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## Technical Data Sheet

### General Description

PRODUCT CODE: S8SH33  
PRODUCT NAME: RAL 8014 SIPIA BROWN  
CHEMISTRY: POLYESTER SUPER- DURABLE  
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 and Chrome-free pretreatment according to AAMA 2604-05 are acceptable methods of optimum adhesion performance and excellent corrosion protection.

Cure Schedule 10 min. at 400 Deg. F, or 15 min. at 375F metal temperature.

Film thickness: 3-5 mils.

Features: Superior gloss and color retention, excellent weather resistance, excellent mechanicals properties, excellent edge coverage, good storage stability.

Typical Applications: All Architectural and construction application including Playground equipment, Agricultural equipment and Marine application.

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.)

### Typical Performance Characteristics

Specific Gravity	Calculated	1.50
Coverage	Calculated	128 squares 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	85+/-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	3000 hr. (ASTM D165 Creepage Min.7) (ASTM D714 Blister Min. 8)
Humidity Resistance	ASTM D 2247	3000 hr. (ASTM D714 Blister Min.8)

### Weathering: South Florida Exposure 45 degree angle facing South

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

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