

Technical Information Sheet



ALESTA AR300*

Number: HFPR09S8

September 27, 2013

Name: RAL 4002 HAA

Type: HAA Polyester

Alesta Group Code: AE80003000716

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.49 ± 0.05
	Theoretical Coverage	129 ft ² /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	6
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
AAMA 2603-02	Organic Coatings on Aluminum Extrusions	Passed

APPLICATION

Electrostatic Spray, Cold

Substrate: 0.032 in. CRS

Pretreatment: Bonderite® 1000, Parcolene® 60

*This product meets the requirements of AAMA 2603.

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

CURE SCHEDULE:

(Time at substrate temperature)

10 Minutes @ 375°F

or 15 Minutes @ 350°F

FILM THICKNESS: 2.0-3.0 Mils

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