



Technical Bulletin

PLSF 20274 RAL 5019 Capri Blue

Description: *PLSF 20274, RAL 5019 Capri Blue* is a Polyester-TGIC Powder coating designed for interior or exterior applications.

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| 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 |

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| Typical Physical Properties: | Film Thickness | 2.0-3.0 mils |
| | Gloss 60°angle (ASTM D-523-89) | 85+ |
| | 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) |

Application Data: *PLSF 20274, RAL 5019 Capri Blue* can be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV or fluidized bed.

Cure Schedule: *PLSF 20274, RAL 5019 Capri 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.

Std. Cure: 10 minutes @ 340°F Peak Metal Temperature

Storage: *PLSF 20274, RAL 5019 Capri 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 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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