Alesta® LE
Low Energy Powder Coatings
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Alesta® LE powder coatings use lower bake temperatures and/or shorter cure cycles to reduce energy consumption by up to 25%* compared to conventional polyester powder coatings.

These polyester, thermoset powder coatings deliver a smooth finish with good performance and weatherability. They are ideal for the mass production of heat sensitive parts or when faster line speeds and lower bake capabilities are desired.

*A 25% reduction in BTU's can be realized by switching from powder coatings with typical cure parameters to Alesta® LE.

Features and benefits:
- Increase line speeds by up to 60%
- Ideal for heavy mass parts since less energy is needed to cure
- Safer part-handling - parts are 75°F to 100°F cooler than normal
- PCI smoothness of 7-8 can be attained
- Does not require expedited freight or shipping by reefer
- Gloss as low as 40 units

Ideal Applications:
Playground equipment, electrical cabinets, lawn mowers, garden implements, outdoor furniture, LP storage tanks, castings, scuba diving tanks, ornamental iron railings, air conditioner, Grills

Stock Products
Alesta LE products can be ordered in any color and gloss ranges (70+ units) and a variety of textures

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Product Name</th>
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</thead>
<tbody>
<tr>
<td>PLW611S9</td>
<td>Sky White LE</td>
</tr>
<tr>
<td>PLG606S9</td>
<td>Evergreen LE</td>
</tr>
<tr>
<td>PLB604S7</td>
<td>Angel Black LE</td>
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<tr>
<td>PLR602S9</td>
<td>Red Baron LE III</td>
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</tbody>
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Physical Properties
Impact: 80 to 160 in/lb
Flexibility: 1/4 to 1/8 inch
Hardness: F to H
Cross Hatch Adhesion: 5B
Dry Film Thickness: 2.0 mil / 38.1 μ to 3.0 mil / 76.2 μ
Gloss at 60°: 70+

LE Cure Schedule
10 Minutes @ 300°F substrate temperature (lower specific gravity products)
15 Minutes @ 325°F substrate temperature (higher specific gravity products)

Contact Axalta Coating Systems- Powder NA Customer Service for more information or to place an order.

In the U.S., call 1-800-247-3886 or e-mail weborders.powder@axaltacs.com.

In Canada, call 1-888-447-2598 or e-mail powder.info@axaltacs.com.

www.axalta.us/powder