

**PIONEER POWDER
TECHNICAL DATA SHEET
EPOXY POLYESTER HYBRID CHARACTERISTICS**

**HK34-2DS-N
JET BLACK HYBRID**



Mfg. after 11-3-99

POWDER SPECIFICATIONS	FILM PROPERTIES
SPECIFIC GRAVITY: 1.62 +/- .05 THEO. COVERAGE @1 MIL.: 119 SQ.FT./LB.	GLOSS LEVEL: 55 TO 65
SALT SPRAY (ASTM B-117): 1000 HR., LESS THAN 1/8" CREEPAGE FROM SCRIBE	SOLVENT RESISTANCE: 50 DOUBLE RUBS NO METAL SHOWS COATING SOFTENS SLIGHTLY
GEL TIME: RANGING FROM 60 TO 100 SEC.	IMPACT RESISTANCE (ASTM D-2794): 100 IN LB.
QUV RESISTANCE: 100 HOURS LESS THAN 50% DROP IN GLOSS	OVERBAKE CAPABILITY: 100 PERCENT
HUMIDITY (ASTM D-2247): 1000 HOURS NO SOFTENING OF COATING OR GLOSS DROP	PENCIL HARDNESS (ASTM D-3363): H TO 2H
FILM THICKNESS: 1.5 TO 2.0 MILS	FLEXIBILITY (ASTM B-522): 1/8" CONICAL BEND NO CRACKING SHOWS
SUBSTRATE TESTED: IRON PHOSPHATE BONDRITE 1000 PANELS	ADHESION (ASTM D-3359): 100 SQUARES SCRIBED, NO PEEL OFF WITH TAPE

CURE CYCLE: 10 MINUTES AT 375 DEGREES FAHRENHEIT

STORAGE: SIX MONTHS SHELF LIFE; LESS THAN 75 DEGREES F