



**DURACOIL HDPE ALU**

**PRODUCT DESCRIPTION**

Super-durable polyester topcoat with oven curing, designed for high-performance coating of metal coils. Exhibits good adhesion over specific primers. Excellent color and gloss retention, with high resistance to atmospheric agents and certain solvents, and high performance in terms of hardness, impact resistance, and flexibility.

**RECOMMENDED USE**

Excellent finish for painting pre-coated metal coils for civil construction, roofing, and side panels requiring excellent resistance to natural weathering and lightfastness.

**PACKAGING**

<b>Single Component</b>	264.17 US gal Package containing 264.17 US gal 50.2 US gal Packaging
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**CHARACTERISTICS**

<b>Color</b>	According to customer standard.
<b>Color Tolerance</b>	± 0.50 L, A, B (line).
<b>Gloss</b>	Matte
<b>Volume Solids</b>	52 ± 2% (ISO 3233)
<b>Solids by Weight</b>	68 ± 2 %
<b>Shelf Life</b>	12 months
<b>Dry Film Thickness</b>	0.7 mils - 0.9 mils
<b>Theoretical Coverage</b>	1059.5 ft <sup>2</sup> /gal without dilution at a dry film thickness of 0.8 mils. Loss factors during application are not considered.
<b>Specific Gravity</b>	Min: 1.23 Max: 1.33 g/cm <sup>3</sup>
<b>Solvent Resistance</b>	100 cycles, double rub, MEK.
<b>Impact</b>	40 lbf/po
<b>Pencil hardness</b>	F - 2H
<b>Flexibility</b>	1T - 3T NTO

**Oven Drying**

	450 °F	480 °F
<b>Suggested PMT</b>	Minimum	Maximum

**SURFACE PREPARATION**

**Standard Surface Preparation**

The performance of this product is related to the degree of surface preparation. In case of doubts, for more information, consult WEG's Technical Department.

The surface must be previously pre-treated in line and free of any contaminants, completely removing oils, grease and fats. We recommend the use of Bonderite C-AK 212 degreaser or equivalent, and the Bonderite 1402W chromium-based conversion coating or a similar product. Although these products are essential for the final performance of the system, they are only suggestions; WEG Coatings assumes no responsibility for their composition, application, or performance.

**Over Primer**

The product can be applied over a specific primer in order to form an appropriate coating system.

**APPLICATION PREPARATION**

<b>Mixing</b>	Mechanically homogenize the contents of each container in order to maintain product uniformity during the in-line
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painting process. Ensure that no sediment remains at the bottom of the container. If necessary, add the reducing solvent to the drum or container in the specified mixing ratio, under continuous agitation, until complete homogenization is achieved.

<b>Thinner</b>	DILUENT S-100 OU BUTIL GLICOL
<b>Alternative Thinners</b>	PU 5008 Diluent.
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 15%.
<b>Pot Life</b>	Not relevant.

**APPLICATION METHODS**

<b>Roller</b>	<p>Reverse roller:</p> <p>Primer ..... 18453199 or 18826454</p> <p>Substrate ..... Aluminum, HDG or Galvalume</p> <p>Suggested pre-treatment ..... Bonderite C-AK 212 + Bonderite 1402W or similar</p> <p>Dry topcoat layer ..... 0.71 to 0.87 mils</p> <p>Dry primer layer ..... 0.20 to 0.28 mils (when applicable)</p> <p>Dilution ..... Max. 20%.</p> <p>Direct roller: Recommended only for specific primers or monobackers.</p>
<b>Notes</b>	<p>When applied with alteration of the specified dry film thickness, above or below, at the express request of the end clients, we are not responsible for the applicator's ability to control or maintain physical properties, such as gloss, color, MEK resistance, etc.</p> <p>Equipment cleaning: MEK or W-CLEAN 40.</p> <p>NOTE: When applied with a dry film thickness different from that specified, either above or below, upon the express request of the end customer, we shall not be held responsible for the applicator's ability to control or maintain the product's physical properties, such as gloss, color, MEK resistance, among others.</p> <p>This specification also describes the characteristics that the product must exhibit immediately before and after painting. If the product does not present these characteristics, its use must be immediately discontinued and the Technical Assistance or Sales departments of Weg Tintas must be contacted.</p>

**SAFETY PRECAUTIONS**

Product developed for industrial use intended for handling by qualified professionals. Carefully read all information contained in the SDS of this product, available at: [www.weg.net](http://www.weg.net).

Store in a covered and well-ventilated place. Keep the container tightly closed and away from sources of heat or ignition.

Use only in well-ventilated areas, avoiding the accumulation of flammable vapors. Keep the product away from heat and sources of ignition.

Do not inhale mists/vapors/aerosols generated during handling and/or application. Use protective gloves/protective clothing/eye protection/face protection.

Empty containers and materials with paint residues must be disposed of according to current legislation. Take care of the environment.

**NOTE**

The information contained in this technical bulletin is based on the experience and knowledge acquired in the field by WEG's technical team.

In the event of using the product without prior consultation with WEG regarding its suitability for the purpose for which the customer intends to use it, the customer acknowledges that the use will be at their own exclusive responsibility, and WEG is not liable for the behavior, safety, suitability, or durability of the product.

Some information mentioned in this bulletin is only an estimate and may vary due to factors beyond the manufacturer's control. Therefore, WEG does not guarantee and assumes no responsibility for performance, efficiency, or any material or personal damages resulting from the incorrect use of the products in question or from the information contained in this Technical Bulletin.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services,



providing quality solutions to meet the needs of our customers.

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