

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

**TK12-6DS-T  
BLACK TEX TGIC**

<b>POWDER SPECIFICATIONS</b>	<b>FILM PROPERTIES</b>
SPECIFIC GRAVITY: 1.75 +/- .05 THEO. COVERAGE @ 1 MIL. 110 SQ. FT./LB.	GLOSS LEVEL: VISUAL
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: 70 TO 120 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 3.5 MILS	FLEXIBILITY (ASTM B-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: 7 MINUTES AT 325 DEGREES FAHRENHEIT**

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