

**PIONEER POWDER
TECHNICAL DATA SHEET
POLYESTER TGIC CHARACTERISTICS**

**RAL 3000
FLAME RED**

POWDER SPECIFICATIONS	FILM PROPERTIES
SPECIFIC GRAVITY: 1.56 +/- .05 THEO. COVERAGE @ 1 MIL. :123 SQ.FT./LB.	GLOSS LEVEL : 85+
SALT SPRAY (ASTM B-117): 1000 HR., LESS THAN 1/8" CREEPAGE FROM SCRIBE	SOLVENT RESISTANCE: 50 DOUBLE RUBS NO METAL SHOWS COATING SOFTENS SLIGHTLY
GEL TIME:RANGING FROM: 50 TO 100 Sec.	IMPACT RESISTANCE: (ASTM D-2794): 100 IN LB
QUV RESISTANCE:400 HOURS, LESS THAN 50% DROP IN GLOSS	OVERBAKE CAPABILITY: 100 PERCENT
HUMIDITY (ASTM D-2247): 1000 HOURS, NO SOFTENING OF COATING OR GLOSS DROP	PENCIL HARDNESS: (ASTM D-3363): H-2H
FILM THICKNESS: 2.5 TO 3.0 MILS	FLEXIBILITY (ASTM D-522): 1/8" CONICAL BEND NO CRACKING
SUBSTRATE TESTED:IRON PHOSPHATE BONDRITE 1000 PANELS	ADHESION (ASTM D-3359):100 SQUARES SCRIBED, NO PEEL OFF WITH TAPE

CURE CYCLE: 10 MINUTES AT 375 DEGREES FAHRENHEIT

STORAGE: SIX MONTHS SHELF LIFE; LESS THAN 75 DEGREES F