125 Colfax Street
Springdale, PA 15144
ppgmetalcoatings.com

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 residential quality acrylics and polyesters (Duracron®, Polycron®, Duraform®). 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. It is not intended for any spray application. Duranar® ADS or Coraflon® ADS (Air Dry System) color coats must be used for larger repair areas and in some cases requires a primer.

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.
- For systems requiring a primer, immediately prime any pretreated substrate with PPG Duracryl® Primer (UC51760) or the Coraflon® ADS epoxy bonding primer (ADS 510 / ADS 512). 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

Custom-Pak Products, Inc.
N118W18981 Bunsen Drive
Germantown, WI 53002
800 657-0847
262 251-6180
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

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

125 Colfax Street
Springdale, PA 15144
ppgmetalcoatings.com

CORAFLON™
PPG High Performance Coatings

Specification for Application of Coraflon™ 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 Coraflon™ 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 Coraflon™ ADS Epoxy Bonding Primer, ADS 510 / ADS 512, @ 2.0 – 3.0 mils DFT. Allow primer to cure 6 hours minimum before applying topcoat.

Coraflon™ ADS Application

1. Apply one coat of Coraflon™ ADS topcoat per instructions on the respective products *technical data bulletin.*
2. Coraflon™ ADS Metallic coatings require a Coraflon 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. Coraflon™ 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.