SHERWIN-WILLIAMS
Chemical Coatings

# TECHNICAL INFORMATION

**POWDURA® RAL Series Super Durable TGIC-FREE POLYESTER**

## POWDURA® RHS8-40003 RAL 1019 GL Super Durable TGIC-FREE POLYESTER High Gloss

**POWDURA® RAL Series Super Durable TGIC-FREE POLYESTER Powder Coatings** are recommended for a broad range of interior/exterior decorative applications. They are designed for superior weatherability compared to standard polyester powder coatings.

### APPLICATION

| | |
|---|---|
| **Cure Schedule:** | 10 min. at 400°F |
| **Film Thickness Range:** | 2.0. – 3.0 mils |

### ATTRIBUTES

| | |
|---|---|
| **Specific Gravity:** | 1.60 |
| **Coverage at 1.0 Mil** | 121 sq. ft./ lb**.** |
| **60° Gloss:** (ASTM D-523) | 85+ |
| **Adhesion:** (ASTM D-3359) | 5B |
| **Flexibility:** (ASTM D-522) | Pass 1/8 " Mandrel Bend |
| **Pencil Hardness:** (ASTM D-3363) | H-2H |
| **Impact Resistance:** (ASTM D-2794) | 80**+** in-lbs direct<br>80+ in-lb reverse |

**Other Notes**:
The Powdura RAL high gloss series is designed to meet AAMA 2603-02 offering very durable exterior performance.

**Storage:** Powdura® Powder Coatings should be kept in a dry and cool area at temperatures below 80°F (27° C). Shelf life is approximately 12 months. When not in use, store powder in sealed containers: fine powders are hygroscopic.

**Substrate Preparation:** Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface preparation treatments to ensure optimum adhesion and coating performance properties. The use of a chemical conversion coating prior to the application of a powder coating is strongly recommended.

For aluminum a minimum of a 5-stage chrome phosphate metal treatment, or equivalent, is required for good adhesion and optimum coating performance properties.

Consult Metal Preparation Brochure CC-T1 for additional details.

**Testing:** Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full-scale application. The properties listed are typical and should not be construed as the actual specification.

### APPLICATION

Powder coatings must be applied using suitable electrostatic equipment. Consult your Sherwin-Williams Representative regarding unique applications.

**Product Limitations:**

- Contact your Sherwin-Williams Representative where use of this product at higher than recommended film thickness may be required.

### CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. Please direct any questions or comments to your local Sherwin-Williams facility.

**CAUTION!** Causes eye irritation, causes skin irritation, may cause allergic skin reaction, respiratory irritant, dust may cause eye and respiratory irritation, dust may form an explosive mixture in air. Avoid breathing dust. Avoid contact with eyes and prolonged or repeated contact with skin. Use protective clothing and NIOSH approved respirator. Do not use near sparks or open flame or any type of ignition source. Wash thoroughly after handling. Use only with adequate ventilation.

**FIRST AID:**
**If on SKIN:** Wash thoroughly with soap and water.
**If in EYES:** Flush with water immediately and procure medical attention. The area adjacent to the coating operation should be properly ventilated. Cure ovens must be exhausted to the outside atmosphere. All dusts are respiratory irritants; inhalation of the dust should be avoided. To avoid static electricity build-up, properly ground all equipment. Provide dust collection equipment with adequate explosion venting; dust clouds of any finely divided organic material can be ignited by open flame or electrical sparks.

**DO NOT TAKE INTERNALLY.**

**KEEP OUT OF REACH OF CHILDREN.**

**FOR INDUSTRIAL USE ONLY.**

**REFER TO MATERIAL SAFETY DATA SHEET FOR ADDITIONAL INFORMATION.**

**Note:**
Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating and opinions stated above pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application, which are not known, or under our control, The Sherwin-Williams Company cannot make any warranties or guaranties as to the end results.

Arlington, TX
**9/22/2008**

green sure