



Product Data Guide

Group: Polyester Metallic

Prismatic Powders™ · A division of NIC Industries, Inc. 7050 Sixth Street, White City, OR 97503 USA
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GROUP: POLYESTER METALLIC

CONTROL # PMS, PMB, P-0000 Series, P-4000 Series

DESCRIPTION: Smooth single tone heavy or light metallic color.
(Thermosetting Powder Coating). Illusion colors activated with topcoat.

Note: This product can vary between lot numbers, various KV settings, mil thickness, and oven temperatures. *Always run a test prior to starting any production with these products!*
Proper application will be aided with the use of an air fluidized hopper to ensure proper metallic suspension.

POWDER CHARACTERISTICS:

Powder type -	Polyester
Specific gravity -	1.0 to 2.5 (Depends on metallic content)
Suggested KV setting -	45

CURED FILM CHARACTERISTICS:

Tested at 2.0 to 3.0 mils on a 3x5 QC panel (CRS panel): **12 min. @ 400° F**
Note: Full cure time depends on thickness of substrate!

“CURE TIME STARTS WHEN PART METAL IS AT TEMP”

GLOSS -	60% - 90%
FORWARD IMPACT -	160 in/lbs
REVERSE IMPACT -	160 in/lbs
PENCIL HARDNESS -	H - 2H
ULTRA VIOLET -	Stable

*Fluorescent, Transparent and Candy colors may have limited UV stability.
(Recommend top coat on all-metallic silvers & golds to help prevent oxidation)

SALT SPRAY (ASTM-G85) -	1,000 hrs
HUMIDITY: (ASTM-D2247) -	1,000 hrs

RECOMMENDED STORAGE / SHELF LIFE:

Temperature: (Store in cool dry environment)	Less than 70° F
Time:	6 to 8 months

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