

## TECHNICAL DATA SHEET

**Product Series:** Super Durable Polyester [SD]

**Revision Date:** May 18, 2026

### 1. PRODUCT IDENTIFICATION

- **Product Name:** RAL 1000 - Green Beige - Glossy
- **Product Code:** SD-1000-000-80-SM-R
- **Color:** Yellow
- **Resin Type:** Super Durable Polyester [SD]
- **Finish:** Smooth

### 2. PHYSICAL PROPERTIES

| Property            | Test Method  | Result                           |
|---------------------|--------------|----------------------------------|
| Gloss at 60°        | ASTM D523    | "Glossy" [70GU - 90GU]           |
| Specific Gravity    | Theoretical  | 1.5±0.1 g/cm <sup>3</sup>        |
| Adhesion            | ASTM D3359   | 100% (5B)                        |
| Hardness            | ASTM D3363   | 1H - 2H Minimum                  |
| Impact Resistance   | ASTM D2794   | 80 - 100 in-lbs (Direct/Reverse) |
| Salt Spray          | ASTM B117-16 | 2000+ Hours                      |
| Humidity Resistance | ASTM D2247   | 2000+ Hours                      |
| Chemical Resistance | Internal     | Excellent                        |

### 3. APPLICATION & CURING

#### Application Parameters

- **Method:** Corona
- **Recommended Film Thickness:** 2.0 – 3.0 mils
- **Theoretical Coverage:** 110 sq.ft/lb/mil

#### Curing Schedule (Metal Temperature)

- **Temperature:** 200C [400F]
- **Time:** 10min
- *Note: Substrate thickness may require adjusted oven dwell time.*

### 4. STORAGE & SHELF LIFE

- **Conditions:** Store in a cool, dry environment.
- **Temperature:** Do not exceed 27°C (80°F).
- **Shelf Life:** 12–24 months from date of manufacture if stored correctly.

### 5. IMPORTANT NOTICE

The technical data provided is based on laboratory testing and raw material supplier data. Kroma Coatings Technology LLC provides this information in good faith but offers no express or implied warranty regarding performance or suitability for a specific application. Results are dependent on substrate preparation and application conditions.

## 6. COMPANY CONTACT

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