



Fas-Trac Service

NUMBER: HFGR25S8

July 8, 2013

NAME: RAL 6024 HAA

Type: HAA Polyester

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.48 ± 0.05
	Theoretical Coverage	130 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°	80-90
DPC TM 10.219	PCI Powder Smoothness	6
ASTM D3363-92a	Pencil Hardness	2H
ASTM D2794-93	Dir / Rev Impact, Gardner	160 / 160 in/lbs
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 @ 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 7/18/2013

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