



Technical Bulletin

PRSM 47241 Matte RAL 1019

Description: *PRSM 47241, Matte RAL 1019* is a thermosetting modified Polyester powder coating and designed for interior and exterior durability. When properly applied this product will meet or exceed the AAMA 2603 specification.

Typical Powder Properties	Specific Gravity (ASTM D5965-96, C)	1.64+/-0.05
	Theoretical Coverage	117 sq./lb./mil
Typical Physical Properties:	Film Thickness	2.0-3.0 mil
	Gloss 60'angle (ASTM D-523-89)	1-3 (visual)
	Hardness (ASTM D-3363-92A)	2H
	Flexibility (ASTM D-1737-89)	1/4 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	80/80 in-lbs.
	Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
	Salt Spray (ASTM B117, 2000 hrs, Alodine panel)	Rating 7 (creepage)

Application Data: *PRSM 47241, Matte RAL 1019* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PRSM 47241, Matte RAL 1019* 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 @ 400°F Peak Metal Temperature

Storage: *PRSM 47241, Matte RAL 1019* 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 iron phosphated panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

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