



Technical Data Sheet

RAL 3009 Oxide Red PLSF 60083

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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 | 1.7 + mil |
| | Gloss 60°angle (ASTM D-523-89) | 80+ |
| | 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) | 1.40 |
| 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 ⁰ 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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