



Technical Data Sheet

Ral 2010 Signal Orange PLSF 60130

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	2.5 + 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)	1.33+/-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.		
	<u>Standard Cure:</u> 10 Minutes @ 340 ⁰ 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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