

Columbia Coatings

Technical Data Sheet

Columbia Coatings
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Number:	U4191037
Name:	Illusion Autumn
Type:	Hybrid

Powder Properties

Specific Gravity	1.23 (\pm 0.05) g/cm ³
Storage Temp	< 80°F (27°C) up to 1 year
Theoretical Coverage	63 ft ² /lb. @ 2.5 mils
Particle Distribution	+44 MICRONS (325 MESH) 35 - 45%

Coating Properties

Film Thickness	Recommended Film Thickness: 3.5–4.5 mils
Cure Schedule	Partial Cure: 15 min. total time in oven preheated to 400°F. Then apply our Super Mirror Clear and fully cure. * This powder requires a clear coat for the Illusion Effect
Gloss Level	80% - 90% @ 60°
Pencil Hardness	H (ASTM D3363)
Flexibility	1/8" (ASTM D522)
Adhesion	5B (ASTM D3359)
Direct Impact	160 in-lb. direct (ASTM D2794)
Reverse Impact	160 in-lb. reverse (ASTM D2794)
Salt Spray	1000 hrs. less than 1/16" in creepage over B-1000 treated test panels (ASTM B117)

www.columbiacoatings.com