



CHANNEL GREEN QUALITY: POLYESTER

Powder Properties

Test Method	Powder Properties	Tolerances
ASTM D3451 (18.30)	Specific Gravity	1.33 ± 0.03
ASTM D3451 (18.30)	Theoretical Coverage	144.58 ± 4.0 FT ² /Lb/Mil.
ASTM D3451 (13)	Volatile Content	Max. 2.5%
ASTM D3451 (13)	Storage Temperature Max	80°F

Coating Properties

All tests performed on Substrate 0.032 CRS
Pretreatment Bonderite 1000

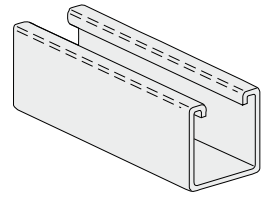
Test Method	Coating Properties	Tolerances/ Specifications
ASTM D523	Gloss 20°/60°	70-80
ASTM D2454	Over Bake Resistance Time	100%
ASTM D3363	Pencil Hardness	H - 2H
ASTM D2794 (Modified)	Direct Impact (Gardner)	80 in. Lbs.
ASTM D2794 (Modified)	Reverse Impact (Gardner)	80 in. Lbs.
ASTM D33598B	Adhesion (Cross Hatch)	Pass No Adhesion Loss
ASTM D5222	Flexibility (Mandrel)	¹ / ₈ Bend No Fracture
ASTM 117	Salt Spray	1000 Hrs.
ASTM D2247	Humidity	500 Hrs.

Application

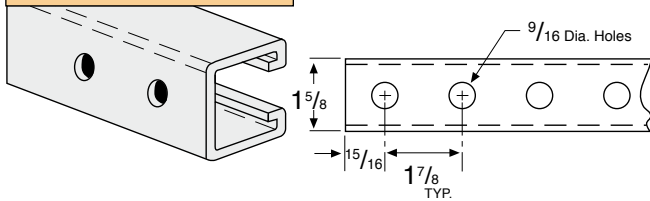
Test Method	Application	Cure Schedule
Electrostatic Spray	Ambient Temperature	15' @ 190°C (375°F) Recommend Minimum Film Thickness 1.5

Selection Chart

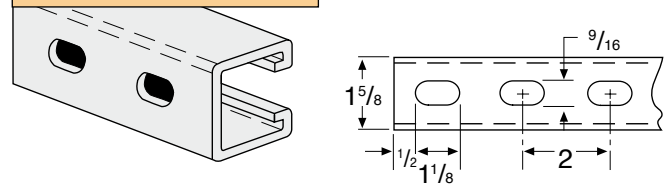
Figure Number	Width	Height	Material Size	See Page Number
1001-1042	1-5/8	1-5/8	12 Ga.	26
1101-1142	1-5/8	1-5/8	14 Ga.	28
1201-1242	1-5/8	13/16	12 Ga.	30
1301-1342	1-5/8	13/16	14 Ga.	32
1401-1442	1-5/8	1	12 Ga.	34
1501-1542	1-5/8	3-1/4	12 Ga.	36
1601-1642	1-5/8	2-7/16	12 Ga.	38
1701-1742	1-5/8	1-3/8	12 Ga.	40



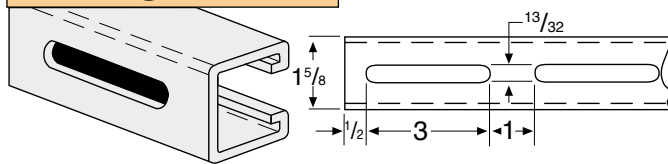
Holes



Slots



Long Slots



Knockouts

