



# Technical Bulletin

## RAL 9011 GRAPHITE BLACK PLSF 10137

<b>Description:</b>	This product is a polyester TGIC powder coating, designed for interior or exterior applications.	
<b>Typical Applications:</b>	General industrial finishing.	
<b>Typical Physical Properties:</b>	Film Thickness	1.7-3.0+ mil
	Gloss 60°angle (ASTM D-523-89)	90+
	Hardness (ASTM D-3363-92A)	H - 2H
	Flexibility (ASTM D-1737-89)	1/16 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)	1.49 +/- 0.05
<b>Application Data:</b>	Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.	
<b>Cure Schedule:</b>	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	
<b>Storage:</b>	Product should be stored at temperatures below 80 <sup>0</sup> f, in a dry area away from any heat source.	
<b>Notes:</b>	All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.	

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