



Technical Bulletin

PLSF 30043 RAL 6004 Blue Green

Description: *PLSF 30043, RAL 6004 Blue Green* is a thermosetting Polyester-TGIC powder coating and designed for interior and exterior durability.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.63±0.05
	Theoretical Coverage	118 sq.ft./lb./mil

Typical Physical Properties:	Film Thickness	2.5-3.0 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, 2000 hrs, Alodine panel)	Rating 7 (creepage)

Application Data: *PLSF 30043, RAL 6004 Blue Green* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PLSF 30043, RAL 6004 Blue Green* 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 30043, RAL 6004 Blue Green* should be stored at temperatures below 80°F, in a dry area away from any heat source.

Notes: All tests were performed on Bonderite 1000, Iron Phosphate panels with a nominal film thickness of 1.5-2.5 mils. Please refer to the SDS for safety information.

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