Technical Data Sheet

Ral 5012 Light Blue
PLSF 20009

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	**1.4 + 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)	**1.44+/-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^{o}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.