



Product Finishes

TECHNICAL INFORMATION POWDURA® SUPER DURABLE POLYESTER TGIC POWDER COATING

DBS6-20001 MG BLACK DBS6-20D01

DBS6-20001 is a medium gloss polyester designed to meet the stringent requirements of the agricultural and construction industry. It provides very good corrosion protection, chemical resistance, excellent outdoor durability, and overall good physical properties.

It is designed to meet the requirements of Caterpillar specification 1E1952H and the guidelines of UL 1332.

- Free of chromate hazards
- Free of lead hazards, as packaged, in compliance with Consumer Product Safety Commission's (CPSC) 16 DFR Chapter II: Subchapter B, part 1303.

Advantages:

- Meets Caterpillar 1E1950H specification.
- Meets Caterpillar 1E1952 when applied over a 1E1850 approved powder or E-coat Primer.
(To verify CAT approval refer to the active 1E1850 specification).
- DBS6-20001 is UL 1332 approved and the DBS6-20D01 designates this approval.
- Application characteristics allow film builds to meet 1E2001 requirements.
- Excellent hardness, impacts, and abrasion resistance

APPLICATION

Powder coatings must be applied using suitable electrostatic equipment. Consult your Sherwin-Williams Representative regarding unique applications.

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.

For aluminum a minimum of a 5-stage chrome phosphate metal treatment, or equivalent, is required for good adhesion and optimum coating performance properties.

Consult Metal Preparation Brochure CC-T1 for additional details.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full-scale application. The properties listed are typical and should not be construed as the actual specification.

Storage: POWDURA® Powder Coatings should be kept in a dry and cool area at temperatures below 80°F (27°C) and with a relative humidity around 50-60%. Shelf life is approximately 12 months. When not in use, store powder in sealed containers: fine powders are hygroscopic.

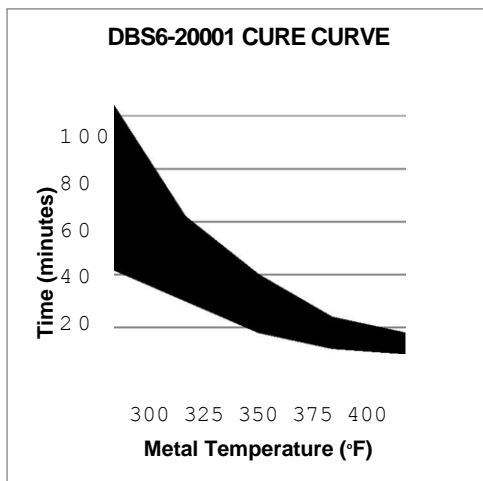
Product Limitations:

- Contact your Sherwin-Williams Representative where use of this product at higher than recommended film thickness may be required.

Due to continuously evolving requirements of Caterpillar specifications, always verify approval status prior to product introduction at potential customers. To determine the most current level of approval consult Caterpillar's active 1E1850 specification document or your local SW Product Finishes representative.

ATTRIBUTES

Cure Schedule 10 min @ 400 °F



Over-Bake Properties: 100% time

Primer

DFT Minimum: 1.5 mils (0.038 mm)
DFT Maximum: 1.8 mils (0.045 mm)

Primer/Topcoat System

DFT Minimum: 2.9 mils (0.075 mm)
DFT Maximum Primer: 3.5 mils (0.090 mm)

Specific Gravity 1.35 (g/ml)

Spreading Rate
(no application loss) 0.74 m²/kg/mm DFT

60° Gloss 55-65
(ASTM D-523)

Adhesion Pass 5B
(ASTM D-3359)

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

Pencil Hardness: 4H
(ASTM D-3363)

Orange Peel 7-8
PCI Standards

Shelf Life: 12 Months

Air Quality Data: Non-photochemically reactive

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. Please direct any questions or comments to your local Sherwin-Williams facility.

CAUTION! Causes eye irritation, causes skin irritation, may cause allergic skin reaction, respiratory irritant, dust may cause eye and respiratory irritation, dust may form an explosive mixture in air. Avoid breathing dust. Avoid contact with eyes and prolonged or repeated contact with skin. Use protective clothing and NIOSH approved respirator. Do not use near sparks or open flame or any type of ignition source. Wash thoroughly after handling. Use only with adequate ventilation.

FIRST AID:

If on SKIN: Wash thoroughly with soap and water.

If in EYES: Flush with water immediately and procure medical attention. The area adjacent to the coating operation should be properly ventilated. Cure ovens must be exhausted to the outside atmosphere. All dusts are respiratory irritants; inhalation of the dust should be avoided. To avoid static electricity build-up, properly ground all equipment. Provide dust collection equipment with adequate explosion venting; dust clouds of any finely divided organic material can be ignited by open flame or electrical sparks.

**DO NOT TAKE INTERNALLY.
KEEP OUT OF REACH OF CHILDREN.
FOR INDUSTRIAL USE ONLY.**

REFER TO MATERIAL SAFETY DATA SHEET FOR ADDITIONAL INFORMATION.

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.

Rockford, Illinois
December 22, 2015