



Technical Bulletin

PLSF 60071 RAL 3001 Signal Red

Description: *PLSF 60071, RAL 3001 Signal 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.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.45±0.05
	Theoretical Coverage	132 sq.ft./lb./mil
	Shelf life (at below 80°F in dry condition)	12 months

Typical Physical Properties:	Film Thickness	2.0-3.5 mil
	Gloss 60°angle (ASTM D-523-89)	80-90
	Hardness (ASTM D-3363-92A)	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)
UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.)	Recognized *	

Application Data: *PLSF 60071, RAL 3001 Signal Red* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PLSF 60071, RAL 3001 Signal 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 Peak Metal Temperature

Storage: *PLSF 60071, RAL 3001 Signal 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 MSDS for safety information.

*5 stage Phosphate pre-treated steel

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