

Columbia Coatings

Technical Data Sheet

Columbia Coatings
1173 Industrial Park Rd
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Number:	RAL1013
Name:	RAL 1013
Type:	TGIC

Powder Properties

Specific Gravity	Approx. 1.64
Storage Temp	80°F (27°C)
Theoretical Coverage	139 sq. ft./lb/1 mil
Particle Distribution	n/a

Coating Properties

Film Thickness	Recommended film thickness 2.5 to 3.5 mils
Cure Schedule	10min @ 392°F/200°C 25min @ 356°F/180°C (actual substrate temperature)
Gloss Level	85 - 100 units on 60°
Pencil Hardness	H - 2H (ASTM D3363)
Flexibility	n/a
Adhesion	5B
Direct Impact	80 in-lb direct;
Reverse Impact	80 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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