

Columbia Coatings

# Technical Data Sheet

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



<b>Number:</b>	RAL3031
<b>Name:</b>	RAL 3031 – Orient Red
<b>Type:</b>	Polyester

<b>Specific Gravity</b>	Approx. 1.56 g/cm <sup>3</sup>
<b>Storage Temp</b>	< 80°F (27°C)
<b>Theoretical Coverage</b>	123 sq. ft/lb. @ 1 mil
<b>Particle Distribution</b>	n/a

## Powder Properties

<b>Film Thickness</b>	Recommended Film Thickness: 2.5–3.5 mils
<b>Cure Schedule</b>	Metal Temperature: 7 minutes @ 400°F (204°C) or 10 minutes @ 375°F (191°C) or 15 minutes @ 350°F (177°C)
<b>Gloss Level</b>	85% ± 3% @ 60°
<b>Pencil Hardness</b>	H - 2H (ASTM D3363)
<b>Flexibility</b>	3/16" (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. reverse (ASTM D2794)
<b>Salt Spray</b>	1000 hrs. less than 1/16" in creepage over B-1000 treated test panels (ASTM B117)

## Coating Properties