

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
1173 Industrial Park Rd  
Columbia, TN 38401  
931-388-7730  
931-388-5573 FAX



<b>Number:</b>	RAL2004MATTE
<b>Name:</b>	RAL 2004 – Pure Orange - Matte
<b>Type:</b>	TGIC

## Powder Properties

<b>Specific Gravity</b>	Approx. 1.55 g/cm <sup>3</sup>
<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: 2.5–3.5 mils
<b>Cure Schedule</b>	Metal Temperature: 10 minutes at 400°F (204°C)
<b>Gloss Level</b>	25-35% @ 60°
<b>Pencil Hardness</b>	2H (ASTM D3363)
<b>Flexibility</b>	1/8" (ASTM D522) (Conical Mandrel)
<b>Adhesion</b>	5B (ASTM D3359)
<b>Direct Impact</b>	100 in-lb. direct (ASTM D2794)
<b>Reverse Impact</b>	100 in-lb. direct (ASTM D2794)
<b>Salt Spray</b>	1000 Hrs. Pass <1/8" Scribe Creep - No Blisters (ASTM B117)

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