

Columbia Coatings

Technical Data Sheet

Columbia Coatings
1173 Industrial Park Rd
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Number:	RAL1004
Name:	RAL 1004
Type:	TGIC

Powder Properties

Specific Gravity	Approx. 1.55
Storage Temp	80°F (27°C)
Theoretical Coverage	124 sq. ft./lb/1 mil
Particle Distribution	n/a

Coating Properties

Film Thickness	Recommended film thickness 2 to 3 mils
Cure Schedule	7 minutes at 400°F (204°C) or 10 minutes at 375°F (191°C) or 15 minutes at 350°F (177°C) (metal temperature)
Gloss Level	85 ± 3 units on 60°
Pencil Hardness	H - 2H (ASTM D3363)
Flexibility	1/8" (ASTM D522)(Conical Mandrel)
Adhesion	5B
Direct Impact	160 in-lb direct;
Reverse Impact	160 in-lb reverse (ASTM D2794)
Salt Spray	1000 hrs less than 1/16" in creepage over B-1000 treated test panels (ASTM B117)

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