



## Technical Bulletin

### RAL 1016 Sulfur Yellow PLSF 50031

|                                     |                                                                                                                                                                    |                 |
|-------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| <b>Description:</b>                 | Thermosetting polyester TGIC powder coating designed for interior or exterior use.                                                                                 |                 |
| <b>Typical Applications:</b>        | General industrial finishing.                                                                                                                                      |                 |
| <b>Typical Physical Properties:</b> | Film Thickness                                                                                                                                                     | 2.0-4.0+ 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)                                                                                                                                      | 1.61 +/- 0.05   |
| <b>Application Data:</b>            | Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.                                                          |                 |
| <b>Cure Schedule:</b>               | 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                                                                                                    |                 |
| <b>Storage:</b>                     | Product should be stored at temperatures below 80°F, in a dry area away from any heat source.                                                                      |                 |
| <b>Notes:</b>                       | 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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