



Product Data Guide

Group: Epoxy - Wrinkle

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GROUP: EPOXY – WRINKLE

CONTROL # EWS, EWB, E-9000 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: Wrinkle texture finish (Thermosetting Powder Coating).

POWDER CHARACTERISTICS:

Powder type -	Epoxy
Specific gravity -	1.6
Suggested KV setting -	45

CURED FILM CHARACTERISTICS:

Tested at 2.5 to 3.5 mils on a 3x5 QC panel (CRS panel): **15 min. @ 350° F**
For a more uniform appearance, parts should enter the oven at 150° F – then ramp up to 350° F then time to full cure.
Note: Full cure time depends on thickness of substrate!!

GLOSS -	10% +
FORWARD IMPACT -	60 in/lbs
REVERSE IMPACT -	60 in/lbs
PENCIL HARDNESS -	H
ULTRA VIOLET -	Non-stable

FAQ’S AND TECH:

Wrinkle powders may blister around welded areas on projects with sealed tubes, i.e. fencing, railing, gates, etc. The inherent properties that form a wrinkle finish, cross- link slow during the cure cycle, which can allow gas to be trapped. Drilling vent holes will help minimize this effect. If venting is not feasible, powder other than a wrinkle should be considered.

RECOMMENDED STORAGE / SHELF LIFE:

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

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