

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

**RAL 3009  
OXIDE RED**

<b>POWDER SPECIFICATIONS</b>	<b>FILM PROPERTIES</b>
SPECIFIC GRAVITY: 1.64 +/- .05 THEO. COVERAGE @ 1 MIL. :117 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**