

Technical Information Sheet



ALESTA AR400*

Number: HFW605S4

September 22, 201

Name: AR400 Bone White Matte

Type: HAA Polyester

Alesta Group Code: SD40009000016

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.65 ± 0.05
	Theoretical Coverage	117 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°	25-35
DPC TM 10.219	PCI Powder Smoothness	7
ASTM D2454-95	Overbake Resistance, Time	100%
ASTM D3363-92a	Pencil Hardness	2H
ASTM D2794-93	Direct Impact, Gardner	30 in/lbs
ASTM D3359-97	Adhesion, Cross Hatch	5B Pass
ASTM D522-93a	Flexibility, Mandrel	3/8 in. dia., no fracture
ASTM B117-97	Salt Spray	1,000 hrs
UL DTOV2 Organic Coating	Steel Enclosures, Elect. Eq.	Recognized
AAMA 2604-05	High Performance Organic Coatings on Aluminum Extrusions	Passed

APPLICATION

Electrostatic Spray, Cold

Substrate: 0.032 in. CRS

Pretreatment: Bonderite® 1000, Parcolene® 60

CURE SCHEDULE:

(Time at substrate temperature)

10 Minutes @ 400°F

or 15 Minutes @ 375°F

FILM THICKNESS: 2.0-3.0 Mils

Recommended for use in architectural applications such as window frames, cladding, shopfronts and other products where enhanced levels of exterior weatherability are required. This product meets requirements for AAMA 2604 as per the American Architectural Manufacturers Association and is based on proven polyester technology used globally in architectural market.

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