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PRODUCT CODE:	2578G20003	**DATE:**	July 2, 2014
DESCRIPTION:	Green Polyester Backer	**CUSTOMER:**	American Construction Metals
CUSTOMER CODE:		**LOCATION(S):**	1600 Park Avenue
PRODUCT TYPE:	Thermosetting Polyester		Beloit, WI 53511
INTENDED USE:	Backer		

COATING PROPERTIES

WEIGHT SOLIDS:		**COVERAGE:**	
VOLUME SOLIDS:		**VOC:**	
WEIGHT/GALLON:		**FLASH POINT:**	95 $^\circ$F
VISCOSITY:	20-24 Seconds #4 Zahn @ 77 $^\circ$F	**CONTAINS LUBE?:**	Yes ☐ No ☒
	Seconds #4 Ford @ $^\circ$F	**LEAD CONTENT:**	Less than 0.06%

SHELF LIFE: 6 Months at 70-80 F.   Material older than this should be tested before use.

APPLICATION PROPERTIES

SUBSTRATE:	Aluminum	**CURE SCHEDULE:**	
PRETREATMENT:	Bonderite 1402W	**LINE PMT RANGE:**	450-465 $^\circ$F
PRIMER:	None	**TYPICAL LAB BAKE:**	25-30 Seconds at 450 $^\circ$F PMT
DRY FILM THICKNESS:			
TOPCOAT:	0.15-0.20 mils	**TOPCOAT WET FILM :**	
PRIMER:	N/A mils	**REDUCTION:** 1.	Aromatic 150
TOTAL:	0.15-0.20 mils	2.	Butyl Cellosolve

PHYSICAL CONSTANT

GLOSS:	20-30 @ 60 Degrees
SOLVENT RESISTANCE:	30 Double Rubs with MEK
PENCIL HARDNESS:	F-2H
FLEXIBILITY:	0-2T No Tape Off On 0.019 Aluminum (Varies w/ metal thickness)
REVERSE IMPACT:	1.5X Metal Thickness
OTHER SPECIFICATIONS:	

SPECIAL INSTRUCTIONS:

Initial Issue: (mah)

NOT COLOR CONTROLLED

SUBMITTED BY: _____   **APPROVAL:** _____