

Technical Information Sheet



ALESTA AR300*

Number: PFB401S6

October 14, 2008

Name: Vulcan Black

Type: TGIC-Polyester

Alesta Group Code: AD60004000014

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.5 ± 0.05
	Theoretical Coverage	128 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°	55-65
DPC TM 10.219	PCI Powder Smoothness	5
ASTM D2454-95	Overbake Resistance, Time	100%
ASTM D3363-92a	Pencil Hardness	H-2H
ASTM D2794-93	Dir / Rev Impact, Gardner	60 / 60 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
ASTM F963-95, 4.3.5	Toy Safety, Element Levels	Pass
European EN 71, Part 3, 1994	Safety of Toys, Element Levels	Pass

APPLICATION

Electrostatic Spray, Cold

Substrate: 0.032 in. CRS

Pretreatment: Bonderite® 1000, Parcolene® 60

*This product meets the requirements of AAMA 2603.

This product meets the requirements of AAMA 2603 for architectural aluminum.

CURE SCHEDULE:

(Time at substrate temperature)

10 Minutes @ 400°F

or 20 Minutes @ 350°F

FILM THICKNESS: 2.5-3.5 Mils

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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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