



Technical Bulletin

Ral 3000 Flame Red PLSF 60251

Description:	Thermosetting polyester TGIC powder coating designed for interior or exterior use.	
Typical Applications:	General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.	
Typical Physical Properties:	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
	Exterior Durability	Very Good
	Chemical Resistance	Good
	Salt Spray (ASTM B117)	1000 Hrs < 1/8'
	Specific Gravity (calculated)	1.45+/-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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