



Technical Bulletin

RAL 7021 BLACK GRAY PLSF 70406

- Description:** This product is a polyester TGIC powder coating, designed for interior or exterior applications.
- Typical Applications:** General industrial finishing.
- Typical Physical Properties:**
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| Film Thickness | 1.7-3.0+ 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) | 1.64 +/- 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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