



# PPG Coil Coatings Product Data Sheet

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

Product: COIL DURANAR® XL Metallic (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 88°F (31°C) (Pensky-Martens)

Wt/Gal. 9.8-10.6\*\* +/- 0.20 lbs. (Kg./Lit. 1.2 - 1.3 +/- 0.09 kg.)

VOC # / Gal = ~5.0 (0.60 kg/lit.)

Theor. Solids by Wt % 48-53 +/- 2.00

Contains Lubricant No

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

Color Color

## PHYSICAL PROPERTIES

Gloss: 15-35\*\* @ 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: Butyl Cellosolve / Butyl Cellosolve Acetate

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-.85 Mils  
Coverage/Lit.: 16.2-19.4      m<sup>2</sup> @ 17-19 Microns

## LABORATORY CURE\*

Peak Metal Temperature 465°F-480°F      Oven Temperature As Required      Substrate Time At Temperature 5-10 seconds  
(241°C-249°C)

*\*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.

NOTE: Statements and methods described herein are based upon the best information and practices known to PPG Industries, Inc. However, procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance or results, nor does PPG Industries, Inc. warrant freedom from patent infringement in the use of any formula or process set forth herein.