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Product Data Sheet

General Description

PRODUCT CODE: P9SO20
PRODUCT NAME: RAL 2004 PURE ORANGE
CHEMISTRY: POLYESTER
SURFACE FINISH: SMOOTH

Application Recommendation

Surface preparation: All oil and grease, scale and rust, must be removed.
Pretreatment Requirements: A five stage pretreatment according to ASTM B449 is highly recommended,
Anodizing according to AAMA 2603-02 are acceptable methods of optimum adhesion performance and excellent corrosion protection
Cure Schedule 10 min. at 400 Deg. F or 15 min. at 375 Deg. F, Metal Temperature.
Film thickness: 2-4 mils.
Weatherability: Good for outdoor applications.
Designed for electrostatic application. For use in wide variety of general metal applications.
Shelf life is expected to be at least one year from date of shipment when stored in dry conditions at less than 80 Deg. F.(27 Deg. C.)

This powder coating do not contain the 10 restricted substances, as defined in the European directive 2015/863/EU (RoHS 3 restriction of Hazardous Substances) 2), Article (4)2, Annex II, to this product, and have determined that any impurities disclosed to us by our suppliers are in amounts less than the maximum concentration values tolerated by weight in homogeneous materials for the restricted hazardous substances under the RoHS 3 CE- marking directive and REAC Restricted Chemical list , Cadmium, Chromium VI, Lead, Mercury, Cadmium, Polybromobiphenyls, Polybrominatedbiphenyls(PBB) under the RoHS 3 compliance effect July, 2019 Do not contain Chemicals listed in California January 03, Proposition 65 list

Typical Performance Characteristics

Specific Gravity	Calculated	1.60
Coverage	Calculated	120 square foot/lb./mil
Particle Size	ASTM D3451	0-10% over 200 Mesh
	Alpine Jet Sieve	40-45% over 400 Mesh
Gloss 60 Degree	ASTM D 523	90+/-5 UNITS
Impact Resistance	ASTM D 2794	160 in.lbs.Direct/160 in.lbs. Reverse
Flexibility	ASTM D 522	Pass 1/8" Mandrel
Pencil Hardness	ASTM D 3363	2H
Adhesion	ASTM D 3359	5B- Method B
Salt Spray Resistance	ASTM B 117	1000 hr. (ASTM D165 Creepage Min.7)
		(ASTM D714 Blister Min. 8)
Humidity Resistance	ASTM D 2247	1000 hr. (ASTM D714 Blister Min.8)

Weathering: South Florida Exposure 45 degree angle facing South

Color Retention	3 years (ASTM D2244)	< 5 DE "CIELAB" (ASTM D2244)
Chalk Retention	3 years (ASTM D4214)	Minimum 8 rating (ASTM D659)
Gloss Retention	3 years (AAMA 2604)	> 30% retention (ASTM D523)
Erosion retention	3 years (ASTM D662)	<10% Loss

* Testing performed on Bonderite B1000 panels.

Important: Warranty and Disclaimer- The information contained herein is to the best of our knowledge, true and accurate. All recommendations or suggestion for use are made without guarantee. Since the conditions of use are beyond our control. The performance characteristics of these products vary according to product application, operation conditions, materials applied to. Since these factors can affect results, we recommended that you perform your own test to determine to your satisfaction whether the product is acceptable and is suitable for your particular purpose under your own operation conditions prior to using any product in full scale production, Seller warrants the product to be free from defects in materials and workmanship. Such warranty is exclusive and is in lieu of any other warranty. Nortek Corporation disclaims any liability incurred in connection with the use of our products and information contained herein. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.