

PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: DURACRON® 100

Location: Springdale C&R

Suggested Use: Conventional acrylic spray finish for properly pretreated aluminum extrusions and panels.

PRODUCT DESCRIPTION

As shipped: Viscosity 45-50 sec # 4 Ford +/- 3 sec @ 77°F (25°C) Kg./Lit. 1.20 - 1.32 +/- 0.02 kg.
Wt./Gal. 10 - 11 +/- 0.2 lbs.

Non-Volatile: 52 - 60 +/- 1.5 % by weight 33 - 40 +/- 1.5 % by volume

Hardness: H-2H Gloss: 10-100 (60°)

Other:

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

<u>Application Method</u>	<u>Type Reducer</u>	<u>Parts Product</u>
Conventional/ Electrostatic spray	Xylol,S-150, Toluol, Butyl Carbitol	27.5

REDUCED PRODUCT

<u>Application Viscosity</u>	<u>Per Cent Solids</u>
20-24 sec. #2 Zahn	

Recommended Dry Film Thickness 1.2 - 1.3 Mils
(30.5 - 33.0 Microns)

Recommended Wet Film Thickness 3.0 - 3.5 Mils
(76.2 - 88.9 Microns)

Theo. Coverage 530-640 sq. ft./Gal. @ 1.0 Mils Dry
13 - 15.7 m²/Lit. @ 25.4 Microns

Clean up Solvent xylol 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 convection	400°F (204°C)	10 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. Final reduction to be determined during trial run.

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.