



Technical Data Sheet

Product Number: WNL331633

Product Name: MONARCH BLACK 31633 POL. SD TGIC FREE

Chemistry: POLYESTER SUPERDURABLE TGIC FREE

Date: MARCH 13RD, 2018

Powder Properties

ASTM D5965 (B)	Specific Gravity	1.50 ± 0.05
PCI TECHNICAL BRIEF #8	Theoretical Coverage	128.1 ft ² /lb/mil
	Shelf Life	12 months in climate controlled environment

Film Characteristics

ASTM D523	Gloss @ 60°	50-60%
ASTM D3359 (B)	Adhesion	5B Pass
ASTM D3363	Pencil Test (Scratch Hardness)	2H Pass
ASTM D7091	Recommended Film Thickness	2.0-3.0 mils
PCI TECHNICAL BRIEF #20	PCI Powder Smoothness	5
ASTM D522 (A)	Flexibility Mandrel	1/8"
ASTM D2794	Indirect Impact	60 in/lbs
ASTM D5402	MEK Resistance	50 Double Rubs
ASTM B117	Salt Spray	3,000 hours
ASTM G154	UV Resistance	1,000 hours

Application

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

Cure Schedule
(Time at Substrate Temperature)
356 °F @ 10 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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