



Technical Data Sheet

Product Number: PNG50111

Product Name: BLACK HAMMERTONE 21981

Chemistry: Polyester Tgic

Date: August 17, 2011

Powder Properties

ASTM D5965 (B)	Specific Gravity	1.70± 0.05
PCI TECHNICAL BRIEF #8	Theoretical Coverage	113.1 ft ² /lb/mil
	Shelf Life	12 months in climate controlled environment

Film Characteristics

ASTM D523	Gloss @ 60°	20-40
ASTM D3359 (B)	Adhesion	5B Pass
ASTM D3363	Pencil Test (Scratch Hardness)	H Pass
ASTM D7091	Recommended Film Thickness	4.5-6.0 mils
PCI TECHNICAL BRIEF #20	PCI Powder Smoothness	N.A.
ASTM D522 (A)	Flexibility Mandrel	1/8" Pass
ASTM D2794	Impact (D/R)	60/60 in-lbs
ASTM D5402	MEK Resistance	25 Double Rubs
ASTM B117	Salt Spray	1,000 hours
ASTM G154	UV Resistance	500 hours

Application

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

Cure Schedule
(Time at Substrate Temperature)
15 min @ 400°F

Notes

American Standard Testing Method (ASTM)
Powder Coating Institute (PCI)

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

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