



Technical Data Sheet

Product Number: ZOR233770

Product Name: RAL 2010 SIGNAL ORANGE RPSD POL. SD

Chemistry: POLYESTER SUPERDURABLE

Date: JULY 17TH, 2019

Powder Properties

| | | |
|------------------------|----------------------|---|
| ASTM D5965 (B) | Specific Gravity | 1.50 ± 0.05 |
| PCI TECHNICAL BRIEF #8 | Theoretical Coverage | 128.1 ft ² /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 | 5 |
| 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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