



# Technical Data Sheet

**Product Number:** POL225243

**Product Name:** NARANJA RAL 2009/25243 (700051) POL.

**Chemistry:** POLYESTER TGIC

**Date:** AUGUST 01<sup>ST</sup>, 2013

## *Powder Properties*

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ASTM D5965 (B)	Specific Gravity	1.70 ± 0.05
PCI TECHNICAL BRIEF #8	Theoretical Coverage	113.1 ft <sup>2</sup> /lb/mil
	Shelf Life	12 months in climate controlled environment

## *Film Characteristics*

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ASTM D523	Gloss @ 60°	55-65%
ASTM D3359 (B)	Adhesion	5B Pass
ASTM D3363	Pencil Test (Scratch Hardness)	2H Pass
ASTM D7091	Recommended Film Thickness	2.0-3.0 mils
PCI TECHNICAL BRIEF #20	PCI Powder Smoothness	4
ASTM D522 (A)	Flexibility Mandrel	1/8"
ASTM D2794	Indirect Impact	120 in/lbs
ASTM D5402	MEK Resistance	25 Double Rubs
ASTM B117	Salt Spray	500 hours
ASTM G154	UV Resistance	500 hours

## *Application*

Electrostatic Spray, Cold  
Substrate: 0.024 in. CRS  
Pretreatment: Bonderite® 1000 , Parcolene® 60

**Cure Schedule**  
(Time at Substrate Temperature)  
375 °F @ 8 minutes

## *Notes*

- WITHOUT LOSING ITS ANTICORROSIVE PROPERTIES  
- HEAVY METAL CONTENT: <0.009%

American Standard Testing Method (ASTM)  
Powder Coating Institute

This report cannot be altered or changed without the authorization of the Quality Manager.

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