



Product Data Guide

Group: Urethane – Top-Coats

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GROUP: URETHANE – Top-Coats

CONTROL# UPS, UPB, U-5000 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: Transparent top coat – clear, clear w/metallic, candy, candy w/metallic, thermosetting powder coating. **NOTE:** *Transparent colors will vary depending on their substrate or base coat color. Use a silver or “chrome like” base coat to achieve the standard transparent color.*

POWDER CHARACTERISTICS:

Powder type -	Urethane/ Top Coat
Specific gravity -	1.2 to 1.5
Suggested KV setting -	45 or less if top coating over basecoat

CURE TIME & TEMP:

10 min. @ 400° F

“CURE TIME STARTS WHEN PART METAL IS AT TEMP”

Testing done at 1.8 to 2.8 mils on a 3x5 QC panel (CRS panel)

Remember base coats act as an insulator – adjust and extend cure times as needed.

For thick substrates: 3 to 4 min @ 400° then drop to as low as 350° F – extended cure time for a full cure. Expanded application guides available by request.

CURED FILM CHARACTERISTICS:

GLOSS -	20% to 100 +%
FORWARD IMPACT -	160 in/lbs
REVERSE IMPACT -	160 in/lbs
PENCIL HARDNESS -	2H - 3H
ULTRA VIOLET -	Stable

*Fluorescent, Transparent and Candy colors may have limited UV stability.

RECOMMENDED STORAGE / SHELF LIFE:

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

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