



# Technical Data Sheet

**Product Number:** ZOR233734

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

**Chemistry:** Polyester Superdurable

**Date:** August 7, 2020

## ***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 - 100
ASTM D3359 (B)	Adhesion	5B Pass
ASTM D3363	Pencil Test (Scratch Hardness)	F Pass
ASTM D7091(B)	Recommended Film Thickness	2.0-3.0 mils
PCI TECHNICAL BRIEF #20	PCI Powder Smoothness	6
ASTM D522 (A)	Flexibility Mandrel	1/8" Pass
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, Aluminum  
Pretreatment: Bonderite ® 1000, Parcolene® 60, Chromate

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

## ***Notes***

This product was designed to meet weathering requirements under AAMA 2604 "5 years south Florida with maximum Delta E < 5 (Hunter) and gloss retention > 30%".

Formulated to visually match RAL K7 international standards

American Standard Testing Method (ASTM)

Powder Coating Institute (PCI)

American Architectural Manufacturers Association (AAMA)

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

## **Vitracoat, Inc.**

2807 Marina Drive Elkhart, IN 46514 Ph: 574-264-6090  
Toll-Free: 888-778-5994 Fax: 574-264-2776 www.vitracoat.com

## **Vitracoat Pinturas en Polvo S.A de C.V.**

Av. Circuito de la Industria Sur 284, Parque Industrial Lerma, C.P. 52000, Estado de Mexico, México, Phone: +(722) 2627000, Fax+(722)2827024  
www.vitracoat.com\*Email:sales@vitracoat.com