

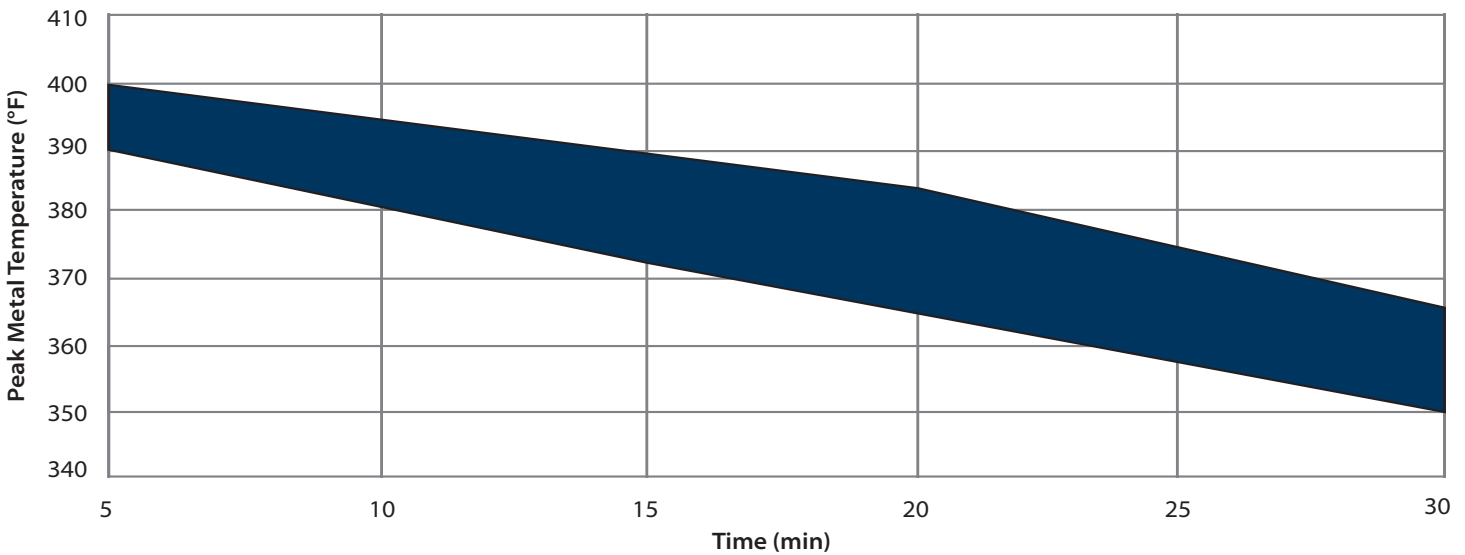
Urethane Polyester Powder Coatings

Diamond Vogel U-Series Powder Coatings offer excellent application and performance characteristics. Diamond Vogel's U-Series Powder Coatings' tightly controlled particle size distribution provides extremely good first pass-transfer efficiencies and edge coverage, along with the smoothest film available. Urethane powder coatings exhibit excellent gloss retention and long-term resistance to humidity and corrosion in thin film applications (less than 3 mils DFT).

TYPICAL APPLICATIONS

- Agricultural equipment
- Air conditioners
- Electrical enclosures
- Office furniture
- Lawn and garden equipment
- Rims and wheels
- Outdoor furniture
- Under the hood automotive
- Light fixtures
- Construction equipment

CURE SCHEDULES



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

The cure range for Urethane Powder Coatings is from 20 minutes at 380°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
Adhesion (ASTM D3359).....	5B (100%)	Humidity (ASTM D2247).....	1,000+ hours
Gloss (ASTM D523).....	10-99	Salt Spray (ASTM B117).....	1,000-3,500 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.