



## Technical Bulletin

### PLSF 70175 RAL 7004 Signal Gray

|                                     |                                                                                                                                                                                           |                                           |
|-------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------|
| <b>Description:</b>                 | <b>PLSF 70175, RAL 7004 Signal Gray</b> is a Polyester-TGIC Powder coating designed for interior or exterior applications.                                                                |                                           |
| <b>Typical Powder Properties</b>    | Specific Gravity (ASTM D5965-96, C)                                                                                                                                                       | 1.62±0.05                                 |
|                                     | Theoretical Coverage                                                                                                                                                                      | 119 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)                                                                                                                                                              | 1/8 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 70175, RAL 7004 Signal Gray</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 70175, RAL 7004 Signal Gray</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 70175, RAL 7004 Signal Gray</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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