

PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: MACROFLEX™ RTS (Ready-To-Spray)

Location: Springdale C&R

Suggested Use: A flexible polyester for post-fabrication in the RV extrusion finish/van, bus and truck window markets.

PRODUCT DESCRIPTION

As shipped: Viscosity 26 sec # 2 Zahn +/- 2 sec @ 77°F (25°C) Kg./Lit. 0.96 - 1.32 +/- 0.02 kg.
Wt./Gal. 8.0 - 11.0 +/- 0.2 lbs.

Non-Volatile: 35 - 60 +/- 1.5 % by weight 27 - 42 +/- 1.5 % by volume

Hardness: F-H Gloss: 20-90 (whites) 20-45 (colors) (60°)

Other: Must pass 30 minutes boiling water.

SUGGESTED APPLICATION DATA

Substrate Aluminum

Basecoat None

Substrate Preparation: Conversion coating at 30 mg/sq ft. min. (3.2 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 | READY TO SPRAY | | | | |

Recommended Dry Film Thickness 1.0 - 1.2 Mils
(25.4 - 30.5 Microns)

Recommended Wet Film Thickness 2.5 - 3.0 Mils
(63.5 - 76.2 Microns)

Theo. Coverage 433-675 sq. ft./Gal. @ 1.0 Mils Dry
10.6 - 16.5 m²/Lit. @ 25.4 Microns

Clean up Solvent xylol

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 convection | 400°F (204°C) | 10 min.* | | |

Additional Information: * Must pass 40 double rubs with xylox. Test will exhibit rub-off and dulling but film should not be removed to substrate. Bake time and/or temp. may vary based on metal thickness and mass. Recoat may adversely affect flexibility. Agitate well before and during use to ensure uniformity. Flexibility and recoat requirements to be established by customer for shapes and bending operations.

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.