

Columbia Coatings

Technical Data Sheet

Columbia Coatings
1173 Industrial Park Rd
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Number:	RAL7004
Name:	RAL 7004 – Signal Grey
Type:	Polyester

Powder Properties

Specific Gravity	Approx. 1.65 g/cm ³
Storage Temp	< 80°F (27°C)
Theoretical Coverage	117 sq. ft/lb. @ 1 mil
Particle Distribution	n/a

Coating Properties

Film Thickness	Recommended Film Thickness: 2 – 3 mils
Cure Schedule	Metal Temperature: 7 minutes @ 400°F (204°C) or 10 minutes @ 375°F (191°C) or 15 minutes @ 350°F (177°C)
Gloss Level	85% ± 3% @ 60°
Pencil Hardness	H - 2H (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)

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