



PPG Coil Coatings Product Data Sheet

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

Product: TRUFORM® HS

Location: Springdale, PA

Suggested Use: A thermosetting polyester paint designed for roll-coat application over properly cleaned, pretreated and primed Hot Dip Galvanized, GALVALUME®, Aluminum or CRS. TRUFORM HS is designed for applications requiring 2T bend flexibility, moderate durability and low cost. Applied cost is low due to its high volume solids. Typical applications include truck trailer and building panels due to its good stain and dirt resistance (cleanability). TRUFORM HS should not be used for applications requiring boiling water or dry heat resistance (use TRUDRAW for these applications).

PRODUCT DESCRIPTION (As Shipped)

Viscosity: 20 to 25 Sec.# 4 Zahn cup@ 77°F (25°C)

Flash Point 90°F (32.2°C) (Pensky-Martens)

Wt/Gal. 9.0-13.0 lbs/gallon (Kg./Lit. 1.07 - 1.56 kg.)

VOC # / Gal = 2.7 - 3.8 (0.32 - 0.46 kg/lit.)

Theor. Solids by Wt % 57-78 +/- 2.00

Contains Lubricant No

Theor. Solids by Vol % 49-64 +/- 1.50

PHYSICAL PROPERTIES

Gloss: 5-80+ @ 60° / N/A @ 85°

Hardness: H-3H Eagle Turquoise

Film Thickness: As required Dry

Cure Test: 100+ Double MEK Rubs*

Reverse Impact: ** 1½X MT:NPO aluminum
3X MT:NPO steel on 23 guage (.027")

Flexibility: **2T Bend : No Pickoff

SUGGESTED APPLICATION DATA

Substrate: Aluminum, HDG, Galvalume, CRS

Reducer: Butyl Cellosolve or Solvesso 150

Surface Preparation: As required

Clean Up: MEK

Primer:

Coverage/Gal: 1065-1360 Sq. Ft. @ 0.75 Mils
Coverage/Lit.: 98 - 127 m² @ 19.05 Microns

LABORATORY CURE*

Peak Metal Temperature 465°F-480°F Oven Temp. As Required Substrate Time At Temperature 5-10 seconds
(240-249°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: Peak metal temperature may vary due to dwell time. Six month shelf life from date of shipment.

**Results will vary with metal thickness and temper.

*MEK rubs will be lower if DFT is less than 0.65 mil and also if applied over B-902 CRS when no primer is present.

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.