

# PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: ACRYNAR®

Location: Springdale C&R

Suggested Use: A high performance fluoropolymer spray finish, that complies with AAMA 2604, for architectural aluminum extrusions and panels.

### PRODUCT DESCRIPTION

As shipped: Viscosity 55 sec # 4 Ford cup +/- 15 sec @ 77°F (25°C) Kg./Lit. 1.08 - 1.26 +/- 0.09 kg.  
Wt./Gal. 9.0 - 10.5 +/- 0.2 lbs.

Non-Volatile: 35 - 47 +/- 1.5 % by weight 24 - 30 +/- 1.5 % by volume

Hardness: F min.

Gloss: 15 - 35 (60°)

Other: Theoretical package VOC 5.4 – 5.8 lbs./gal. (0.65 – 0.69 kg./lit.) (not measured)

### SUGGESTED APPLICATION DATA

Substrate Aluminum

Basecoat UC68348 or UC51742 primer

Substrate Preparation: Conversion coating at 30 mg/sq ft. min. (2.8 mg/m<sup>2</sup>) 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	Xylol Butyl Carbitol	As required	As required	20-25 sec #2 Zahn	

Recommended Dry Film Thickness 1.0 - 1.2 Mils  
(24-29 Microns)

Recommended Wet Film Thickness 4.0 - 5.0 Mils  
(96-120 Microns)

Theo. Coverage 400-650 sq. ft./Gal. @ 1.0 Mils Dry  
9.8 - 11.3 m<sup>2</sup>/Lit. @ 24 Microns

Clean up Solvent xylol, 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 or electric	475°F (246°C)	10 min.*	450 °F (232°C)	5 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.  
ACRYNAR is a two-coat system that must be applied on either UC68348 or UC51742 primers. Must pass 100+ MEK double rubs without penetrating colorcoat down to primer.

### 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.