



## TECHNICAL INFORMATION

### POWDURA® HYBRID POWDER COATING

#### PRODUCT DESCRIPTION

##### HB2-C2621

##### Low Gloss Texture Black

**POWDURA® Hybrid Powder Coatings** are recommended for a broad range of interior functional and decorative applications.

##### Advantages:

- Excellent application properties
- Very good overbake resistance
- Wide arrange of colors and textures available
- Very good chemical resistance

Many applications, including:

Tools  
Hot water heaters  
Office furniture  
Shelving  
Toys  
Oil filters  
Electronic enclosures

**Storage:** Powdura® Powder Coatings should be kept in a dry and cool area at temperatures below 80°F (27°C). When not in use, store powder in sealed containers: fine powders are hygroscopic.

**Substrate Preparation:** Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface preparation treatments to ensure optimum adhesion and coating performance properties. The use of a chemical conversion coating prior to the application of a powder coating is strongly recommended.

**Testing:** Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full-scale application.

#### CAUTIONS

Thoroughly review product SDS prior to using this product. Please consult your local sales representative or your local Sherwin-Williams facility for additional information.

Not recommended for exterior applications where color and gloss retention are required.

**Special Advisory:** River texture type finishes are unique finishes that may vary with application, film thickness and cure conditions. Light colors and very dark colors may occasionally show colored specks that appear as contamination.

This is the nature of this type of finish and cannot be predicted or controlled. Thorough cleaning is required when switching to a normal smooth powder coating to prevent craters in the smooth finish.

#### APPLICATION

All testing was performed on clean panels with appropriate pretreatment. Proper pretreatment will enhance performance of this product.

**Cure Schedule:** 10 MIN @ 200 C (390F)

**Film Thickness Range(mils):** 2.0-3.0

#### ATTRIBUTES

**Specific Gravity(g/ml):** 1.43

**Coverage at 1.0 Mil(ft<sup>2</sup>/lb):** 134.9

**60° Gloss:** 10-15  
(ASTM D-523)

**Adhesion:** 5B  
(ASTM D-3359)

**Flexibility:** Pass 1/8"  
(ASTM D-522)

**Pencil Hardness:** 2H  
(ASTM D-3363)

**Impact Resistance(in.lb):** Dir 80 in-lbs  
(ASTM D-2794) Rev 80 in-lbs

**Humidity(ASTM D-4585)**  
-slight gloss and color change  
600 hours

**SaltSpray(ASTM B-117)**  
max 1/8" Creepage  
600 hours

**Note:** Performance measured using  
24-gauge Bonderite® 1000 test panels.

**Shelf Life:** 12 Months

Sherwin-Williams recommends that all material be used in FIFO order ( first in - first out). Materials that exceed the recommended shelf life should be tested prior to use.

##### Note:

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating and opinions stated above pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application, which are not known, or under our control, The Sherwin-Williams Company cannot make any warranties or guaranties as to the end results.

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