



## Technical Data Sheet

### Ral 2003 Pastel Orange PLSF 60333

<b>Description:</b>	Thermosetting polyester TGIC powder coating. Polyester TGIC's are designed for interior or exterior applications.	
<b>Typical Applications:</b>	General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.	
<b>Typical Physical Properties:</b>	<b>Film Thickness</b>	2.5 + mil
	<b>Gloss 60° angle (ASTM D-523-89)</b>	80+
	<b>Hardness (ASTM D-3363-92A)</b>	H – 2H
	<b>Flexibility (ASTM D-1737-89)</b>	1/8 inch
	<b>Adhesion (ASTM D-3359-95A)</b>	5b (100%)
	<b>Impact Direct/Indirect (ASTM D-2794-93)</b>	160 in-lbs
	<b>Exterior Durability</b>	Very Good
	<b>Chemical Resistance</b>	Good
	<b>Salt Spray (ASTM B117)</b>	1000 Hrs < 1/8'
	<b>Specific Gravity (calculated)</b>	1.34+/-0.05
<b>Application Data:</b>	Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.	
<b>Cure Schedule:</b>	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.  <b><u>Standard Cure:</u></b> 10 Minutes @ 340°f Peak Metal Temperature	
<b>Storage:</b>	Product should be stored at temperatures below 80°f, in a dry area away from any heat source.	
<b>Notes:</b>	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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