

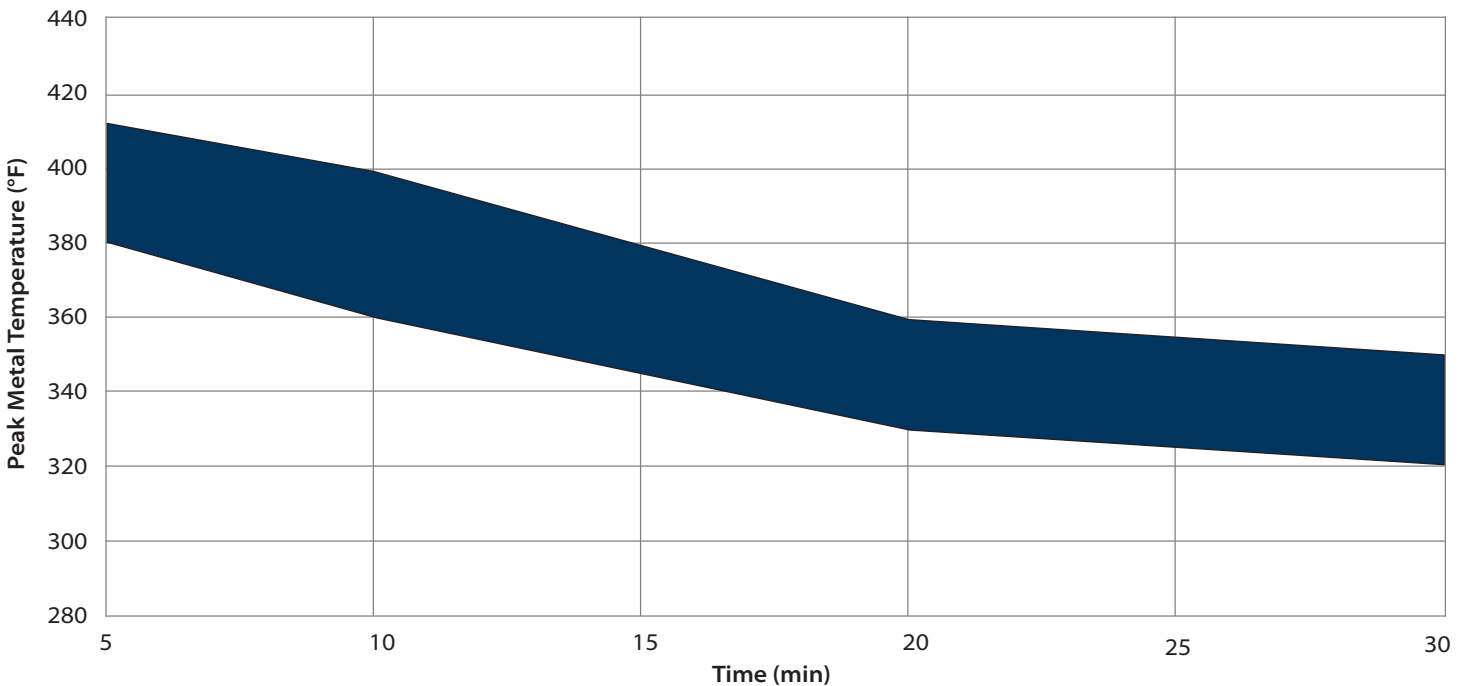
Hybrid Powder Coatings

Diamond Vogel H-Series Powder Coatings offer excellent application and performance characteristics. Diamond Vogel's H-Series Powder Coatings' tightly controlled particle size distribution provides extremely good first-pass transfer efficiencies and edge coverage, along with the smoothest film available. These coatings exhibit good adhesion and resistance properties, offering an economical alternative to epoxies. Hybrid powder coatings will have limited exterior exposure due to the epoxy component, whereas slightly improved overbake resistance to yellowing is found in the polyester component.

TYPICAL APPLICATIONS

- Fire extinguishers
- Electrical enclosures
- Garden tools
- Under the hood automotive
- Tool boxes
- Shelving
- Power tools
- Office furniture

CURE SCHEDULES



- Recommended cure schedule 10 minutes @ 390°F, peak metal temperature

The cure range for Hybrid Powder Coatings is from 20 minutes at 350°F to 7 minutes at 400°F peak metal temperature. Faster cure formulations are available.

CURED FILM PROPERTIES

PCI Powder Smoothness Rating.....	5-9 (high gloss)	Impact (ASTM D2794).....	160+ inch lbs
Specific Gravity (ASTM D792).....	1.2 to 1.8	Flexibility (ASTM D522).....	1/8 inch – No fracturing
Adhesion (ASTM D3359).....	5B (100%)	Humidity (ASTM D2247).....	1,000+ hours
Gloss (ASTM D523).....	10-99	Salt Spray (ASTM B117).....	1,000+ hours
Pencil Hardness (ASTM D3363).....	H-4H		

*Film properties are dependent on gloss, pigmentation, film thickness, and cure temperature.

Storage and Handling: Diamond Vogel powder coatings should be stored at normal room temperature and humidity (less than 80°F and 50-60% RH). Shelf life will be approximately six months to over a year depending on storage conditions. Always rotate inventories to ensure trouble-free powder application. When storage conditions are not the same as the application area, allow a 24 hour acclimation period within the application area to prevent moisture condensation in the powder. Always protect virgin and reclaim powder from excessive heat and humidity.

Industrial Hygiene: Powder handling should always be done in conjunction with proper dust collection and personal protective equipment. Please refer to the Material Safety Data Sheet for more detailed information.