

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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<b>Number:</b>	RAL4006
<b>Name:</b>	RAL 4006
<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>	124 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>	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)
<b>Gloss Level</b>	85 ± 3 units on 60°
<b>Pencil Hardness</b>	H - 2H (ASTM D3363)
<b>Flexibility</b>	1/8" (ASTM D522)(Conical Mandrel)
<b>Adhesion</b>	5B
<b>Direct Impact</b>	160 in-lb direct;
<b>Reverse Impact</b>	160 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)

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