

TECHNICAL DATA SHEET

Product Series: Super Durable Polyester [SD]

Revision Date: May 18, 2026

1. PRODUCT IDENTIFICATION

- **Product Name:** RAL 8004 - Copper Brown
- **Product Code:** SD-8004-000-40-SM-R
- **Color:** Brown
- **Resin Type:** Super Durable Polyester [SD]
- **Finish:** Smooth

2. PHYSICAL PROPERTIES

Property	Test Method	Result
Gloss at 60°	ASTM D523	"Satin" [30GU-50GU]
Specific Gravity	Theoretical	1.5±0.1 g/cm ³
Adhesion	ASTM D3359	100% (5B)
Hardness	ASTM D3363	1H - 2H Minimum
Impact Resistance	ASTM D2794	80 - 100 in-lbs (Direct/Reverse)
Salt Spray	ASTM B117-16	2000+ Hours
Humidity Resistance	ASTM D2247	2000+ Hours
Chemical Resistance	Internal	Excellent

3. APPLICATION & CURING

Application Parameters

- **Method:** Corona
- **Recommended Film Thickness:** 2.0 – 3.0 mils
- **Theoretical Coverage:** 110 sq.ft/lb/mil

Curing Schedule (Metal Temperature)

- **Temperature:** 200C [400F]
- **Time:** 10min
- *Note: Substrate thickness may require adjusted oven dwell time.*

4. STORAGE & SHELF LIFE

- **Conditions:** Store in a cool, dry environment.
- **Temperature:** Do not exceed 27°C (80°F).
- **Shelf Life:** 12–24 months from date of manufacture if stored correctly.

5. IMPORTANT NOTICE

The technical data provided is based on laboratory testing and raw material supplier data. Kroma Coatings Technology LLC provides this information in good faith but offers no express or implied warranty regarding performance or suitability for a specific application. Results are dependent on substrate preparation and application conditions.

6. COMPANY CONTACT

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