

Number: *HFHR21S7*

Name: *RAL 7044 HAA*

Alesta Group Code: AE70007000416

March 24, 2022

Type: HAA Polyester

POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.61 ±0.05
	Theoretical Coverage	119 ft ² /lb/mil
ASTM D3451-92, 13	Mass Loss During Cure	< 1%
	Recommended Shelf Life:	24Months @ 75°F

COATING PROPERTIES

ASTM D523-89	Gloss at 60°	70-80
DPC TM 10.219	PCI Powder Smoothness	7
ASTM D2454-95	Overbake Resistance, Time	100%
ASTM D3363-92a	Pencil Hardness	2H
ASTM D2794-93	Dir / Rev Impact, Gardner	160 / 160 in/lbs
ASTM D3359-97	Adhesion, Cross Hatch	5B Pass
ASTM D522-93a	Flexibility, Mandrel	1/8 in. dia., no fracture
ASTM B117-97	Salt Spray	1,000 hrs
UL DTOV2 Organic Coating	Steel Enclosures, Elect. Eq.	Recognized

APPLICATION

Electrostatic Spray, Cold

Substrate: 0.032 in. CRS

Pretreatment: Bonderite® 1000, Parcolene® 60

CURE SCHEDULE:

(Time at substrate temperature)

10 Minutes @ 375°F

or 15 Minutes @ 350°F

FILM THICKNESS: *2.0-3.0 Mils*

This coating has been developed to meet or exceed the requirements of AAMA 2603 on architectural aluminum components.

Prepared 3/25/2022

ROHS

Axalta does not intentionally add any RoHS restricted substances to this product, and the product is in conformity with the essential requirements of the following directives of the European Parliament and of the Council: Directive 2015/863; Directive 2011/65/EU; Directive 2002/65/EU; and, Directive 2003/11/EU.

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ISO 9001:2015

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