

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
12683 McIlwain Rd,  
Holladay, TN 38341  
931-388-7730  
931-388-5573 FAX



<b>Number:</b>	X5020039
<b>Name:</b>	Black Wrinkle Polyester
<b>Type:</b>	Polyester

## Powder Properties

<b>Specific Gravity</b>	1.44 +/- 0.05
<b>Storage Temp</b>	12 months @ 75°F (24°C)
<b>Theoretical Coverage</b>	134 ft <sup>2</sup> /lb./mil
<b>Particle Distribution</b>	n/a

## Coating Properties

<b>Film Thickness</b>	2.0 – 3.0 mils
<b>Cure Schedule</b>	Metal Temperature: <ul style="list-style-type: none"><li>• 10 min @ 400°F</li><li>• 15 min @ 375°F</li><li>• 20 min @ 350°F</li></ul>
<b>Gloss Level</b>	visual
<b>Pencil Hardness</b>	H-2H
<b>Flexibility</b>	1/8 in. dia., no fracture
<b>Adhesion</b>	5B
<b>Direct Impact</b>	120 in/lb.
<b>Reverse Impact</b>	120 in/lb.
<b>Salt Spray</b>	1000 hrs.