

Technical Information Sheet



Number: *HFHR12S8*

November 1, 2012

Name: *RAL 7013 HAA*

Type: *HAA Polyester*

Alesta Group Code:

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.53 ± 0.05
	Theoretical Coverage	126 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	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	1/4 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: 2.0-3.0 Mils

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

Prepared 6/25/2013

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



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