



54550 Series

Machine Applied Coatings

DURACOLOR™ FC Exterior Finish Acrylic Latex

GENERAL DESCRIPTION

Duracolor FC Finish is designed as an air-dry or force-dry coating to be applied to properly prepared and primed fibre cement board and trim.

Must be applied by approved machine application methods and only by Authorized Machine Operators.

Duracolor FC Exterior Finish can also be used for board end touch-ups during installation and trim application.

This product is not recommended for large touch-up areas.

APPROVED SUBSTRATES

Fibre Cement Board and Trim

LP® SmartSide® Trim & Siding

MiraTEC® Trim

GENERAL SURFACE PREPARATION

Proper surface preparation is essential. Surface must be clean and dry, remove all dust, dirt, oil, grease, mildew and any other surface contaminants.

Substrates should be checked for moisture content. All fibre cement to be coated must be below 15% moisture content.

New fibre cement should cure for at least 28 days prior to paint application and should be dry to the touch before coating.

Substrates should be primed by approved Machine Operators.

For new (unprimed) fibre cement boards, allow to age properly and dry thoroughly, then prime with a PPG alkali resistant primer.

LIMITATIONS OF USE

For use by Professional Authorized Machine Applicators only. This product is designed for application only by professional, trained personnel using proper equipment under controlled conditions and are not intended for sale to the general public.

Apply only when air, surface, and product temperatures are above 10°C (50°F) and at least 3°C (5°F) above the dew point.

Radiant Infrared heat or hot air convection ovens may be used to force dry this product. Care must be taken to avoid overheating so that blisters in the film do not form. If blistering occurs, premature failure of the finish may occur.

Not recommended for touch-up in large areas.

PROTECT FROM FREEZING.

PACKAGING

18.9 L

PRODUCT AND TINTING INFORMATION

Tintable Bases:

54550 White/Pastel Base

54551 Midtone Base*

54552 Deeptone Base*

54553 Deep Rustic Base*

***Must be tinted before use.**

Refer to appropriate PPG Colour formula book for tinting instructions.

Ready Mix Colours:

UC80172	Khaki	UC80173	Sand
UC80174	Granite	UC80175	Mist Gray
UC80177	Sage	UC80178	Country Red
UC80179	Blue	UC80180	Walnut
UC80181	Yellowstone	UC80182	Cream
UC80183	River Rock	UC80184	Almond
LV201007	Nickel (formerly Harbor Gray)		
LV201009	Red Mountain		
LV201241	Prairie Wheat (formerly Wheat)		

PRODUCT DATA

PRODUCT TYPE:	100% Acrylic Latex
SHEEN:	Flat: 5 to 10 (60° Gloss Meter) 10 to 25 (85° Gloss Meter)

VOLUME SOLIDS: 37% ± 2%

WEIGHT SOLIDS: 51% ± 2%

VOC: < 100 g/L

DENSITY: 1.3 kg/L

*Product data calculated on 54550.

COVERAGE PER 3.78 L: Approximately 28 m² (300 ft²) per 3.78 litres on primed, smooth, nonporous fibre cement board and trim.

Coverage figures do not include loss due to surface irregularities and porosity or material losses due to application method or mixing.

Theoretical Wet Film Thickness per Coat:** 132 microns
5.2 mils

Required Dry Film Thickness per Coat: 48 microns minimum
1.9 mils minimum.

**Additional wet film may be necessary in order to achieve the required dry film thickness.

Viscosity (Stormer @ 25°C): 62 - 70 Krebs Units***

***Manufacturing specification, working viscosity may vary

DRYING TIME: A minimum of 8 hours at 21°C (70°F) and 50% humidity is recommended for air drying. Drying times listed may vary depending on temperature, humidity, film build, colour, air movement, application equipment, and line conditions. Under suitable conditions the product may be forced dried.

CLEANUP: Remove as much product quantity as possible and clean equipment with lukewarm soapy water, high-pressure water jet, or steam cleaner immediately after use.

DISPOSAL: Consult your municipality in order to dispose of paint residues according to environmental regulations. Do not pour down a drain or storm sewer.

FLASH POINT: Over 93°C (200°F)

*Duracolor FC Exterior Finish Acrylic Latex***APPLICATION INFORMATION**

Mixing: Mix thoroughly before use. Mixing blades should be 1/3 the diameter of the paint vessel. The mixing blade should be at least 10 cm (4 in.) from the bottom of the vessel. The goal is to generate axial flow – or a rolling doughnut effect. Simple circular paint flow within a vessel will not generate a well-mixed product. Poor mixing can cause colour change within a paint run as well as varying degrees of paint hiding and performance.

Application Equipment: Machine Applied Coatings *Duracolor* is formulated to be applied by Authorized Machine Operators and should be applied using approved equipment under specific conditions. Contact your PPG Technical Service Department for any additional application guidelines and assistance.

Thinning: Thinning is not recommended.

General Application Requirements

Substrate and air temperature must be above 10°C (50°F). Paint temperature must be at least 10°C (50°F). Paint must be mixed thoroughly – see mixing instructions.

If possible, pre-heat substrate to 38–60°C (100–140°F) board surface temperature (BST) for up to 2.5 minutes. Apply 152–203 microns (6–8 mils) wet – depending on application equipment. Dry mils required 48–64 microns (1.9 - 2.5 mils).

*Wet mils applied must result in dry mils required.

**Theoretical Wet Film Thickness per Coat is 132 microns (5.2 mils).

A one-coat system may be applied in two passes by flood or brush coater, spray, or vacuum coater. Product may be air-dried or force cured by convection oven or convection oven with IR assist (BST 49 - 65°C [120 - 150°F]). Cool to less than 38°C (100°F) before slip-sheet and stacking.

Additional Specific Application Conditions

In all applications, the measurement of the wet mils applied may be affected by the application equipment. Temperature and humidity conditions require adjustments to be made to application parameters. These conditions are suggested guidelines, please contact your PPG Technical Service Department for additional assistance and to conduct a review and audit of specific line parameters. Additional wet film may be necessary in order to achieve the required dry film thickness.

Brush Coater

One Coat Application/One Pass: Apply 152–203 microns (6–8 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 38°C (100°F).

One Coat Application/Two Passes: Apply 76–102 microns (3.0 – 4.0 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 2.5 to 3.5 minutes depending on oven temperature. Cool down 20 to 30 seconds; apply second pass of 76–102 microns (3.0 – 4.0 mils) wet; oven cure at 63–93°C (145–200°F) for a minimum of 4 minutes to achieve a BST of 49–65°C (120–150°F). Cool down 3 to 4 minutes to achieve a stacking temperature of less than 38°C (100°F).

Two Coat Application: Apply 152–203 microns (6–8 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 4 to 8 minutes depending on oven temperature. The second coat may be applied immediately by a second inline coater or the boards may be brought around to the beginning of the line and run through again. Again, apply 152–203 microns (6–8 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 38°C (100°F).

Spray Coater

Spray tip recommendation: Spray tip recommendation: 0.017 or 0.019 spray tips – evaluate spray pattern before coating to verify that fan width is appropriate and no fingering is visible.

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APPLICATION INFORMATION (continued)

Vacuum Coater

The vacuum pressure pulled will be dependent on the vacuum system in use. The operator will need to work with the PPG Technical Service Department to determine the appropriate settings.

One Coat Application/One Pass: Apply 152–203 microns (6–8 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 4 to 8 minutes depending on oven temperature. Cool down 3 to 4 minutes to achieve a stacking temperature of less than 38°C (100°F).

One Coat Application/Two Passes: Apply 76–102 microns (3.0 - 4.0 mils) wet; flash a minimum of 30 seconds to 1 minute; oven setting of 63–93°C (145–200°F) to achieve a BST of 49–65°C (120–150°F). Time in oven 2.5 to 3.5 minutes depending on oven temperature. Cool down 20 to 30 seconds; apply second pass of 76–102 microns (3.0 - 4.0 mils) wet; oven cure at 63–93°C (145–200°F) for a minimum of 4 minutes to achieve a BST of 49–65°C (120–150°F). Cool down 3 to 4 minutes to achieve a stacking temperature of less than 38°C (100°F).

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Work with the PPG Technical Service Department for assistance in establishing force cure parameters.

PRECAUTIONS

WARNING! SUSPECTED OF CAUSING CANCER. Sanding and grinding dusts may be harmful if inhaled. Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Wear appropriate protective gloves. Wear eye or face protection. Wear protective clothing. Emits toxic fumes when heated.

Note: These warnings encompass the product series. Prior to use, read and follow product-specific SDS and label information.

FIRST AID: Contact poison treatment specialist immediately if large quantities have been ingested or inhaled. Keep person warm and at rest. Do not induce vomiting. Check for and remove any contact lenses. If in eyes, rinse with water for 15 minutes. In case of contact, immediately flush skin with plenty of water for at least 15 minutes while removing contaminated clothing and shoes. Wash skin thoroughly with soap and water or use recognized skin cleanser. Do not use solvents or thinners. If inhaled, remove to fresh air. Keep person warm and at rest. If not breathing, if breathing is irregular or if respiratory arrest occurs, provide artificial respiration or oxygen by trained personnel.

KEEP OUT OF THE REACH OF CHILDREN.

For workplace use, an SDS is available from your retailer or by calling 1-866-660-2220.

EMERGENCY SPILL INFORMATION: 1-514-645-1320 or 1-866-660-2220.

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