



TECHNICAL DATA SHEET

E311 - BK04

EPOXY POWDER COATING
SEMI GLOSS SELF HAMMER
BLACK

LS #:

RoHS Compliant

POWDER PROPERTIES

SPECIFIC GRAVITY: 1.63 CALCULATED
COVERAGE: 59.26 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) 10 MINUTES @ 400 DEGREES F.

CURED FILM PROPERTIES

ALL TESTS WERE PERFORMED AT A FILM THICKNESS OF: 2.5 to 3.0 mils

TEST	METHOD	RANGE
GLOSS @ 60 DEGREES:	D523	10% +/-10%
DIRECT IMPACT (INCH LBS.):	D2794	60 in.lbs
INDIRECT IMPACT (INCH LBS.):	D2794	60 in.lbs
PENCIL HARDNESS:	D3363	2H
CROSS HATCH ADHESION:	D3359B	4B
FLEXIBILITY (CONICAL MANDREL):	D1737/D522	80%

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.
Galvanized 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.

110MS

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.

www.cardinalpaint.com

**Southern California
Corporate Headquarters**
1329 Potrero Avenue
South El Monte, CA 91733
tel 626.444.9274 fax 626.444.0382

**Powder Coating
Manufacturing**
tel 626.937-6767

Arizona
tel 602.437.2401

Colorado
tel 303.286.1876

Missouri
tel 314.878.3010

Pennsylvania
tel 814.728.0721

Washington State
tel 425.483.5665

Northern California
tel 408.452.8522

Minnesota
tel 952.469.6021

North Carolina
tel 336.882.9493

Texas
tel 214.333.9801

Hong Kong
tel 852.2410.8200