



## Technical Bulletin

### PLSF 60143 RAL 3016 Coral Red

|                                     |                                                                                                                                                                                         |                     |
|-------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------|
| <b>Description:</b>                 | <b>PLSF 60143, Ral 3016 Coral Red</b> is a Polyester-TGIC Powder coating designed for interior or exterior applications.                                                                |                     |
| <b>Typical Powder Properties</b>    | Specific Gravity (ASTM D5965-96, C)                                                                                                                                                     | 1.45±0.05           |
|                                     | Theoretical Coverage                                                                                                                                                                    | 133 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)                                                                                                                                                            | 1/4 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 60143, Ral 3016 Coral Red</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 60143, Ral 3016 Coral Red</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 60143, Ral 3016 Coral Red</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.                                |                     |

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