

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

**UK24-2D0
FLAT BLACK**

POWDER SPECIFICATIONS	FILM PROPERTIES
SPECIFIC GRAVITY: 1.66 +/- .05 THEO. COVERAGE @ 1 MIL. :116 SQ.FT./ LB.	GLOSS LEVEL: 0 TO 10
SALT SPRAY (ASTM B-117): 1000 HR., LESS THAN 1/8" CREEPAGE FROM SCRIBE	SOLVENT RESISTANCE: 50 DOUBLE MEK RUBS, NO METAL SHOWS, COATING SOFTENS SLIGHTLY
GEL TIME: RANGING FROM 70 TO 110 SEC	IMPACT RESISTANCE (ASTM D-2794): MINIMUM 100 IN LB FORWARD AND REVERSE
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 TO 2H
FILM THICKNESS: 1.5 TO 2.5 MILS	FLEXIBILITY (ASTM B-522): 1/8" CONICAL BEND NO CRACKING SHOWS
SUBSTRATE TESTED: IRON PHOSPHATE BONDERITE 1000 PANELS	ADHESION (ASTM D-3359): 100 SQUARES SCRIBED, NO PEEL OFF WITH TAPE

CURE CYCLE: 10 MINUTES AT 400 DEGREES FAHRENHEIT

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