



# PPG Coil Coatings Product Data Sheet

PPG INDUSTRIES, INC., COATINGS AND RESINS, 125 COLFAX STREET, SPRINGDALE, PENNSYLVANIA 15144

Product: COIL CORAFLO® XL (3-coat)

Location: Springdale, PA

Suggested Use: A high-performance fluoropolymer finish designed for roll-coat application over properly cleaned, pretreated and primed Hot Dip Galvanized, GALVALUME® or Aluminum.\*

## PRODUCT DESCRIPTION (As Shipped)

Viscosity: 25 to 45 Sec.# 4 Zahn cup@ 77°F (25°C)

Flash Point 108°F (42°C) (Pensky-Martens)

Wt/Gal. 8.5-10.6\*\* +/- 0.20 lbs. (Kg./Lit. 1.0 - 1.3 +/- 0.09 kg.)

VOC # /Gal = ~4.50- 5.0 (0.54-0.58 kg/lit.)

Theor. Solids by Wt % 44-53 +/- 2.00

Contains Lubricant No

Theor. Solids by Vol % 32-35 +/- 1.50

Color Color

## PHYSICAL PROPERTIES

Gloss: 20-70\*\* @ 60° / N/A @ 85°

Hardness: HB-H Eagle Turquoise

Film Thickness: .70-.80 mils Dry      1.90 – 2.30 mils\*\* Wet  
(17-19 Microns Dry)                      (46-55 Microns Wet)

Cure Test: 50+ Double MEK Rubs

Reverse Impact: 1.5-3X Metal Thickness - No Pickoff

Flexibility: 0T-2T Bend: no pickoff

## SUGGESTED APPLICATION DATA

Substrate: HDG, GALVALUME®, or Aluminum\*

Reducer: Solvesso 150 / Butyl Cellosolve @ 2/1

Surface Preparation: Contact Pretreatment Supplier for Product

Clean Up: Solvesso 150/MIBK 1/1

Primer: Primer is System Dependent

Coverage/Gal: 660-790\*\*      Sq. Ft. @ .70-.80 Mils  
Coverage/Lit.: 16.2 - 19.4      m<sup>2</sup> @ 17-19 Microns

## LABORATORY CURE\*

Peak Metal Temp. 410-420°F base-coat cure  
(210-216°C base-coat cure)  
450-465°F clear-coat cure\*\*\*  
(232-241°C clear-coat cure\*\*\*)

Oven Temp. As Required      Substrate Time At Temp. 5-10 seconds

*\*Peak metal temperature may vary due to dwell time. Line oven temperature and dwell time must be correlated with laboratory cure schedule.*

Additional Information: \*Primer/Substrate Variations May Require Multiple Codes.

\*\*Depending on Color.

\*\*\*Requires Clear Coat.

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