



Technical Bulletin

RAL 6011 RESEDA GREEN PLSF 30261

Description:	This product is a polyester TGIC powder coating, designed for interior or exterior applications.		
Typical Applications:	General industrial finishing.		
Typical Physical Properties:	Film Thickness	2.0 + 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)	1.64 +/- 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.		
	<u>Standard Cure:</u> 10 Minutes @ 340ºf Peak Metal Temperature		
Storage:	Product should be stored at temperatures below 80ºf, 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.		

Any recommendations contained herein or any information given by any IFS COATINGS representative is based on tests and information believed to be accurate. However, since we have no control over the conditions under which our products are transported, stored, handled, or used by purchasers, all recommendations and sales are made on condition that IFS COATINGS will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.