



## Technical Bulletin

### **RAL 1015 Ivory PLSF 40015**

**Description:** Thermosetting polyester tgc powder coating. Polyester tgc's are designed for interior or exterior applications.

**Typical Applications:** General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.

<b>Typical Physical Properties:</b>	<b>Film Thickness</b>	<b>1.7 - 3.0+ mil</b>
	<b>Gloss 60° angle (ASTM D-523-89)</b>	<b>85+</b>
	<b>Hardness (ASTM D-3363-92A)</b>	<b>H – 2H</b>
	<b>Flexibility (ASTM D-1737-89)</b>	<b>1/16 inch</b>
	<b>Adhesion (ASTM D-3359-95A)</b>	<b>5b (100%)</b>
	<b>Impact Direct/Indirect (ASTM D-2794-93)</b>	<b>160 in-lbs</b>
	<b>Exterior Durability</b>	<b>Very Good</b>
	<b>Chemical Resistance</b>	<b>Good</b>
	<b>Salt Spray (ASTM B117)</b>	<b>1000 Hrs &lt; 1/8'</b>
<b>Specific Gravity (calculated)</b>	<b>1.45</b>	

**Application Data:** Polyester tgc's are to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv.

**Cure Schedule:** Polyester tgc's can be cured in a direct or indirect gas convection oven, an electric oven, or an Infra red. 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 MSDS for safety information.



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