IFS 300SP
Technical Data Sheet

PLSF 60344
RAL 4003 Heather Violet

Description:

PLSF 60344, RAL 4003 Heather Violet is thermo-setting Polyester-TGIC powder coatings and designed specifically for architectural applications and exterior durability. It is formulated with Polyester resin technology and high performance pigments to conform to the performance requirements of AAMA2603-20.

Features and Benefits:

*1+ year film integrity on properly pre-treated aluminum available
*1-2 year color retention available
*Very good flow (smooth film appearance)
*Scratch and Mar resistance powder coating (Hard wearing/serviceable finish)

Applications:

Extruded Architectural aluminum including window, Curtain wall, and door frames, Extruded panel work on commercial buildings, etc.

Typical Powder Properties:

Specific Gravity (ASTM D5965-96, C)	1.55±0.05
Theoretical Coverage	124 sq.ft/lb./mil
Shelf life (at below 80°F in dry condition)	12 months

Typical Coatings Performance:

Film Thickness (ASTM D7091)	2.0-3.0 mil
Gloss 60'angle (AAMA 2603-20, Sec. 8.2.2)	50-60
Hardness (AAMA 2603-20, Sec. 8.3.2)	H-2H
Dry Adhesion (AAMA 2603-20, Sec. 8.4.2.1)	5B (100%)
Boiling Water Adhesion (AAMA 2603-20, Sec. 8.4.2.2)	5B (100%)
Wet Adhesion (AAMA 2603-20, Sec. 8.4.2.3)	5B (100%)
Direct Impact Resistance (AAMA 2603-20, Sec. 8.5.2)	3mm±0.3 mm deform, No Coating Pick off with tape
Muriatic Acid Resistance (AAMA 2603-20, Sec. 8.6.1)	No visual change, No blistering
Mortar Resistance (AAMA 2603-20, Sec. 8.6.2)	No visual change, 5B Adhesion
Detergent Resistance (AAMA 2603-20, Sec. 8.7.3)	No color change, 5B Adhesion, and blistering
Humidity Resistance (ASTM D2247, 1500 hours)	Rating 7 (creepage) No blistering
Salt Spray Corrosion (ASTM B117, 1500 hours)	Rating 7 (creepage) Rating 8 (blistering)

Surface Preparation:

Surfaces should be prepared according to AAMA2603-20 or the recommendations of Chemical supplier as appropriate**.**

Application Data:

PLSF 60344, RAL 4003 Heather Violet is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV. For box feeders, ensure probe is fully inserted in powder and operated as manufacturer's instructions. For fluid bed applications, ensure uniform fluidization of powder in the hopper. Fluidized powder should resemble "simmering liquid". Aged or compacted powder may require pre-conditioning for several minutes to fluidize evenly.

Cure Schedule:

PLSF 60344, RAL 4003 Heather Violet 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

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also suitable. Care should be exercised when stoving at 425°F as some colors are prone to discoloration.

Standard Cure: 10 minutes @ 340°F Peak Metal Temperature

Care and Maintenance:

Reference should also be made to IFS Applicator's Manual or AAMA610-15 standard for cleaning of surfaces. This is a condition of the warranty. In broad terms, cleaning of externally located powder coating surfaces must take place every three months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

Three steps to cleaning powder coated surfaces:

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

Warning: In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes and will render the warranty void if used. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Turpentine, White Spirits, Ethyl Alcohol, and Isopropanol.

Storage:

PLSF 60344, RAL 4003 Heather Violet should be stored at temperatures below 80°F, in a dry area away from any heat source.

Health and Safety:

SDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information.
For detailed information, refer to product label and the current Chemical Data Sheet available through Sales and Customer Service Offices (Phone: 940-668-1062).

Notes:

All tests were performed on Alodine panels with a nominal film thickness of 2.5-3.0 mils.

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