



## Technical Bulletin

### PLSF 30530 Ral 6014 Yellow Olive

**Description:** *PLSF 30530, Ral 6014 Yellow Olive* is a Polyester-TGIC Powder coating designed for interior or exterior applications.

<b>Typical Powder Properties</b>	Specific Gravity (ASTM D5965-96, C)	1.64±0.03
	Theoretical Coverage	117 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)	2H
	Flexibility (ASTM D-1737-89)	1/16 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	160/1600 in-lbs.
	Salt Spray (ASTM B117, Bonderite 1000 panel)	1500 hrs.
	Humidity (ASTM D2247, Bonderite 1000 panel)	1500 hrs.

**Application Data:** *PLSF 30530, Ral 6014 Yellow Olive* can be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV or fluidized bed.

**Cure Schedule:** *PLSF 30530, Ral 6014 Yellow Olive* 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 30530, Ral 6014 Yellow Olive* 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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