

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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|                |          |
|----------------|----------|
| <b>Number:</b> | RAL6028  |
| <b>Name:</b>   | RAL 6028 |
| <b>Type:</b>   | TGIC     |

## Powder Properties

|                              |                      |
|------------------------------|----------------------|
| <b>Specific Gravity</b>      | Approx. 1.58         |
| <b>Storage Temp</b>          | 80°F (27°C)          |
| <b>Theoretical Coverage</b>  | 122 sq. ft./lb/1 mil |
| <b>Particle Distribution</b> | n/a                  |

## Coating Properties

|                        |  |
|------------------------|--|
| <b>Film Thickness</b>  | Recommended film thickness 2.0 to 3.0 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>     | 1/16" (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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