

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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|                |          |
|----------------|----------|
| <b>Number:</b> | RAL1003  |
| <b>Name:</b>   | RAL 1003 |
| <b>Type:</b>   | TGIC     |

## Powder Properties

|                              |                      |
|------------------------------|----------------------|
| <b>Specific Gravity</b>      | Approx. 1.55         |
| <b>Storage Temp</b>          | 80°F (27°C)          |
| <b>Theoretical Coverage</b>  | 139 sq. ft./lb/1 mil |
| <b>Particle Distribution</b> | n/a                  |

## Coating Properties

|                        |                                                                                  |
|------------------------|----------------------------------------------------------------------------------|
| <b>Film Thickness</b>  | Recommended film thickness 2.5 to 3.5 mils                                       |
| <b>Cure Schedule</b>   | 10min @ 392°F/200°C<br>25min @ 356°F/180°C                                       |
| <b>Gloss Level</b>     | 80 - 95 units on 60°                                                             |
| <b>Pencil Hardness</b> | H - 2H (ASTM D3363)                                                              |
| <b>Flexibility</b>     | n/a                                                                              |
| <b>Adhesion</b>        | 5B                                                                               |
| <b>Direct Impact</b>   | 80 in-lb direct;                                                                 |
| <b>Reverse Impact</b>  | 80 in-lb reverse (ASTM D2794)                                                    |
| <b>Salt Spray</b>      | 1000 hrs less than 1/16" in creepage over B-1000 treated test panels (ASTM B117) |

[www.columbiacoatings.com](http://www.columbiacoatings.com)