



## Technical Bulletin

### PLSF 40089 Ral 8016 Mahogany Brown

**Description:** *PLSF 40089, Ral 8016 Mahogany Brown* is a Polyester-TGIC Powder coating designed for interior or exterior applications.

|                                  |                                             |                   |
|----------------------------------|---------------------------------------------|-------------------|
| <b>Typical Powder Properties</b> | Specific Gravity (ASTM D5965-96, C)         | 1.56±0.05         |
|                                  | Theoretical Coverage                        | 123 sq.ft/lb./mil |
|                                  | Shelf life (at below 80°F in dry condition) | 12 months         |

|                                     |                                                         |                     |
|-------------------------------------|---------------------------------------------------------|---------------------|
| <b>Typical Physical Properties:</b> | Film Thickness                                          | 2.0-3.0 mils        |
|                                     | 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., Bonderite 1000 panel) | Rating 7 (Creepage) |

**Application Data:** *PLSF 40089, Ral 8016 Mahogany Brown* can be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV or fluidized bed.

**Cure Schedule:** *PLSF 40089, Ral 8016 Mahogany Brown* 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.

**Std. Cure:** 10 minutes @ 340°F Peak Metal Temperature

**Storage:** *PLSF 40089, Ral 8016 Mahogany Brown* 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 iron phosphated panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

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