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® XL (3-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: 53.0 – 63.0 +/- 1.5 % by weight 40 - 50 +/- 1.5 % by volume

Hardness: F min. Gloss: 20-80 (60°)

Other: Theoretical package VOC 4.5 – 5.5 lbs./gal. (0.54 - 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^2) Applied per ASTM D1730, Type B, Method 5 or 7. Processing per ASTM B449, Sec. 5

APPROXIMATE REDUCTION			REDUCED PRODUCT		
Application Method	Type Reducer	Parts Product	Parts Reducer	Application Viscosity	Per Cent Solids
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^2/Lit. @ 30-36 Microns
Clean up Solvent Xylene MEK/MIBK

CURE SCHEDULES

Bake	Type Oven	Oven Temp.	Oven Time	Substrate Temp.	Substrate Time at Temp.
*	Gas or electric	350-370°F (177-188°C) Color-coat 400°F (204°C) Clear-coat**	7 to 10 min.* 7 to 10 min.*	350-370°F or 400°F 177-188°C or 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.
** Requires Clear Coat.

OBSERVE ALL LABEL WARNINGS AND PRECAUTIONS.