



LV201022 Series

Machine Applied Coatings

DURACOLOR™ ST Exterior Finish Acrylic Latex

GENERAL DESCRIPTION

Duracolor ST Semi-Transparent Finish is designed as an air-dry or force-dry coating to be applied to approved substrate that is factory primed and has had one coat of *Duracolor* FC solid colour latex coating applied by the Machine Applicator.

The Semi-Transparent Finish must be applied by approved machine application methods and only by Authorized Machine Operators.

Duracolor ST Exterior Finish can also be used to seal and touch-up board ends 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 and surface temperatures are above 10°C (50°F) and at least 3°C (5°F) above the dew point. Product temperature must be at least 15°C (60°F).

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

Semi-Transparent Finishes & Ready Mix Basecoat:

LV201022	Maple
LV201023	Slate
LV201024	Emerald
LV201025	Cedar
LV201026	Mahogany
LV201027	Redwood
LV201028	Sandstone Basecoat

Product must be applied over one coat of solid colour *Duracolor* FC Exterior Finish.

PRODUCT DATA

PRODUCT TYPE: 100% Acrylic Latex
SHEEN: Eggshell

	LV201028 1 st coat	LV201022 2 nd coat
VOLUME SOLIDS:	35% ± 2%	33% ± 2%
WEIGHT SOLIDS:	48% ± 2%	39% ± 2%
VOC:	< 100 g/L	< 100 g/L
DENSITY:	1.2 Kg/L	1.1 Kg/L
COVERAGE*:	28 square metres (300 sq. ft.)	37 square metres (400 sq. ft.)
**Theoretical Wet Film Thickness per Coat	137 microns 5.4 mils	76 microns 3.0 mils
Required Dry Film Thickness per Coat:	48 microns 1.9 mils	28 microns 1.1 mils

*Coverage per 3.78 litres (U.S. gallon) 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.

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

Viscosity (Stormer @ 25°C): 63 - 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 ST 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* Semi-Transparent Finish 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 for the Basecoat — LV201028 Sandstone or one coat of solid colour *Duracolor FC Exterior Finish*

Substrate and air temperature must be above 10°C (50°F). Paint temperature must be at least 15°C (60°F). Paint must be mixed thoroughly — see mixing instructions.

If possible, preheat 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. Required Dry Film Thickness: 48 – 64 microns (1.9 – 2.5 mils).

*Wet mils applied must result in dry mils required.

**Theoretical Wet Film Thickness per Coat is 137 microns (5.4 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 or applying the *Duracolor ST Finish*.

Additional Specific Application Conditions

In all applications, the measurement of the wet mils applied may be affected by the application equipment. A minimum dry film build of 48 microns (1.9 mils) is required. 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).

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.

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).

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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.

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Duracolor ST Exterior Finish Acrylic Latex

APPLICATION INFORMATION (continued)

General Application Requirements for the *Duracolor* ST Finish — LV201022-LV201027

Substrate and air temperature must be above 10°C (50°F). Paint temperature must be at least 15°C (60°F). Paint must be mixed thoroughly — see mixing instructions.

Apply 76 – 102 microns (3 – 4 mils) wet — depending on application equipment. Dry mils required 25 microns (1.0 mils).

*Wet mils applied must result in dry mils required.

**Theoretical Wet Film Thickness per Coat is 76 microns (3.0 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. Mechanical manipulation of the *Duracolor* ST Finish is permitted in order to achieve the desired amount of contrast between the basecoat and the ST finish.

Brush Coater

One Coat Application/One Pass: Apply 76 – 102 microns (3 – 4 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 38 – 51 microns (1.5 – 2.0 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).

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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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 76 – 102 microns (3 – 4 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).

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

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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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