

# PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: POLYCRON®

Location: Springdale C&R

Suggested Use: A VOC compliant polyester spray finish for properly pretreated aluminum extrusions and panels.

## PRODUCT DESCRIPTION

As shipped: Viscosity 30 sec # 3 Zahn +/- 10 sec @ 77°F (25°C) Kg./Lit. 1.08 - 1.53 +/- 0.02 kg.  
Wt./Gal. 9.0 - 12.8 +/- 0.2 lbs.

Non-Volatile: 60 - 78 +/- 3.0 % by weight 55 - 68 +/- 3.0 % by volume

Hardness: H-3H Gloss: 20-80 (60°)

Other: Theoretical package VOC <3.5 lbs./gal. (<0.4 kg./lit.) (not measured)

## 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

### 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,S-150, Butyl Carbitol	As required	As required	As required	

Recommended Dry Film Thickness 0.9 - 1.3 Mils  
(22.9 - 33.0 Microns) Recommended Wet Film Thickness 1.5 - 3.0 Mils  
(38.1 - 76.2 Microns)

Theo. Coverage 880-1090 sq. ft./Gal. @ 1.0 Mils Dry  
21.5 - 26.7 m<sup>2</sup>/Lit. @ 25.4 Microns Clean up Solvent xylene or equivalent

## 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>
*	Convection	350°F (177°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.

## 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 FORMULAOR PROCESS SET FORTH HEREIN.