



Technical Data Sheet

RAL 1004 Golden Yellow PLSF 50073

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| Description: | Thermosetting polyester TGIC powder coating. Polyester TGIC's are designed for interior or exterior applications. | |
| Typical Applications: | General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc. | |
| Typical Physical Properties: | Film Thickness | 2.0 – 4.0 mil |
| | Gloss 60°angle (ASTM D-523-89) | 80+ |
| | Hardness (ASTM D-3363-92A) | H – 2H |
| | Flexibility (ASTM D-1737-89) | 1/8 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) | 1.62+/-0.05 |
| Application Data: | Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv. | |
| Cure Schedule: | Polyester TGIC'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°F Peak Metal Temperature | |
| Storage: | Product should be stored at temperatures below 80°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. | |

Any recommendations contained herein or any information given by any IFS COATINGS representative is based on tests and information believed to be accurate. However, since we have no control over the conditions under which our products are transported, stored, handled, or used by purchasers, all recommendations and sales

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