



TECHNICAL DATA SHEET

E396 - GR1372

EPOXY POWDER COATING
SEMI GLOSS SMOOTH
ZINC RICH PRIMER

STOCK
Rev.: 5/2/13

RoHS Compliant

POWDER PROPERTIES

SPECIFIC GRAVITY: 2.90 CALCULATED
COVERAGE: 33.16 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: 2.0 to 2.5 mils

TEST	METHOD	RANGE
GLOSS @ 60 DEGREES:	D523	60% +/-7%
DIRECT IMPACT(INCH LBS.):	D2794	120 + in.lbs.
INDIRECT IMPACT (INCH LBS.):	D2794	120 + in.lbs
PENCIL HARDNESS:	D3363	2H +
CROSS HATCH ADHESION:	D3359B	4B +
FLEXIBILITY(CONICAL MANDRELL):	D1737/D522	90%

CHEMICAL AND CORROSION EXPOSURE TESTS

SALT SPRAY RESISTANCE: 4000 + hours (ASTM Method B117) with < 1/8 in. creep from scribe.
HUMIDITY RESISTANCE: 4000 + hours (ASTM Method D2247) no loss of adhesion or blistering.
CHEMICAL RESISTANCE: Good to excellent resistance to most solvents, oils, acids, and alkalis.

All tests were performed on 24 gauge Bonderite 1000 panels

APPLICATION

This product was designed to be applied by electrostatic spray, on steel or galvanized steel.
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.

This product is designed for use as a primer for enhanced corrosion protection of steel. **This product is not for use on aluminum substrates.** The primer coated parts should be heated only long enough to allow the coating to flow and form a continuous glossy film. The topcoat should then be applied and cured according to cure recommendations of the topcoat. This procedure must be followed to ensure adhesion between the primer and topcoat, which must be evaluated prior to use.

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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