

Number: HFA627M4

Name: RAL 9006 MINI TEX

Alesta Group Code: SD45207000016

July 8, 2021

Type: HAA Polyester

### POWDER PROPERTIES

ASTM D5965-96, C	Specific Gravity	1.49 ±0.05
	Theoretical Coverage	129 ft <sup>2</sup> /lb/mil
ASTM D3451-92, 13	Mass Loss During Cure	< 1%
	Recommended Shelf Life:	12Months @ 75°F

### COATING PROPERTIES

ASTM D523-89	Gloss at 60°	35-45
DPC TM 10.219	PCI Powder Smoothness	N/A
ASTM D2454-95	Overbake Resistance, Time	100%
ASTM D3363-92a	Pencil Hardness	H
ASTM D2794-93	Dir / Rev Impact, Gardner	20 / 0 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
AAMA 2603-05	Organic Coatings on Aluminum Extrusions	Passed

### APPLICATION

Electrostatic Spray, Cold  
Substrate: Aluminum  
Pretreatment: Chrome Phosphate

**CURE SCHEDULE:**  
(Time at substrate temperature)  
10 Minutes @ 400°F

**FILM THICKNESS:** 2.5-3.5 Mils

Recommended for use in architectural applications such as window frames, cladding, shopfronts and other products where enhanced levels of exterior weatherability are required. This product meets requirements for AAMA 2604 as per the American Architectural Manufacturers Association and is based on proven polyester technology used globally in architectural

Prepared 7/8/2021

### ROHS

9800 Genard Rd. Houston, TX 77041-7624 1-800-247-3886 fax: 713-939-4027  
4130 Lyman Dr. Hilliard, OH 43026-1213 1-800-667-9610 fax: 614-771-4139



ISO 9001:2015

WARRANTY POLICY: Seller certifies that all coatings delivered to Customer in unopened factory filled containers meet all pertinent quality standards presented in its current published literature. Since matters of surface preparation, application procedures, curing procedures and other local factors that affect coating performance are beyond Seller's control, Seller assumes no liability for coating failure other than to supply replacement material for a coating material proven to be defective. Customer will determine suitability of this product for its use and thereby assume all risks and liabilities in connection therewith. Seller will not be liable for any injuries, damages or other losses derived, directly or indirectly, from or as a consequence of Customer's use of the product. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, RELATING TO ITS PRODUCTS AND THEIR APPLICATION, INCLUDING BUT NOT LIMITED TO WARRANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSES.

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*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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