

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

**TK21-5D6
SUMMIT BLACK TGIC**

POWDER SPECIFICATIONS	FILM PROPERTIES
SPECIFIC GRAVITY: 1.51 +/- .05 THEO. COVERAGE @ 1 MIL. 127 SQ. FT./LB.	GLOSS LEVEL: 55 TO 65
SALT SPRAY (ASTM B-117): 1000 HR., LESS THAN 1/16" 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: 2.0 TO 3.0 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: 10 MINUTES AT 350 DEGREES FAHRENHEIT

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