



# TECHNICAL DATA SHEET

## P000 - BG631

POLYESTER POLYURETHANE POWDER COATING  
SEMI GLOSS SMOOTH  
FS #33446 BEIGE

LS #: 11337

RoHS Compliant

### POWDER PROPERTIES

SPECIFIC GRAVITY: 1.47 CALCULATED  
COVERAGE: 65.71 SQ.FT./LB. @ 2 MILS (100% EFFICIENCY)  
PARTICLE SIZE: 25 - 50 MICRONS AVERAGE  
STORAGE: STORE BELOW 80 DEGREES F, IN COOL DRY ENVIRONMENT  
SHELF LIFE: MINIMUM OF 1 YEAR  
CURE SCHEDULE: (METAL TEMPERATURE) 12 MINUTES @ 400 DEGREES F.

### CURED FILM PROPERTIES

ALL TESTS WERE PERFORMED AT A FILM THICKNESS OF: 1.5 to 3.0 mils

| TEST                           | METHOD     | RANGE     |
|--------------------------------|------------|-----------|
| GLOSS @ 60 DEGREES:            | D523       | 0% - 10%  |
| DIRECT IMPACT (INCH LBS.):     | D2794      | 20 in.lbs |
| INDIRECT IMPACT (INCH LBS.):   | D2794      | 20 in.lbs |
| PENCIL HARDNESS:               | D3363      | 2H        |
| CROSS HATCH ADHESION:          | D3359B     | 4B        |
| FLEXIBILITY (CONICAL MANDREL): | D1737/D522 | 90%       |

### CHEMICAL AND CORROSION EXPOSURE TESTS

CHEMICAL RESISTANCE: Good to excellent resistance to most solvents, oils, acids, and alkalis.  
OVERBAKE RESISTANCE: Slight yellowing is evident, especially in white and pastel colors.

All tests were performed on 24 gauge Bonderite 1000 panels

### APPLICATION

This product was designed to be applied by electrostatic spray, on steel, galvanized steel, or aluminum. Most powders can be reclaimed, sieved and recycled, if proper housekeeping is maintained.

### PRE TREATMENT

The substrate pretreatment prior to powder coating is a critical factor in developing maximum corrosion resistance and maximizing the lifetime of the product.

C.R.S. (Iron phosphate): 2 to 5 stages depending upon soil level, and quality desired.  
C.R.S. (Zinc phosphate): 5 to 9 stages depending upon soil level, and quality desired.  
Galvanized steel (Zinc phosphate): 5 to 7 stages depending on soil level, and quality desired.  
Galvanize steel must be degassed at 5 degrees above cure temperature to minimize gassing.  
Aluminum (Chromate): 5 stage system is normally needed.  
Aluminum (phosphate): 5 stage system is normally needed.

D09MS

**IMPORTANT: Warranty and Disclaimer** – The performance characteristics of these products vary according to the product application, operating conditions, materials applied to or use. Since these factors can affect results, we strongly recommend that you make your own tests to determine your satisfaction whether the product is of acceptable quality, has not been affected by storage or transportation and is suitable for your particular purpose under your own operating conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.

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