



Number: *HFLR04S8*

September 20, 201

Name: *RAL 1015 HAA*

Type: *HAA Polyester*

Alesta Group Code:

POWDER PROPERTIES

| | | |
|--------------------------|-------------------------|-----------------------------|
| ASTM D5965-96, C | Specific Gravity | 1.7 ± 0.05 |
| | Theoretical Coverage | 113 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 | 6 |
| 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 6/24/2013

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