

### General Description

A functionalized polyethylene co-polyester based thermoplastic powder coating designed for maximum mechanical performance, impact resistance and UV-stability. N60 is a good general purpose protective coating.

### Surface Preparation

Chemical Pretreatment - Multi-stage phosphate conversion coating may be used

Mechanical Preparation - (SSPC-SP6) 2-3 mil (50-75µm) anchor profile using clean, sharp edged blast media

*NOTE: Properly preparing parts before powder coating is essential for a quality finish. This includes cleaning, rinsing, drying and ensuring the substrate surface is free and clear of any contaminants.*

### Fluidized Bed

For fluidized-bed dipping, preheat parts to 400° F (205°C) adjusting for part thickness. Dip parts in fluidized-bed of N60 for 4-6 seconds. Carefully remove excess powder. Post-bake at 400-450°F (200-230°C) for 5 to 10 minutes depending on metal thickness, or until desired flow out is achieved.

### Electrostatic Deposition

N60 can be applied via electrostatic deposition with or without pre-heat. When not using pre-heat, the powder should be applied to achieve a thickness of 8 – 10mils (203 - 254µm). Recommended voltage setting when using Corona equipment is 40 – 60 kv. Post-bake at 400-450°F (200-230°C) for 5 to 10 minutes depending on metal thickness, or until desired flow out is achieved. For pre-heated parts, the recommended preheat temperature is 400°F (205°C). Deposit N60 8-12mils (203 – 300µm) or higher if desired. For improved surface finish, parts may be post-baked for a short period of time if necessary. Times and temperatures in the oven will depend on configuration and thickness of the part.

### No Cure Time

Thermoplastic powder coatings need only be heated enough to flow out the coating, nothing more. Overheating may cause degradation or embrittlement of the coating. Coating may be put into service when cooled.

Powder Properties	
Coverage (100% efficiency)	25.65 ft <sup>2</sup> per pound @ 8mils (5.24 m <sup>2</sup> per kg @ 203µm)
Particle Size	Available in fluid bed and spray grades
VOC Content	ZERO
Thickness (Recommended)	8 – 10mils (203 – 254µm)
Storage Stability	Store in dry area below 90 F (32°C), keep container closed with liners sealed and out of direct sunlight and any moisture or external contaminants. Always use good manufacturing practices.

Performance Properties		
Specific Gravity	ASTM D 792	0.9414g/cm <sup>3</sup>
Adhesion	ASTM D 4541	>600psi (7MPa)
Hardness Shore D	ASTM D 2240	50
Tensile Strength	ASTM D 638	1573 psi (24MPa)
Elongation (%)	ASTM D 638	67%
Melt Index	ASTM D 1238	25
Taber Abrasion	ASTM D 4060	50-60 mg loss, CS 17 wheel
Flexibility (Conical Mandrel Bend)	ASTM D 522	1/8in (3.2mm), no cracks (>32%)
Gloss	ASTM D 523	25-30 (Depending on color choice)
Salt Spray	ASTM B 117	240 hrs. No lifting of coating from substrate (scribed)

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