



Technical Data Sheet

Ral 8004 Copper Brown PLSF 40228

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)	1.48
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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