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Nortek Powder Coating LLC.

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Product Data Sheet

General Description

PRODUCT CODE: P8SY24
PRODUCT NAME: RAL 1004 GOLDEN YELLOW
CHEMISTRY: POLYESTER
SURFACE FINISH: SMOOTH

Application Recommendation

Surface preparation: All oil and grease, scale and rust, must be removed.
Pretreatment: Iron or Zinc phosphate is recommended for optimum performance.
Cure Schedule 10 min. at 400 Deg. F or 15 min. at 375 Deg. F
Film thickness: 2-4 mils.
Weather ability: Excellent outdoor durability (meets or exceeds A.A.M.A. 1603.98)
Advantages: Outstanding physical & mechanical properties and over bake resistance
Excellent application efficiency and re-coat ability.

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 | 1.55 |
| Coverage | Calculated | 125 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 | 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 | 1000+ hours |
| Humidity Resistance | ASTM D 2247 | 1000+ hours |

- 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 suggestions 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, operating conditions, and 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 operating 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 these provisions, which applies to all product sales.
