



## Technical Data Sheet

### RAL 1019 Gray Beige PLSF 40092

**Description:** Thermosetting polyester tgc powder coating. Polyester tgc's are designed for interior or exterior applications.

**Typical Applications:** General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.

<b>Typical Physical Properties:</b>	Film Thickness	1.7 - 3.0+ mil
	Gloss 60'angle (ASTM D-523-89)	85+
	Hardness (ASTM D-3363-92A)	H - 2H
	Flexibility (ASTM D-1737-89)	1/16 inch
	Adhesion (ASTM D-3359-95A)	5b (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	160 in-lbs
	Exterior Durability	Very Good
	Chemical Resistance	Good
	Salt Spray (ASTM B117)	1000 Hrs < 1/8'
	Specific Gravity (calculated)	1.45+/-0.05

**Application Data:** Polyester tgc's are to be applied with a corona electrostatic powder spray gun at between 60kv - 100 kv.

**Cure Schedule:** Polyester tgc's can be cured in a direct or indirect gas convection oven, an electric oven, or an Infra red. A combination of any of these ovens is also suitable.

**Standard Cure:** 10 Minutes @ 340<sup>o</sup>f Peak Metal Temperature

**Storage:** Product should be stored at temperatures below 80<sup>o</sup>f, in a dry area away from any heat source.

**Notes:** All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils.  
Please refer to the MSDS for safety information.

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