



## Technical Bulletin

### RAL 5021 WATER BLUE PLSF 20038

**Description:** This product is a polyester TGIC powder coating, designed for interior or exterior applications.

**Typical Applications:** General industrial finishing.

|                                     |                                         |                 |
|-------------------------------------|-----------------------------------------|-----------------|
| <b>Typical Physical Properties:</b> | Film Thickness                          | 1.4+ mil        |
|                                     | Gloss 60°angle (ASTM D-523-89)          | 80+             |
|                                     | 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  |
|                                     | Salt Spray (ASTM B117)                  | 1000 Hrs < 1/8' |
|                                     | Specific Gravity (calculated)           | 1.52 +/- 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 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 SDS for safety information.

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