D 3363 | H Pencil (Eagle) |
| Impact - Direct | ASTM D 2794 | 160 in-lbs |
| Impact - Reverse | ASTM D 2794 | 160 in-lbs |
| Conical Mandrel | ASTM D 522 | 1/8" Mandrel - No cracking |
| Salt spray | ASTM B 117 | 1000 hrs |
| Humidity | ASTM D 4585 @ 38° C | 100 °F, 100% RH - 1000+ hrs |
| Specific gravity | Calculated | 1.65 ± .05 |
| Theoretical coverage | Calculated | 117 ft ² /lbs at 1.0 mil 23.9 m ² /kg at 25 µm |





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CURING WINDOW* (object temperature)

See Cure Curve PCS-004

- 20 min @ 300 °F (149 °C)
- 10 min @ 350 °F (177 °C)
- 5 min @ 400 °F (204 °C)

*Temperature and time to be adjusted to accomplish proper curing of coating. This can be achieved using infrared, convection, or combination ovens.

STORAGE STABILITY

24 months at 77 °F maximum

Materials need to be stored in sealed plastic bags under dry and cool conditions. Do not expose to sunlight.

PPG recommends that all material be used in FIFO order (first in - first out). Materials that exceed the recommended shelf life should be tested prior to use.

SUBSTRATE PREPARATION

Surface preparation should be chosen according to the type of substrate and required performance. The coater should test the suitability of the surface preparation before the application using appropriate test methods.

APPLICATION RECOMMENDATIONS

Electrostatic Spray

Coating can be applied with automatic and manual devices.

Substrate should be correctly cleaned before use.

Do not mix this product with other powder coatings.

Color and finish influenced by film thickness: a good control of the film thickness will help the consistency of the aspect.

HEALTH AND SAFETY

For comprehensive Health, Safety, and Environmental advice, please refer to the relevant Safety Data Sheets, and information printed on the product label.

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