



# Technical Data Sheet

**Product Number:** ZOR233734

**Product Name:** RAL 2004 PURE ORANGE RPSD POL. SD

**Chemistry:** POLYESTER SUPERDURABLE

**Date:** MAY 08<sup>TH</sup>, 2019

## *Powder Properties*

ASTM D5965 (B)	Specific Gravity	1.45 ± 0.05
PCI TECHNICAL BRIEF #8	Theoretical Coverage	132.6 ft <sup>2</sup> /lb/mil
	Shelf Life	12 months in climate controlled environment

## *Film Characteristics*

ASTM D523	Gloss @ 60°	80-90%
ASTM D3359 (B)	Adhesion	5B Pass
ASTM D3363	Pencil Test (Scratch Hardness)	F Pass
ASTM D7091	Recommended Film Thickness	2.0-3.0 mils
PCI TECHNICAL BRIEF #20	PCI Powder Smoothness	6
ASTM D522 (A)	Flexibility Mandrel	1/8"
ASTM D2794	Indirect Impact	140 in/lbs
ASTM D5402	MEK Resistance	50 Double Rubs
ASTM B117	Salt Spray	3,000 hours
ASTM G154	UV Resistance	1,000 hours

## *Application*

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

**Cure Schedule**  
(Time at Substrate Temperature)  
375 °F @ 10 minutes

## *Notes*

-THIS FORMULATION HAS BEEN DEVELOPED TO MEET ALL OF AAMA 2604 WEATHER AND CORROSION REQUIREMENTS.

-FORMULATED TO VISUALLY MATCH RAL K7 INTERNATIONAL STANDARDS

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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