

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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**COLUMBIA**  
COATINGS

|                |          |
|----------------|----------|
| <b>Number:</b> | F1793071 |
| <b>Name:</b>   | Dark Sea |
| <b>Type:</b>   | TGIC     |

## Powder Properties

|                              |                                      |
|------------------------------|--------------------------------------|
| <b>Specific Gravity</b>      | 1.36 ( $\pm$ 0.05) g/cm <sup>3</sup> |
| <b>Storage Temp</b>          | < 80°F (27°C)                        |
| <b>Theoretical Coverage</b>  | 141.39 ft <sup>2</sup> /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:<br>20 minutes @ 350°F (177°C)<br>15 minutes @ 375°F (191°C)<br>10 minutes @ 400°F (204°C) |
| <b>Gloss Level</b>     | 90+% @ 60°   |
| <b>Pencil Hardness</b> | H (ASTM D3363)   |
| <b>Flexibility</b>     | 1/8" (ASTM D522) (Conical Mandrel)   |
| <b>Adhesion</b>        | 100% (ASTM D3359)  |
| <b>Direct Impact</b>   | 40/40 or better (ASTM D2794)   |
| <b>Reverse Impact</b>  | 40/40 or better (ASTM D2794)   |
| <b>Salt Spray</b>      | 1/16" creep @ 500 hrs. (ASTM B117)   |

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