

**Number:** HFKR05S8

**Name:** RAL 5005 HAA

**Alesta Group Code:** AE80005000316

**October 26, 2012**

**Type:** HAA Polyester

### POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.55 ± 0.05
	Theoretical Coverage	124 ft <sup>2</sup> /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°	75-85
DPC TM 10.219	PCI Powder Smoothness	6
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:** 2.0-3.0 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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