



# Technical Data Sheet

**Product Number: PNL327418**

**Product Name: MMI BLACK 27418 POL.**

**Chemistry: POLYESTER TGIC**

**Date: DECEMBER 23<sup>RD</sup>, 2014**

## *Powder Properties*

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<b>ASTM D5965 (B)</b>	Specific Gravity	1.75 ± 0.05
<b>PCI TECHNICAL BRIEF #8</b>	Theoretical Coverage	109.8 ft <sup>2</sup> /lb/mil
	Shelf Life	12 months in climate controlled environment

## *Film Characteristics*

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<b>ASTM D523</b>	Gloss @ 60°	50-60%
<b>ASTM D3359 (B)</b>	Adhesion	5B Pass
<b>ASTM D3363</b>	Pencil Test (Scratch Hardness)	2H Pass
<b>ASTM D7091</b>	Recommended Film Thickness	2.0-3.0 mils
<b>PCI TECHNICAL BRIEF #20</b>	PCI Powder Smoothness	5
<b>ASTM D522 (A)</b>	Flexibility Mandrel	1/8"
<b>ASTM D2794</b>	Indirect Impact	60 in/lbs
<b>ASTM D5402</b>	MEK Resistance	25 Double Rubs
<b>ASTM B117</b>	Salt Spray	1,000 hours
<b>ASTM G154</b>	UV Resistance	500 hours

## *Application*

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Electrostatic Spray, Cold  
Substrate: 0.024 in. CRS  
Pretreatment: Bonderite® 1000 , Parcolene® 60

**Cure Schedule**  
(Time at Substrate Temperature)  
325 °F @ 20 minutes

## *Notes*

American Standard Testing Method (ASTM)  
Powder Coating Institute

This report cannot be altered or changed without the authorization of the Quality Manager.

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