

Columbia Coatings

Technical Data Sheet

Columbia Coatings
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COLUMBIA
COATINGS

Number:	MLS170801
Name:	Philadelphia Union Gold
Type:	Polyester

Powder Properties

Specific Gravity	1.65 ($\pm$ 0.05) g/cm ³
Storage Temp	< 80°F (27°C) up to 1 year
Theoretical Coverage	71.5 ft ² /lb. @ 2 mils
Particle Distribution	25 - 50 MICRONS AVERAGE

Coating Properties

Film Thickness	Recommended Film Thickness: 2 – 3 mils
Cure Schedule	Metal Temperature: 10 minutes @ 400°F (204°C)
Gloss Level	Approx. 20% @ 60°
Pencil Hardness	H – 2H (ASTM D3363)
Flexibility	100% (ASTM D522)
Adhesion	4B (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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