



Technical Data Sheet

RAL 1000 Green Beige PLSF 40705

Description:	<i>PLSF 40705, RAL 1000</i> is a thermosetting Polyester-TGIC powder coating. Polyester TGIC's are designed for interior or exterior applications.	
Typical Applications:	General metals, architectural, automotive, lawn & garden furniture, stadium seating, light fixtures, marine, fencing, etc.	
Typical Physical Properties:	Film Thickness	2.0-3.0 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, 3 mm Creepage
	Specific Gravity (calculated)	1.60±0.03
Application Data:	<i>PLSF 40705, RAL 1000</i> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.	
Cure Schedule:	<i>PLSF 40705, RAL 1000</i> 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 MSDS for safety information.	

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