



Technical Bulletin

PLSF 60027 RAL 3002 Carmine Red

Description: *PLSF 60027, RAL 3002 Carmine Red* is a thermosetting Polyester-TGIC powder coating and designed for exterior durability. This product is formulated to meet UL 1332 standard for organic coatings for steel enclosures for outdoor use electrical equipment.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.42±0.05
	Theoretical Coverage	135 sq.ft/lb./mil
	Shelf life (at below 80°F in 50% humidity)	18 months

Typical Physical Properties:	Film Thickness	1.8-2.5 mil
	Gloss 60°angle (ASTM D-523-89)	85-95
	Hardness (ASTM D-3363-92A)	2H-3H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	140/140 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs., Bonderite 1000 panel)	Rating 7 (creepage)

UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.) Recognized *

Application Data: *PLSF 60027, RAL 3002 Carmine Red* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PLSF 60027, RAL 3002 Carmine Red* 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 or 400°F Peak Metal Temperature

Storage: *PLSF 60027, RAL 3002 Carmine Red* 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 panels with a nominal film thickness of 1.8-3.0 mils. Please refer to the SDS for safety information.

*5 stage Phosphate pre-treated steel

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