

GENERAL INFORMATION

Substrate to be Hot Dipped Galvanized or Galvalume®. Manner of application to be a two coat roll coated system including a premium PVDF top coat over a properly cleaned and pre-treated substrate. Meets both Kynar 500 and Hylar 5000 Specifications.

SURFACE APPEARANCE

The surface is to be streak free and smooth with no blistering or other imperfections.

FILM THICKNESS

Topcoat finish consist of a primer with a dry film thickness of 0.20–0.30 mil. Primary topcoat shall have a dry film thickness of 0.70–0.80 mil. The reverse side of the panel shall have a primer coat with a dry film thickness of 0.20–0.30 mil and a pigmented backer coat with a dry film thickness of 0.30–0.40 mil. Total dry topside film thickness for the system shall be 0.90–1.10 mils. All measurements per accordance with ASTM D 1005.

CHALK RESISTANCE

No chalking greater than #8 rating per ASTM D 4214, Method ASTM D 659 test procedure after a 2000 hour weatherometer test.

COLOR CHANGE

Finish color coat change not to exceed 5 Hunter units per ASTM D 2244 test procedure, after 2000 hour weatherometer test.

ABRASION RESISTANCE

Per ASTM D 968, Method A, PVDF will pass 65±5 liters/mil, minimum of falling sand.

SPECULAR GLOSS

Specular gloss is to be determined per ASTM D 523 at a glossmeter angle of 60°. PVDF has a standard gloss range of approximately 20–35°.

HARDNESS

Minimum pencil hardness is HB to 2H, using Eagle Turquoise pencils per ASTM D 3363.

CURE TEST

PVDF will withstand 100 double rubs of an MEK soaked cloth before exposing primer coat per ASTM D 5402.

CROSS-HATCH ADHESION

No paint removal with cellophane tape after cross-scoring with eleven horizontal and eleven vertical lines 1/8" apart per ASTM D 3359.

DIRECT AND REVERSE

No visible paint removal with cellophane tape after direct and reverse impact of 80-inch pounds, using 5/8" steel ball on a Gardner Impact Tester (Not to include Zinc coating failures), per ASTM D 2794.

BEND ADHESION

Per ASTM D 4145, no loss of adhesion when taped with cellophane tape when subjected to a OT-2T diameter 180° bend test on 0.017" G-90 (grade D) galvanized steel or fabricator's roll forming operation. (Not to include Zinc failures).

HUMIDITY RESISTANCE

No blistering, cracking, peeling, loss of gloss or softening of the finish after 2000 hours of exposure to 100% humidity at 100°F ±5°F, per Federal Test Method Standard 141, Method 6201 or ASTM D 2247.

SALT SPRAY RESISTANCE

Samples diagonally scored and subjected to 5% neutral salt spray per ASTM B 117, then taped with cellophane tape: 1000 hours-no blistering, and no loss of adhesion greater than 1/8" from score line. Samples taped 1 hour after removal from test cabinet.

WEATHEROMETER TEST

No checking, blistering or adhesion loss of coating system after 2000 hours of accelerated weathering, per ASTM 822/G23.

FLAME SPREAD RATE

PVDF displays a flame spread classification of A (Class 1), when tested in accordance with ASTM E84.

CHEMICAL RESISTANCE

No significant color change after 24 hours exposure to 10% solutions of hydrochloric and sulfuric acids, per ASTM D 1308.

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