

# PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

PPG INDUSTRIES, INC., ONE PPG PLACE, PITTSBURGH, PENNSYLVANIA 15272

Product: SPRAY CORAFLON® (2-coat)

Location: Springdale C&R

Suggested Use: A high-performance fluoropolymer finish for architectural aluminum extrusions and panels.

### PRODUCT DESCRIPTION

As shipped: Viscosity 25-45 sec # 4 Ford +/- 15 sec @ 77°F (25°C)      Kg./Lit. 1.1 - 1.3 +/- 0.1 kg.  
 Wt./Gal. 9.00 - 10.50 +/- 0.3 lbs.

Non-Volatile: 50.0 – 63.0 +/- 1.5 % by weight      40 - 50 +/- 1.5 % by volume

Hardness: F min.

Gloss: 20-80 (60°)

Other: Theoretical package VOC 4.0 – 5.5 lbs./gal. (0.48 - 0.66 kg./lit.) (not measured)

### SUGGESTED APPLICATION DATA

Substrate Aluminum

Basecoat UC50190 Inhibitive primer

Substrate Preparation: Conversion coating at 40-90 mg/sq ft. (3.7 - 8.4 mg/m<sup>2</sup>) Applied per ASTM D1730, Type B, Method 5 or 7. Processing per ASTM B449, Sec. 5

### APPROXIMATE REDUCTION

### REDUCED PRODUCT

<u>Application Method</u>	<u>Type Reducer</u>	<u>Parts Product</u>	<u>Parts Reducer</u>	<u>Application Viscosity</u>	<u>Per Cent Solids</u>
Conventional/ Electrostatic spray	MIBK Xylene, Butyl Carbitol	As required			

Recommended Dry Film Thickness 1.25 - 1.50 Mils  
(30-36 Microns)

Recommended Wet Film Thickness 3.0 - 5.0 Mils  
(72-120 Microns)

Theo. Coverage 600-700 sq. ft./Gal. @ 1.25-1.50 Mils Dry  
14.7 - 17.2 m<sup>2</sup>/Lit. @ 30-36 Microns

Xylene  
Clean up Solvent MEK/MIBK

### CURE SCHEDULES

<u>Bake *</u>	<u>Type Oven</u>	<u>Oven Temp.</u>	<u>Oven Time</u>	<u>Substrate Temp.</u>	<u>Substrate Time at Temp.</u>
	Gas or electric	400°F (204°C)	7 to 10 min.*	400°F (204°C)	2 to 3 min.

Additional Information:

\* Oven time and/or temp. may vary based on metal thickness and mass. Agitate well before and during use to ensure uniformity.

### OBSERVE ALL LABEL WARNINGS AND PRECAUTIONS.

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