



## Technical Bulletin

### PLSF 60041 RAL 2004 Pure Orange

|                                     |                                                                                                                                                                                           |                     |
|-------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------|
| <b>Description:</b>                 | <b>PLSF 60041, Ral 2004 Pure Orange</b> is a Polyester-TGIC Powder coating designed for interior or exterior applications.                                                                |                     |
| <b>Typical Powder Properties</b>    | Specific Gravity (ASTM D5965-96, C)                                                                                                                                                       | 1.34±0.05           |
|                                     | Theoretical Coverage                                                                                                                                                                      | 144 sq.ft/lb./mil   |
|                                     | Shelf life (at below 80°F in 50% humidity)                                                                                                                                                | 18 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)                                                                                                                                                              | 1/4 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) |
| <b>Application Data:</b>            | <b>PLSF 60041, Ral 2004 Pure Orange</b> can be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV or fluidized bed.                                            |                     |
| <b>Cure Schedule:</b>               | <b>PLSF 60041, Ral 2004 Pure Orange</b> 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. |                     |
|                                     | <b>Std. Cure:</b> 10 minutes @ 340°F Peak Metal Temperature                                                                                                                               |                     |
| <b>Storage:</b>                     | <b>PLSF 60041, Ral 2004 Pure Orange</b> 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 B-1000 iron phosphated panels with a nominal film thickness of 2.0-3.0 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.