

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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|                |                |
|----------------|----------------|
| <b>Number:</b> | CS1695077      |
| <b>Name:</b>   | Black Dawn     |
| <b>Type:</b>   | TGIC Polyester |

## Powder Properties

|                              |                                |
|------------------------------|--------------------------------|
| <b>Specific Gravity</b>      | Approx. 1.23 g/cm <sup>3</sup> |
| <b>Storage Temp</b>          | < 80°F (27°C)                  |
| <b>Theoretical Coverage</b>  | 156 sq. ft/lb. @ 1 mil         |
| <b>Particle Distribution</b> | n/a                            |

## Coating Properties

|                        |                                                             |
|------------------------|-------------------------------------------------------------|
| <b>Film Thickness</b>  | Recommended Film Thickness: 3–5 mils                        |
| <b>Cure Schedule</b>   | Metal Temperature:<br>20 minutes at 375°F (191°C)           |
| <b>Gloss Level</b>     | 95+% @ 60°                                                  |
| <b>Pencil Hardness</b> | 4H (ASTM D3363)                                             |
| <b>Flexibility</b>     | 1/8" (ASTM D522) (Conical Mandrel)                          |
| <b>Adhesion</b>        | 5B (ASTM D-3359)                                            |
| <b>Direct Impact</b>   | 100 in-lb. direct (ASTM D2794)                              |
| <b>Reverse Impact</b>  | 100 in-lb. direct (ASTM D2794)                              |
| <b>Salt Spray</b>      | 1000 Hrs. Pass <1/8" Scribe Creep - No Blisters (ASTM B117) |

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