



Technical Bulletin

PLSF 80037 RAL 9003 crystal/Signal White

Description: *PLSF 80037, RAL 9003 Crystal/Signal White* 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.

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| Typical Powder Properties | Specific Gravity (ASTM D5965-96, C) | 1.51±0.05 |
| | Theoretical Coverage | 127 sq.ft./lb./mil |
| | Shelf life (at below 80°F in dry condition) | 12 months |

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| Typical Physical Properties: | Film Thickness | 2.5-3.5 mil |
| | Gloss 60°angle (ASTM D-523-89) | 85+ |
| | Hardness (ASTM D-3363-92A) | 2H |
| | Flexibility (ASTM D-1737-89) | 1/16 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) UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.) | Rating 7 (creepage) Recognized * |

Application Data: *PLSF 80037, RAL 9003 Crystal/Signal White* is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: *PLSF 80037, RAL 9003 Crystal/Signal White* 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 80037, RAL 9003 Crystal/Signal White* 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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