



## Fas-Trac Service

**NUMBER:** HFTR02S8

September 20, 2012

**NAME:** RAL 1019 HAA

**Type:** HAA Polyester

### POWDER PROPERTIES

<b>ASTM D5965-96, C</b>	Specific Gravity	1.5 ± 0.05
	Theoretical Coverage	128 ft <sup>2</sup> /lb/mil
<b>ASTM D3451-92, 13</b>	Mass Loss During Cure	< 1 %
	Recommended Shelf Life:	12 Months @ 75 F

### COATING PROPERTIES

<b>ASTM D523-89</b>	Gloss at 60°	75-85
<b>DPC TM 10.219</b>	PCI Powder Smoothness	7
<b>ASTM D3363-92a</b>	Pencil Hardness	2H
<b>ASTM D2794-93</b>	Dir / Rev Impact, Gardner	160 / 160 in/lbs
<b>ASTM D522-93a</b>	Flexibility, Mandrel	1/8 in. dia., no fracture
<b>ASTM B117-97</b>	Salt Spray	1,000 hrs
<b>UL DTOV2 Organic Coating</b>	Steel Enclosures, Elect. Eq.	Recognized

### APPLICATION

Electrostatic Spray, Cold  
 Substrate: 0.032 in. CRS  
 Pretreatment: Bonderite 1000®, Parcolene® 60

#### Cure Schedule:

(Time at substrate temperature)

10 Minutes @ 375F

or 15 Minutes @ 350F

**Film Thickness:** 2.0-3.0 Mils

This coating has been developed to meet or exceed the requirements of AAMA 2603 on architectural aluminum components.

Prepared 6/25/2013

9800 Genard Rd. Houston, TX 77041-7624 1-800-247-3886 fax: 713-939-4027  
 4130 Lyman Dr. Hilliard, OH 43026-1213 1-800-667-9610 fax: 614-771-4139



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