



## **REWORK PROCEDURES FOR FACTORY APPLIED, BAKED ON FINISHES**

There are currently no set rework procedures for all the possible situations that may arise in the field. When refinishing a painted surface with exposed bare substrate, a determination must be made concerning the cleaning, pretreating and priming of the area prior to topcoat application. This usually depends on the size of the repair area, the factory applied system and the project location.

PPG Duracryl® acrylic lacquer is the recommended touchup for AAMA 2603 residential quality acrylics and polyesters (Duracron®, Polycron®, Duraform®). For AAMA 2605 quality Duranar® ADS or Corafon® ADS (Air Dry System) color coats must be used. For larger repair areas Corafon ADS should be considered and applied by a contractor. Acrylanar® is the Acrylic air dry additive to be used in Duranar® 1:1 or in Acrynar® 2:1 recommended for use over Duranar high bake liquid coatings for minor repairs and surface imperfections. Acrylanar does not have the performance quality of Duranar ADS and Corafon ADS and should only be used for minor touch ups.

## **FIELD TOUCH-UP PROCEDURES – Duracryl/Duranar ADS**

### **□ SURFACE PREPARATION**

- Surface must be clean, dry and free of foreign contaminants.
- Lightly scuff sand surface to be recoated, feathering edges at the damaged area.
- Remove sanding dust and other contaminants with solvent dampened, lint-free cloth or use tack cloths.
- Large areas of bare metal must be cleaned and pretreated with a field-applied conversion coating. For aluminum, use Alumiprep® #33 and Alodine® 1201 or equivalent. For HDG steel, use Metalprep® 79 and Galvaprep® SG or equivalent. The above pretreatment products are offered by The Henkel Pretreatment Co. Call 1-800-521-1355 for a distributor in your area. Apply according to label directions on manufacturer's containers.
- Applications down to bare metal require a primer, immediately prime any pretreated substrate with PPG Primer or the Corafon® ADS epoxy bonding primer (ADS 510 / ADS 512). Primers are available in chrome and chrome free (NIA) versions. Follow label directions closely.

### **□ APPLICATION OF TOUCH-UP ENAMEL**

- Ambient air temperatures and surface temperatures should be above 50° F for application of the paint and for a reasonable length of the initial drying period (24-hour minimum).
- Application is usually made with air spray equipment. Rolling and brushing does not provide a smooth film due to the drying speed of the touch-up type coatings, although it is possible for small scratches or minor defects.
- Multiple light passes to slowly build to the desired dry film thickness is recommended.

### **□ TOUCH-UP PRODUCT / REDUCTION**

- Follow specific instructions for the PPG product being used.



125 Colfax Street  
Springdale, PA 15144  
ppgmetalcoatings.com

- For Duracron, Polycron and Envirocron repairs Duracryl touch up materials that need to be matched in the same color as the original finish along with clear coats can be purchased directly from the locations below. Small application devices can also be ordered such as pencils and small brushes. Larger quantities can be ordered directly through PPG.

Custom Aerosol  
919 Louisiana Drive  
Celina, Texas 75009  
972-382-4321  
[www.custom-aerosol.com](http://www.custom-aerosol.com)

Custom-Pak Products, Inc.  
N118W18981 Bunsen Drive  
Germantown, WI 53002  
800 657-0847  
262 251-6180  
[info@custompakproducts.com](mailto:info@custompakproducts.com)

For touching up Duranar, Coraflon and Acrynar coatings only a fluoropolymer touch up should be used to assure similar weathering over time with the original coating. Either Duranar ADS or Coraflon ADS are recommended for liquid product lines. Duranar powder should be repaired with Duranar ADS and Coraflon powder should utilize Coraflon ADS for best adhesion properties.

### **Duranar ADS**

Nanochem  
1203 Kent Street  
Elkhart, IN 46514-1739  
574-970-2436  
<http://www.nanochemtechnologies.com/>

### **Coraflon ADS**

#### ***Coraflon Custom Matches/Panel Requests***

1-877-774-3131  
[Email-brcolormatching@ppg.com](mailto:Email-brcolormatching@ppg.com)

#### ***Ordering Coraflon***

Product takes 10 working to produce with a Coraflon color code.



# CORAFYLON™

 PPG High Performance Coatings

## Specification for Application of Coraflyon™ ADS to

### PVDF Kynar Resin & Duranar® Coated Surfaces

#### Surface Preparation

1. Solvent clean, per SSPC SP-1, substrate to remove any contamination that may be present.
2. Abrade substrate to remove gloss and to obtain a minimum surface profile of 1.0 mil for adhesion of the Coraflyon™ ADS. This can be accomplished by hand sanding with 120 - 220 grit sandpaper per SSPC SP-2 "Hand Tool Cleaning" or DA Sanding per SSPC SP-3 "Power-Tool Cleaning".
3. Care should be taken not to abrade the surface too aggressively as surface defects may be visible when coated.
4. Prior to coating, Solvent wipe substrate to remove dust and residual contamination

#### Primer Application

1. Apply one coat of Coraflyon™ ADS Epoxy Bonding Primer, ADS 510 / ADS 512, @ 2.0 – 3.0 mils DFT. Allow primer to cure 6 hours minimum before applying topcoat.

#### Coraflyon™ ADS Application

1. Apply one coat of Coraflyon™ ADS topcoat per instructions on the respective products *technical data bulletin*.
2. Coraflyon™ ADS Metallic coatings require a Coraflyon clear finish coat @ 1.5-2.0 mils DFT. The clear coat protects the aluminum pigmentation from ultra-violet degradation. Allow metallic topcoat to dry 4 hours minimum before top coating. Refer to technical data bulletin for complete product information.
3. Coraflyon™ ADS Mica coatings may require a base-coat applied before the Mica coat. The base-coat (ADS 650 Series @ 3 -5 mils) protects the epoxy primer from ultra-violet degradation. Full cure will be achieved in 3 – 5 days. Refer to technical data bulletin for complete product info.