

PPG Product Data Sheet

TENTATIVE SPECIFICATIONS



ALUMINUM EXTRUSION COATINGS/COATINGS AND RESINS DIVISION

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

Product: SPRAY DURANAR® XL (3-coat)

Location: Springdale C&R

Suggested Use: A high-performance fluoropolymer finish for architectural aluminum extrusions and panels.
Must be topcoated with UC51132 Clear.

PRODUCT DESCRIPTION

As shipped: Viscosity 40-70 sec # 4 Ford +/- 15 sec @ 77°F (25°C) Kg./Lit. 1.09 - 1.15 +/- 0.09 kg.
Wt./Gal. 9.10 - 9.60 +/- 0.2 lbs.

Non-Volatile: 37.0 - 41.0 +/- 1.5 % by weight 25.5 - 26.5 +/- 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 UC50190 or UC51742 primer

Substrate Preparation: Conversion coating at 40-90 mg/sq ft. (3.7 - 8.4 mg/m²) 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	MIBK Toluol, Butyl Carbitol	As required			

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 400-420 sq. ft./Gal. @ 1.0 Mils Dry
9.8 - 10.3 m²/Lit. @ 24 Microns

Clean up Solvent xytol 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 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.

OBSERVE ALL LABEL WARNINGS AND PRECAUTIONS.

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