

# PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: MACROFLEX™

Location: Springdale C&R

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

## PRODUCT DESCRIPTION

As shipped: Viscosity 27 sec # 3 Zahn +/- 3 sec @ 77°F (25°C) Kg./Lit. 0.96 - 1.38 +/- 0.02 kg.  
Wt./Gal. 8.0 - 11.5 +/- 0.2 lbs.

Non-Volatile: 46 - 66 +/- 1.5 % by weight 38 - 47 +/- 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/m<sup>2</sup>) 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/	Xylol,	Paint - 12
Electrostatic spray	Solvesso 150	2

## REDUCED PRODUCT

<u>Application Viscosity</u>	<u>Per Cent Solids</u>
21-22 sec. #2 Zahn	

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 609-754 sq. ft./Gal. @ 1.0 Mils Dry  
14.9 - 18.5 m<sup>2</sup>/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 xylol. 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. Final reduction to be determined during trial run.

## OBSERVE ALL LABEL WARNINGS AND PRECAUTIONS.

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