



# Technical Bulletin

## Ral 1011 Brown Beige PLSF 40245

- Description:** Thermosetting polyester TGIC powder coating designed for interior or exterior use.
- Typical Applications:** General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.
- Typical Physical Properties:**
- |   |                       |
|---|-----------------------|
| Film Thickness                          | 2.0-3.0+ mil          |
| Gloss 60°angle (ASTM D-523-89)          | 80-90                 |
| 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,3mm Creepage |
| Specific Gravity (calculated)           | 1.60+/-0.03           |
- Application Data:** Polyester TGIC's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.
- Cure Schedule:** 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.
- Standard Cure: 10 Minutes @ 340°f Peak Metal Temperature
- Storage:** Product 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 phosphated panels with a nominal film thickness of 2 mils. Please refer to the SDS for safety information.

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