

PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: SPRAY DURANAR® (2-coat)

Location: Springdale C&R

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

PRODUCT DESCRIPTION

As shipped: Viscosity 50-105 sec # 4 Ford +/- 15 sec @ 77°F (25°C) Kg./Lit. 1.08 - 1.26 +/- 0.09 kg.
Wt./Gal. 9.00 - 10.50 +/- 0.2 lbs.

Non-Volatile: 35.0 - 47.0 +/- 1.5 % by weight 24 - 30 +/- 1.5 % by volume

Hardness: F min.

Gloss: 25-35 (60°)

Other: Theoretical package VOC 5.4 – 5.8 lbs./gal. (0.65 - 0.69 kg./lit.) (not measured)

SUGGESTED APPLICATION DATA

Substrate Aluminum

Basecoat UC50190 or UC51742 primer

Substrate Preparation: Conversion coating at 40-90 mg/sq ft. (3.7 - 8.4 mg/m²) 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 Toluol, Butyl Carbitol	As required			

Recommended Dry Film Thickness 1.0 - 1.2 Mils
(24-29 Microns)

Recommended Wet Film Thickness 4.0 - 5.0 Mils
(96-120 Microns)

Theo. Coverage 400-460 sq. ft./Gal. @ 1.0 Mils Dry
9.8 - 11.3 m²/Lit. @ 24 Microns

Clean up Solvent xytol or toluol

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	475°F (246°C)	10 min.*	450 °F (232°C)	5 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.

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.