



Technical Data Sheet

Ral 7004 Signal Gray PLSF 70175

Description:	<i>PLSF70175, Ral 7004 Signal Gray</i> is thermosetting, low cure polyester TGIC powder coating and is 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	2.0-3.0 mil
	Gloss 60°angle (ASTM D-523-89)	80-90
	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)	160/160 in-lbs
	Exterior Durability	Very Good
	Chemical Resistance	Good
	Salt Spray (ASTM B117)	1000 hrs, <3 mm creepage
	Specific Gravity (calculated)	1.62±0.02
Application Data:	<i>PLSF70175, Ral 7004 Signal Gray</i> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	<i>PLSF70175, Ral 7004 Signal Gray</i> can be cured in a direct or indirect gas convection oven, an electric oven, or an Infrared. 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°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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