

DRAWN DATE
GJL 11-18-99

EO REV
991888 A



OTTAWA TRUCK
415 EAST DUNDEE
OTTAWA, KANSAS 66067
PHONE (785) 242-2200

SHEET
1 OF 1

APPROVED

ENGINEERING SPECIFICATIONS OR INSTRUCTIONS

ESN-0030

POWDER PAINT SPECIFICATION

TECHNICAL DATA

REFERENCE - LILLY INDUSTRIES PRODUCT CODE 3100

POWDER TYPE - TGIC POLYESTER

POWDER CHARACTERISTICS

GEL TIME(350°F) - 120-160

SPECIFIC GRAVITY (± 0.05) - 1.30

THEORETICAL COVERAGE (FT²/LB) @ 1 MIL - 148

FILM PERFORMANCE

TEST PERFORMED AT 1.5-2.0 MILS ON 0.032" CRS CURED 10 MINUTES AT 400°F

GLOSS (60°F) - 90 MIN.

REVERSE IMPACT (IN-LBS) - P60

DIRECT IMPACT (IN-LBS) - P60

FLEXIBILITY (180°F) - P 1/4"

ADDITIONAL REQUIREMENTS

COLOR TO BE DETERMINED BY CONTRACT

PAINT THICKNESS ON FINISHED PARTS - 1.5-2.0 MILS

CURED POWDER TO BE COMPATIBLE WITH THE DUPONT IMRON 5000
PAINT SYSTEM.

PAINT TO BE APPLIED IN ACCORDANCE WITH MANUFACTURER'S
RECOMMENDED PROCEDURE.

ESN-0030 PG 1 OF 1