

# Technical Information Sheet



Number: *HFYR03S8*

September 20, 2012

Name: *RAL 1023 HAA*

Type: *HAA Polyester*

Alesta Group Code: AE80001000216

## POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.59 ± 0.05
	Theoretical Coverage	121 ft <sup>2</sup> /lb/mil
ASTM D3451-92, 13	Mass Loss During Cure	< 1%
	Recommended Shelf Life:	12 Months @ 75 °F

## COATING PROPERTIES

ASTM D523-89	Gloss at 60°	75-85
DPC TM 10.219	PCI Powder Smoothness	7
ASTM D2454-95	Overbake Resistance, Time	100%
ASTM D3363-92a	Pencil Hardness	2H
ASTM D2794-93	Dir / Rev Impact, Gardner	160 / 160 in/lbs
ASTM D3359-97	Adhesion, Cross Hatch	5B Pass
ASTM D522-93a	Flexibility, Mandrel	1/8 in. dia., no fracture
ASTM B117-97	Salt Spray	1,000 hrs
UL DTOV2 Organic Coating	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 @ 375°F*

*or 15 Minutes @ 350°F*

**FILM THICKNESS: 2.5-3.5 Mils**

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

Prepared 6/25/2013

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