ifs coatings

Technical Bulletin

PLSF 10001
RAL 9005 Gloss Black

Description: ***PLSF 10001, RAL 9005 Gloss Black*** is a thermosetting Polyester-TGIC powder coating and designed for interior or exterior applications.

Typical Powder Properties

Specific Gravity (ASTM D5965-96, C)	1.40±0.05	
Theoretical Coverage	137 sq.ft/lb./mil	
Shelf life (at below 80°F in 50% humidity)	18 months	

Typical Physical Properties:

Film Thickness	2.0-3.0 mil
Gloss 60'angle (ASTM D-523-89)	90-95
Hardness (ASTM D-3363-92A)	2H-3H
Flexibility (ASTM D-1737-89)	1/8 inch
Adhesion (ASTM D-3359-95A)	5B (100%)
Impact Direct/Indirect (ASTM D-2794-93)	160/160 in-lbs.
Salt Spray (ASTM B117, 1000 hrs, Bonderite 1000 panel)	Rating 7 (creepage)
UL DTOV2 Organic Coating (Steel Enclosure, Elect. Eq.)	Recognized *
Exterior Exposure* (1 Yr.; ASTM D2244, ASTM D4214)	30% GR, ΔE:≤5.0
*45° South Florida	

Application Data: ***PLSF 10001, RAL 9005 Gloss Black*** is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kV.

Cure Schedule: ***PLSF 10001, RAL 9005 Gloss Black*** can be cured in a direct or indirect gas convection oven, an electric oven, or an Infrared. A combination of any of these ovens is also suitable.

         Standard Cure: 10 minutes @ 340°F Peak Metal Temperature

Storage: ***PLSF 10001, RAL 9005 Gloss Black*** should be stored at temperatures below 80°F, in a dry area away from any heat source.

Notes: All tests were performed on B-1000 panels with a nominal film thickness of 2.0-3.0 mils. Please refer to the SDS for safety information.

*5 stage Phosphate pre-treated steel