



## Technical Bulletin

### PLSF 20150 Ral 5011 Steel Blue

**Description:** *PLSF 20150, RAL 5011 Steel Blue* is a thermosetting Polyester-TGIC powder coating and is designed for exterior durability, and will meet or exceed AAMA 2603. This product has been formulated for exceptionally high gloss and flow.

**Typical  
Powder Properties**

Specific Gravity (ASTM D5965-96, C)	1.64±0.05
Theoretical Coverage	117 sq.ft/lb./mil

**Typical  
Physical Properties:**

Film Thickness	2.0-3.0 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.
Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
Salt Spray (ASTM B117, 3000 hrs, Alodine panel)	Rating 7 (creepage)

**Application Data:** *PLSF 20150, RAL 5011 Steel Blue* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

**Cure Schedule:** *PLSF 20150, RAL 5011 Steel Blue* 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.

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

**Storage:** *PLSF 20150, RAL 5011 Steel Blue* should be stored at temperatures below 80°F, in a dry area away from any heat source.

**Notes:** All tests were performed on B-1000 panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

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