

Columbia Coatings

# Technical Data Sheet

Columbia Coatings  
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<b>Number:</b>	U4198033
<b>Name:</b>	Illusion Doublon
<b>Type:</b>	Hybrid

## Powder Properties

<b>Specific Gravity</b>	1.2 – 1.8 g/cm <sup>3</sup>
<b>Storage Temp</b>	6 months @ 77°F (25°C)
<b>Theoretical Coverage</b>	51.5 ft <sup>2</sup> /lb. (11.1 m <sup>2</sup> /kg)
<b>Particle Distribution</b>	n/a

## Coating Properties

<b>Film Thickness</b>	Recommended Film Thickness: 2 – 3 mils
<b>Cure Schedule</b>	Partial Cure: 15 min. total time in oven preheated to 400°F. Then apply our Super Mirror Clear and fully cure. * This powder requires a clear coat for the Illusion Effect
<b>Gloss Level</b>	80 – 90% @ 60°
<b>Pencil Hardness</b>	2H minimum
<b>Flexibility</b>	1/8" Mandrel
<b>Adhesion</b>	5B
<b>Direct Impact</b>	80 in/lb.
<b>Reverse Impact</b>	n/a
<b>Salt Spray</b>	1/32 in. (1mm) @ 500 hours

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