

**PIONEER POWDER
TECHNICAL DATA SHEET
POLYESTER TGIC CHARACTERISTICS**

**RAL 2010
SIGNAL ORANGE**

| POWDER SPECIFICATIONS | FILM PROPERTIES |
|---|---|
| SPECIFIC GRAVITY: 1.51 +/- .05 THEO. COVERAGE @ 1 MIL. :127 SQ.FT./LB. | GLOSS LEVEL : 85+ |
| 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: 50 TO 100 Sec. | IMPACT RESISTANCE: (ASTM D-2794): 100 IN LB |
| QUV RESISTANCE:400 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-2H |
| FILM THICKNESS: 2.5 TO 3.0 MILS | FLEXIBILITY (ASTM D-522): 1/8" CONICAL BEND NO CRACKING |
| 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