



Alesta®

RLY604S8

Primer CAT Yellow LC

Revised: 9 September 2021

Application: Long Term Corrosion Protection Coating

Alesta Group Code:

DESCRIPTION

Alesta® Product No. RLY-604-S8 is a low cure thermosetting Epoxy-polyester hybrid designed with extended corrosion protection. When compared in similar outdoor, corrosive conditions to standard grade powder coatings of similar chemistry and specific gravity, it will provide extended corrosion protection. * Note: PCI, Orange Peel of a Caterpillar approved topcoat applied at 2.5 mils minimum over primer and applied following TDS instructions.

TYPICAL POWDER PROPERTIES

Color:	Yellow	Theoretical Coverage:	116 ft ² /lb/mil
Specific Gravity:	1.66 ± .05	Typical Gel Time:	33 sec ± 10% @ 204°C (400°F)
Cyclic Corrosion Resistance:		Recommended Shelf Life	12 Months
SAE J2334, 20 cycles	Pass 1E2731	@ 25°C (77°F)	
		@ 50% RH	
Mass Loss during Cure:	< 1%		
ASTM D2351			

* Transportation: The material is stable during transportation at temperatures below 25°C (77°F) and 50% RH.

* After opening, storage of powder should be in a closed container. Recertification of material is available after 12 months from manufacturing date.

TYPICAL PROPERTIES OF APPLIED FILM*

<u>TEST / REQUIREMENT</u>	<u>METHOD</u>	<u>RESULT</u>
Pencil Hardness:	ASTM D3363	2H
Direct/Rev Impact, Gardner:	ASTM D2794	160/160 in.lbs.
Elongation Flexible Mandrel:	ASTM 522 Method A	32% at MAX Elongation, no Fracture
Adhesion, Cross Hatch:	ASTM D3359, Method B	5B, Topcoat to Primer (Intercoat) 5B, Primer to Substrate
Gloss @ 60°:	ASTM D523	85+
*PCI Powder Smoothness:	ACS TM 10.219	7
*Orange Peel:	ACT Visual Standards	6
Salt Spray:	ASTM B117	1,000 hrs
Steel Enclosures, Elect. Eq:	UL DTOV2 Organic Coating	Recognized



Overbake Resistance, Time: ASTM D2454 100%

Substrate: Reference materials per 1E4093.

GENERAL APPLICATION PARAMETERS

Application: Electrostatic Spray, Cold
Substrate Recommendation: Cold Rolled Steel

Standard Primer using a Caterpillar approved topcoat:

- Apply under a Caterpillar approved topcoat at the recommended thickness.
- Fully or partially cure following recommended schedules.
- Apply topcoat powder at recommended thickness.
- Fully cure topcoat + primer system following recommended schedules.

****CAUTION**** Total oven residency time will vary depending on substrate, substrate thickness, and oven heat-up rate.

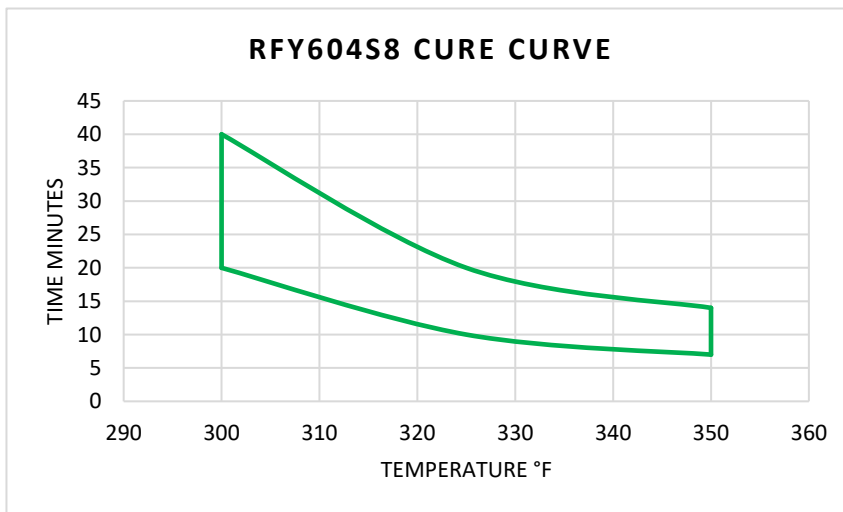
CURE SCHEDULE GUIDELINES

The cure schedule when applied direct to metal shows the minimum time at temperature required to achieve the typical performance properties of the coating.

Substrate Type	Application System	Recommended Total Film Thickness (mils)	Cure type	Cure Schedule (Time at Substrate Temperature)	
Cold Rolled Steel	Primer only (DTM)	1.5 – 2.5	Full	7 min	350°F
				10 min	325°F
				20 min	300°F

For two-layer systems please refer to the recommended cure schedule for the topcoat as listed in the TDS.

****CAUTION**** Maximum DFT (Dry Film Thickness) without lowering coating performance is 2.5 mils (0.063 mm) for primer only; 5.0 mils (0.127 mm) for primer with topcoat



Always consult product Material Safety Data (MSDS) prior to handling.

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