



# Product Data Guide

## Group: Polyester – Wrinkle

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### GROUP: POLYESTER – WRINKLE

#### CONTROL # PWS, PWB, P-9000 Series

**Note:** These products may show variances in color and metallic density due to mil thickness, oven temp., and KV setting. *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.

**DESCRIPTION:** Wrinkle texture finish (Thermosetting Powder Coating).

#### POWDER CHARACTERISTICS:

Powder type: -	Polyester
Specific gravity -	1.6
Suggested KV setting -	45

#### CURED FILM CHARACTERISTICS:

Tested at 2.0 to 3.0 mils on a 3x5 QC panel (CRS panel): 20 min. @ 400° F

**Note:** Full cure time depends on thickness of substrate!

“CURE TIME STARTS WHEN PART METAL IS AT TEMP”

GLOSS -	10% +
FORWARD IMPACT -	160 in/lbs
REVERSE IMPACT -	160 in/lbs
PENCIL HARDNESS -	H
ULTRA VIOLET -	Stable

#### FAQ’S AND TECH:

Wrinkle powders may blister around welded areas on projects with sealed tubes, i.e. fencing, railing, gates, etc. The inherent properties that form a wrinkle finish, cross-link slow during the cure cycle, which can allow gas to be trapped. Drilling vent holes will help minimize this effect. If venting is not feasible, powder other than a wrinkle should be considered.

#### RECOMMENDED STORAGE / SHELF LIFE:

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

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