Technical Data Sheet

Product Number: ZRR233669
Product Name: RAL 3004 PURPLE RED RPSD POL. SD
Chemistry: Polyester Superdurable **Date:** August 7, 2020

Powder Properties

ASTM D5965 (B)	Specific Gravity	1.35± 0.05
PCI TECHNICAL BRIEF #8	Theoretical Coverage	142.4 ft2/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.

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