



## POWDER COATING

## Technical Data Sheet

### Highlights

A new, innovative patented addition to PPG's world-class fluoropolymer powder coatings for architectural aluminum extrusions. Coraflon® Platinum Powder Coat is a one-coat FEVE-based fluoropolymer that fully meets and exceeds AAMA 2605 specifications in all colors. Coraflon Platinum is the first high transfer efficiency fluoropolymer powder in the industry, offering first-pass transfer efficiency rate of 85% or better resulting in superior application build rates on aluminum extrusions. Coraflon Platinum Powder is available in a wide range of colors, glosses, surface effects, micas and bonded metallics.

### PRODUCT APPROVALS

Specifically formulated to meet the requirements of AAMA 2605.

### PRODUCT CHARACTERISTICS

- Extended gloss range (5-85%)
- 20%+ higher transfer efficiency
- Improved corrosion performance
- Formulated without the use of TGIC, BPA, or PFOA's

### TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated aluminum panels
Recommended Thickness	ASTM D 7091	2.0 - 3.0 mils
Curing Conditions	Metal Temperature	10 min @ 400 °F

For chemical resistance, Pass = No color change, no loss of adhesion, no blistering or no visual appearance change.

### PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 60°	ASTM D 523	55 - 65
Adhesion	ASTM D 3359	Dry: 100% (5B Pass) Wet: 100% (5B Pass) Boiling Water: 100% (5B Pass)
Hardness	ASTM D 3363	H Pencil Minimum (Eagle)
Impact - Direct	ASTM D 2794	40 in-lbs - No flaking
Impact - Reverse	ASTM D 2794	40 in-lbs - No flaking
Chemical Resistance		
Window Cleaner	10 drops for 24 hours	Pass
Mortar	24 hour pat test	Pass
Muriatic Acid	15 minute spot test	Pass
Nitric Acid	30 minute vapor test	Pass
Detergent Immersion	38C for 72 hours	Pass
Humidity	ASTM D 4585 @ 38° C	4000 hrs Blister rating - 8 minimum
Cyclic Corrosion	ASTM G 85, Annex A5	4000 hrs Blister rating - 8 minimum Scribe rating - 7 minimum





# CORAFLON® Platinum Powder Coat

Fluoropolymer

PCNT99335P - Daktronics Black

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Property	Test method	Value
Exterior Weathering		
South Florida Exposure	Minimum 10 Years	
EMMAQUA NTW	Minimum 2900 MJ	
Chalk resistance	ASTM D 4214A	Pass - No more than 8
Gloss Retention	ASTM D 523	Pass - Minimum 50%
Color Retention	ASTM D 2244	Pass - < 5.0 DE
Resistance to Errosion	ASTM B 244	Pass - Less than 10% film loss
Specific gravity	Calculated	1.62 ± .05
Theoretical coverage	Calculated	119 ft <sup>2</sup> /lbs at 1.0 mil 24.3 m <sup>2</sup> /kg at 25 μm



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### CURING WINDOW\* (object temperature)

See Cure Curve PCN-001

- 20 min @ 370 °F (188 °C)
- 15 min @ 380 °F (193 °C)
- 10 min @ 400 °F (204 °C)

\*Temperature and time to be adjusted to accomplish proper curing of coating. This can be achieved using infrared, convection, or combination ovens.

### STORAGE STABILITY

12 months at 77 °F maximum

Materials need to be stored in sealed plastic bags under dry and cool conditions. Do not expose to sunlight.

PPG recommends that all material be used in FIFO order (first in - first out). Materials that exceed the recommended shelf life should be tested prior to use.

### SUBSTRATE PREPARATION

Surface preparation should be chosen according to the type of substrate and required performance. The coater should test the suitability of the surface preparation before the application using appropriate test methods.

### APPLICATION RECOMMENDATIONS

Electrostatic Spray

Coating can be applied with automatic and manual devices.

Substrate should be correctly cleaned before use.

Do not mix this product with other powder coatings.

Color and finish influenced by film thickness: a good control of the film thickness will help the consistency of the aspect.

### HEALTH AND SAFETY

For comprehensive Health, Safety, and Environmental advice, please refer to the relevant Safety Data Sheets, and information printed on the product label.

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