



Technical Bulletin

RAL 1006 Maize Yellow PLSF 50089

Description: **PLSF 50089, RAL 1006 Maize Yellow** 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 Applications: General industrial finishing.

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|-------------------------------------|---|-----------------|
| Typical Physical Properties: | Film Thickness | 2.0-4.0+ 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 < 1/8' |
| | Specific Gravity (calculated) | 1.61 +/- 0.05 |

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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