



## Technical Bulletin

### PLSF 60027 RAL 3002 Carmine Red

**Description:** *PLSF 60027, RAL 3002 Carmine Red* is a thermosetting Polyester-TGIC powder coating and designed for exterior durability. This product is formulated to meet UL 1332 standard for organic coatings for steel enclosures for outdoor use electrical equipment.

<b>Typical Powder Properties</b>	Specific Gravity (ASTM D5965-96, C)	1.42±0.05
	Theoretical Coverage	135 sq.ft./lb./mil
	Shelf life (at below 80°F in 50% humidity)	18 months

<b>Typical Physical Properties:</b>	Film Thickness	1.8-2.5 mil
	Gloss 60°angle (ASTM D-523-89)	85-95
	Hardness (ASTM D-3363-92A)	2H-3H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	140/140 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs., Bonderite 1000 panel) UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.)	Rating 7 (creepage) Recognized *

**Application Data:** *PLSF 60027, RAL 3002 Carmine Red* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

**Cure Schedule:** *PLSF 60027, RAL 3002 Carmine Red* 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 or 400°F Peak Metal Temperature

**Storage:** *PLSF 60027, RAL 3002 Carmine Red* 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 panels with a nominal film thickness of 1.8-3.0 mils. Please refer to the SDS for safety information.

\*5 stage Phosphate pre-treated steel

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