



## Fas-Trac Service

**NUMBER:** HFMR01S8

September 20, 2012

**NAME:** RAL 3004 HAA

**Type:** HAA Polyester

### POWDER PROPERTIES

<b>ASTM D5965-96, C</b>	Specific Gravity	1.38 ± 0.05
	Theoretical Coverage	139 ft <sup>2</sup> /lb/mil
<b>ASTM D3451-92, 13</b>	Mass Loss During Cure	< 1 %
	Recommended Shelf Life:	12 Months @ 75 °F

### COATING PROPERTIES

<b>ASTM D523-89</b>	Gloss at 60°	75-85
<b>DPC TM 10.219</b>	PCI Powder Smoothness	6
<b>ASTM D3363-92a</b>	Pencil Hardness	2H
<b>ASTM D2794-93</b>	Dir / Rev Impact, Gardner	160 / 160 in/lbs
<b>ASTM D522-93a</b>	Flexibility, Mandrel	1/4 in. dia., no fracture
<b>ASTM B117-97</b>	Salt Spray	1,000 hrs
<b>UL DTOV2 Organic Coating</b>	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

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