

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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**COLUMBIA**  
 COATINGS

<b>Number:</b>	RAL3001
<b>Name:</b>	RAL 3001 – Signal Red
<b>Type:</b>	TGIC

## Powder Properties

<b>Specific Gravity</b>	Approx. 1.57 g/cm <sup>3</sup>
<b>Storage Temp</b>	< 77°F (25°C)
<b>Theoretical Coverage</b>	123 sq. ft/lb. @ 1 mil
<b>Particle Distribution</b>	n/a

## Coating Properties

<b>Film Thickness</b>	Recommended Film Thickness: 2–3 mils
<b>Cure Schedule</b>	Metal Temperature: 10 minutes at 400°F (204°C) -or- 10 minutes at 340°F (171°C)* 6 minutes at 360°F (182°C)* 3 minutes at 400°F (204°C)* *Low-Temp cure curve
<b>Gloss Level</b>	85-100% @ 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>	160 in-lb. direct (ASTM D2794)
<b>Reverse Impact</b>	160 in-lb. direct (ASTM D2794)
<b>Salt Spray</b>	1000 Hrs. Pass <1/8" Scribe Creep - No Blisters (ASTM B117)

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