Technical Bulletin

PLSF 10001
RAL 9005 Gloss Black

Description:

PLSF 10001, RAL 9005 Gloss Black is a thermosetting Polyester-TGIC powder coating and designed for interior or exterior applications.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.40±0.05
	Theoretical Coverage	137 sq.ft/lb./mil
	Shelf life (at below 80°F in 50% humidity)	18 months
Typical Physical Properties:	Film Thickness	2.0-3.0 mil
	Gloss 60'angle (ASTM D-523-89)	90-95
	Hardness (ASTM D-3363-92A)	2H-3H
	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.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
	UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.)	Recognized *
	Exterior Exposure* (1 Yr.; ASTM D2244, ASTM D4214)	30% GR, ΔE:≤5.0
	*45° South Florida	

Application Data:

PLSF 10001, RAL 9005 Gloss Black is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule:

PLSF 10001, RAL 9005 Gloss Black 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:

PLSF 10001, RAL 9005 Gloss Black should be stored at temperatures below 80°F, in a dry area away from any heat source.

Notes:

All tests were performed on B-1000 panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

*5 stage Phosphate pre-treated steel

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