

# Technical Information Sheet



Number: *HFKR04S8*

October 26, 2012

Name: *RAL 5012 HAA*

Type: *HAA Polyester*

Alesta Group Code: AE80005000116

## POWDER PROPERTIES

<b>ASTM D5965-96, C</b>	Specific Gravity	1.63 ± 0.05
	Theoretical Coverage	118 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 D2454-95</b>	Overbake Resistance, Time	100%
<b>ASTM D3363-92a</b>	Pencil Hardness	2H
<b>ASTM D2794-93</b>	Dir / Rev Impact, Gardner	160 / 160 in/lbs
<b>ASTM D3359-97</b>	Adhesion, Cross Hatch	5B Pass
<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 @ 375°F

or 15 Minutes @ 350°F

**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 6/24/2013

9800 Genard Rd. Houston, TX 77041-7624  
4130 Lyman Dr. Hilliard, OH 43026-1213

1-800-247-3886 fax: 713-939-4027  
1-800-667-9610 fax: 614-771-4139



WARRANTY POLICY: Seller certifies that all coatings delivered to Customer in unopened factory filled containers meet all pertinent quality standards presented in its current published literature. Since matters of surface preparation, application procedures, curing procedures and other local factors that affect coating performance are beyond Seller's control, Seller assumes no liability for coating failure other than to supply replacement material for a coating material proven to be defective. Customer will determine suitability of this product for its use and thereby assume all risks and liabilities in connection therewith. Seller will not be liable for any injuries, damages or other losses derived, directly or indirectly, from or as a consequence of Customer's use of the product. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, RELATING TO ITS PRODUCTS AND THEIR APPLICATION, INCLUDING BUT NOT LIMITED TO WARRANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSES.

