



Technical Bulletin

RAL 1000 Green Beige PLSF 40705

Description:	Thermosetting polyester TGIC powder coating designed for interior or exterior use.		
Typical Applications:	General industrial finishing.		
Typical Physical Properties:	Film Thickness		2.0-3.0+ 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)	1.49 +/- 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 @ 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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