Alesta®
Powder Coatings

Technical Information Sheet

Number: *HFYR06S7*

Name: *RAL 1016 HAA*

Alesta Group Code:

February 14, 2013

Type: HAA Polyester

POWDER PROPERTIES

ASTM D5965-96, C	*Specific Gravity*	*1.61 ± 0.05*
	Theoretical Coverage	*119 ft2/lb/mil*
ASTM D3451-92, 13	*Mass Loss During Cure*	*< 1%*
	Recommended Shelf Life:	*12 Months @ 75 °F*

COATING PROPERTIES

ASTM D523-89	*Gloss at 60°*	*70-80*
DPC TM 10.219	*PCI Powder Smoothness*	*7*
ASTM D2454-95	*Overbake Resistance, Time*	*100%*
ASTM D3363-92a	*Pencil Hardness*	*2H*
ASTM D2794-93	*Dir / Rev Impact, Gardner*	*160 / 160 in/lbs*
ASTM D3359-97	*Adhesion, Cross Hatch*	*5B Pass*
ASTM D522-93a	*Flexibility, Mandrel*	*1/8 in. dia., no fracture*
ASTM B117-97	*Salt Spray*	*1,000 hrs*
UL DTOV2 Organic Coating	*Steel Enclosures, Elect. Eq.*	*Recognized*

APPLICATION

Electrostatic Spray, Cold
Substrate: 0.032 in. CRS
Pretreatment: Bonderite® 1000, Parcolene® 60

CURE SCHEDULE:
(Time at substrate temperature)
10 Minutes @ 375°F
or 15 Minutes @ 350°F
FILM THICKNESS: *2.5-3.5 Mils*

This coating has been developed to meet or exceed the requirements of AAMA 2603 on architectural aluminum components.

Prepared 12/19/2014

ROHS

Axalta does not intentionally add any of the restricted substances, as defined in the European directive 2011/65/EU (RoHS-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; lead, mercury, cadmium, hexavalent chromium, polybrominated biphenyls, and polybrominated diphenyl ethers, under the RoHS directive.

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ISO 9001:2008

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