

# Technical Information Sheet



Number: HFGR21S7

May 14, 2013

Name: RAL 6004 HAA

Type: HAA Polyester

Alesta Group Code:

## POWDER PROPERTIES

<b>ASTM D5965-96, C</b>	Specific Gravity	1.45 ± 0.05
	Theoretical Coverage	133 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°	70-80
<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

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