



PPG Coil Coatings Product Data Sheet

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

Product: TRUDRAW®

Location: Springdale, PA

Suggested Use: A high molecular weight thermosetting polyester paint designed for roll-coat application over properly cleaned, pretreated and primed Hot Dip Galvanized, GALVALUME®, Aluminum or CRS. TRUDRAW is designed for applications requiring a high degree of flexibility, deep draw capability and applications requiring dry heat and boiling water resistance on tight bends such as screen frame and muntin bar. End uses include many drawn parts such as air vents, oil filters, oil pans, etc.

PRODUCT DESCRIPTION (As Shipped)

Viscosity: 25 to 30 Sec.# 4 Zahn cup@ 77°F (25°C)

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

Wt/Gal. 8.5-12.5 lbs/gallon (Kg./Lit. 1.01 - 1.50 kg.)

VOC # / Gal = 4.3 - 5.1 (0.51 - 0.61 kg/lit.)

Theor. Solids by Wt % 42.5-63 +/- 2.00

Contains Lubricant No

Theor. Solids by Vol % 35-46 +/- 1.50

PHYSICAL PROPERTIES

Gloss: 5-80+ @ 60° / N/A @ 85°

Hardness: H minimum

Film Thickness: As required Dry

Cure Test: 50+ Double MEK Rubs*

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

Flexibility: **0T NPO aluminum, CRS
0T NPO HDG, Galvalume

SUGGESTED APPLICATION DATA

Substrate: Aluminum, HDG, Galvalume, CRS

Reducer: Butyl Cellosolve or Solvesso 150

Surface Preparation: As required

Clean Up: MEK

Primer:

Coverage/Gal: 750-1000 Sq. Ft. @ 0.75 Mils
Coverage/Lit.: 69 - 93 m² @ 19.05 Microns

LABORATORY CURE*

Peak Metal Temperature 435°F-465°F Oven Temp. As Required
(224-241°C)

Substrate Time At Temperature 5-10 seconds

**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.