



Encase® G35

General Description

Encase® is a low density polyethylene (LDPE) based powder coating designed for encapsulation coating of wire goods.

Application & Surface Preparation

Chemical Pretreatment - Multi-stage phosphate conversion coating may be used

Mechanical Preparation - (SSPC-SP6) 2-3 mil (50-75µm) anchor profile using clean, sharp edged blast media

NOTE: Properly preparing parts before powder coating is essential for a quality finish. This includes cleaning, rinsing, drying and insuring that the substrate surface is free and clear of any contaminants.

Fluidized Bed

For fluidized-bed dipping, preheat parts to 400° F (205°C) adjusting for part thickness. Dip parts in fluidized-bed of Encase® G35 for 4-6 seconds. Carefully blow off excess powder. For improved surface finish (if necessary), parts may be post-baked for a short period of time.

Electrostatic Deposition

Encase® G35 can be applied via electrostatic deposition with or without pre-heat. When not using pre-heat, the powder should be applied to achieve a thickness of 8 – 10mils (203 - 254µm). Recommended voltage setting when using Corona equipment is 40 – 60 kv. Post-baking at 350 - 425°F (175 - 220°C) for 5 to 10 minutes depending on metal thickness, or until desired flow out is achieved. For pre-heated parts, the recommended preheat temperature is 400°F (205°C). Deposit Encase® G35 8-12mils (203 – 300µm) or higher if desired. For improved surface finish, parts may be post-baked for a short period of time if necessary. Times and temperatures in the oven will depend on configuration and thickness of the part.

No Cure Time

Thermoplastic powder coatings need only be heated enough to flow out the coating, nothing more. Overheating may cause degradation or embrittlement of the coating. Coating may be put into service when cooled.

Powder Properties	
Polymer Type	Low Density Polyethylene (LDPE)
Particle Size	Suitable for fluid bed & spray grade applications
VOC Content	ZERO
Thickness (Recommended)	8 – 30mils (203 - 750µm)
Storage Stability	Store in dry area below 90° F (32°C), keep container closed with liners sealed and out of direct sunlight and any moisture or external contaminants. Always use good manufacturing practices.

Performance Properties		
Specific Gravity	ASTM D 792	0.926 g/cm ³
Hardness	ASTM D 2240	55
Vicat Softening Point	ASTM D 1525	208°F (97°C)
QUV	ASTM G 53	Not UV Stable
Taber Abrasion	ASTM D 4060	29 mg loss, CS 17 wheel
Salt Fog (1,000 hours unscribed)	ASTM B 117	No Blistering
Melt Index	ASTM D 123	30
Gloss Retention	ASTM B 523	2.7% Loss
Freeze / Thaw	IPC FT-1	No effects, 10 Cycles

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