



Powder Coating Process Recommendations:

Date: 4/12/18

MNDOT/Cardinal Paint and Powder: Galvanized Structural Steel

Cardinal recommends that all galvanized structural steel be prepared to MNDOT specifications prior to powder coat application.

Primer Powder H304-GR312 should be applied at 3 to 5 mils DFT, Primer should be cured no less than 80% prior to topcoat application. See Cardinal tech data sheet for temperature requirements.

Top Coat Super durable powders, should be applied at 3 to 5 mils DFT, top coat should be cured no less than 100% to temp stated on Cardinal tech data sheet.

From any tech service requests please contact your local Cardinal Sales Person.

Best Regards,

Robert Weeks

Midwest Sales Manager

Cardinal Paint and Powder

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