

Number: *HFL609S9*

Name: *Caruva Ivory*

Alesta Group Code: IE90001000216

July 23, 2021

Type: HAA Polyester

POWDER PROPERTIES

| | | |
|-------------------|-------------------------|-----------------------------|
| ASTM D5965-96, C | Specific Gravity | 1.56 ±0.05 |
| | Theoretical Coverage | 123 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° | 85+ |
| 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 @ 400°F

FILM THICKNESS: *2.0-3.0 Mils*

Prepared 9/13/2021

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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