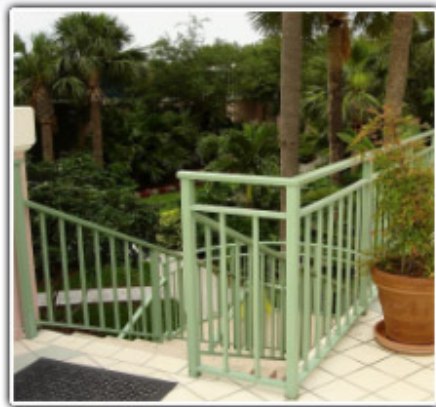


Architectural Grade Standard Polyester

A.P. Grade - Architectural Grade Standard Polyester Powder Coatings are formulated to meet or exceed the AAMA 2603-02 Voluntary Specifications. They provide substrate protection with the toughness of powder coatings while also bringing the aesthetics of color to your project. These coatings are also suitable for a same venue interior or lower demand applications while conveniently color matching the A.S.D. Grade, and Fluoro Guard™ .



Storage Stability:

The maximum storage temperature for this coating is 75°F at 50% Relative Humidity. Under these conditions, a shelf life of 12 months is expected.

Metal Preparation and Pretreatment:

A multi stage cleaning and pretreatment system is required to prepare the aluminum substrate. A properly operating pretreat system will remove organic and inorganic surface soils, remove residual oxides, and apply a chemical conversion coating to which organic coatings will adhere. Pretreat chemical conversion solutions and rinses should utilize high purity water, and may be of chrome containing conversion, or non-chrome conversion chemistries. Applicator pretreat solutions and processes must comply with the chemical supplier's procedures and guidelines. Frequent in-plant testing and control of pretreatment is required to insure satisfactory performance of the coating system.

Application:

A.P. Grade Powder Coatings are designed for application by electrostatic spray – manual or automatic. Reclaim is acceptable, provided there is no incident of cross-contamination. Reclaimed coatings which contain special effect micas should be evaluated for consistency. When applying the A.P. Grade Powder Coatings, some experimentation is typical with regard to gun kV settings and air velocities to maximize transfer efficiency and achieve a consistent coating thickness. Curing by means of gas fired convection oven with proper exhausting is the industry norm. Oven profiling is required to evaluate the cure process.

Precautions:

All dusts are respiratory irritants. The coating area must be properly ventilated. If skin contact occurs, wash with mild, soapy water. If eye contact occurs, flush with water immediately and secure medical attention. Dust clouds of any finely divided organic material can be ignited by electrical sparks or open flames. All equipment must be electrically grounded to preclude buildup of static electricity. Ensure adequate oven ventilation when curing this product. See MSDS for further precautions.

A.P. Grade Physical Properties and Tests:

Specific Gravity:	1.45 to 1.78 g/cm ³ varies by color	
Cure Schedule, Peak Metal temperature:	15 to 25 minutes at 400 degrees F	
	20 to 40 minutes at 380 degrees F	
Film Thickness:	2.5 to 4.0 mils, with no measurement below 1.8 mils	
Specular Gloss Values:	25 to 85 Using a 60 degree gloss meter per ASTM D 523	
Dry Film hardness	AAMA 2603-02, 6.3	Pass, no rupture of film
Film Adhesion:	AAMA 2603-02, 6.4 6.4.1.1 Dry Adhesion	Pass, no removal of film
	6.4.1.2 Wet Adhesion	Pass, no removal of film
Impact Resistance:	AAMA 2603-02, 6.5	Pass, no removal of film
Chemical Resistance:	AAMA 2603-02, 6.6 6.6.1 Muriatic Acid Resistance	Pass
	6.6.2 Mortar Resistance	Pass
	6.6.3 Nitric Acid Resistance	Pass
	6.6.4 Detergent resistance	Pass
	6.6.5 Window Cleaner resistance	Pass
Corrosion Resistance:	AAMA 2604-02, 6.7 6.7.1 Humidity Resistance, 2,500 hrs	Pass
	6.7.2 Salt Spray Resistance, 2,500 hrs	Pass
Weathering:	AAMA 2603-02, 6.8	Pass

Disclaimer:

We urge you to consult with Crosslink and to perform your own tests to determine the suitability of this product for your particular purposes. The information contained herein is to the best of our knowledge, and is not intended to be exhaustive. It is intended to inform users of the general criteria regarding this coating. We have no control over either the quality or condition of the substrate, the processes of pretreat, application, or curing, or the many factors affecting the use, application or final installed environment of the coated product. We make no guarantee of results, and assume no liability for damages incurred by following these suggestions, or for misuse. We do not accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising out of the use of the product. Any product liability shall be incurred in writing only. The information contained in this sheet is subject to modification from time to time due to experience and continuous product development.