



# APPLICATION GUIDE

WITH TECHNICAL DATA INFORMATION

PRISMATIC POWDERS | 7050 SIXTH STREET | WHITE CITY, OR 97503 | 866-774-7628 | PRISMATICPOWDERS.COM

As with all powder coatings, this product may vary between lot numbers, KV settings, mil thickness, oven temperatures, application equipment and technique. We recommend a clear top coat to maintain the appearance and prevent oxidation on metallic powder coatings. Always coat a sample prior to any production, to determine if this product meets all your requirements.

**PRODUCT LINE/NAME:** RAL SERIES

**ITEM NUMBER:** RAL 1000-9018

**DESCRIPTION:** Polyester Solid Tone (Thermosetting Powder Coating).

**SPECIAL INSTRUCTIONS:** NONE

**CURE TIME & TEMP:**

**12 min. @ 400°F**

As always, the cure time starts when the substrate reaches temperature.

**Note:** Each additional coat of powder coating will act as an insulator, which will require additional time for the substrate to reach temperature. Extend cure times as needed.

**POWDER CHARACTERISTICS:**

Powder type -	Polyester
Specific gravity -	1.5
Suggested KV setting -	45
Theoretical Coverage -	25-30 ft <sup>2</sup> /lb at 1 mil thickness.

**CURED COATING CHARACTERISTICS:** (Tested at 2-3.5 mils coating thickness)

GLOSS at 60° (ASTM D523)	60%-85%
IMPACT DIRECT/INDIRECT (ASTM D2794)	160/160 in-lbs
PENCIL HARDNESS (ASTM D3363)	H-2H
UV STABILITY	Excellent
SALT SPRAY	Excellent

**RECOMMENDED STORAGE / SHELF LIFE:**

Temperature: (Store in cool dry environment)	70° F
Time:	6-8 months

NIC Industries, Inc. does not warranty the use or application of the materials it manufactures or supplies. Our only obligation shall be to replace any defective materials supplied by us after we have determined it to be defective. We assume no liability for damages of any kind and the user accepts the product "as is" and without any warranties, expressed or implied. The suitability of the product or intended use shall be the sole responsibility of the user.

The information contained in this bulletin we believe to be correct to the best of our knowledge and testing. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets all your requirements.