

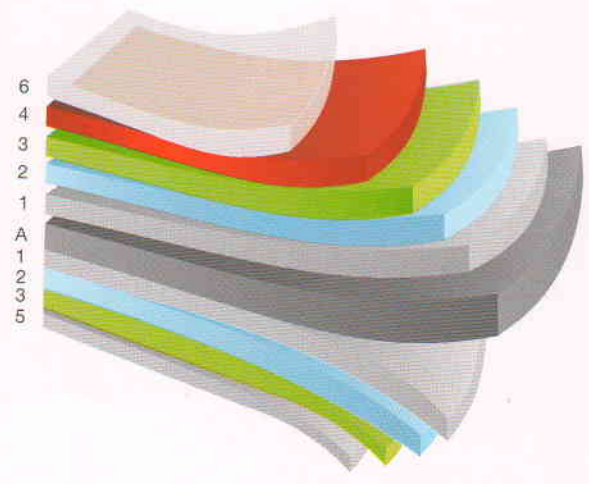
Colours of life



Product specifications

Fundamental Product Structure

- A- Cold rolled steel....substrate
- 1- Al-Zinc alloy coat
- 2- Pre-treatment (chromating)
- 3- Primer
- 4- Top coat
- 5- Backer coat
- 6- Guard film (optional)



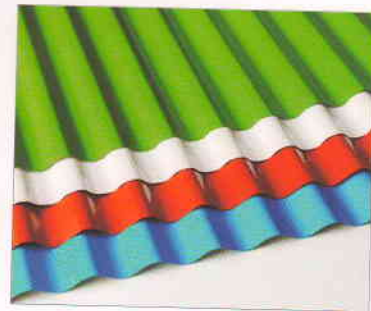
Product Specifications

Profile	Coil / Corrugated / Trapezoidal / Ribbed / Mangalore Tile Profile / Wave / Arch Trapezoidal
Substrate	Al-Zinc alloy steel
Al-Zinc Coating (gsm)	70-200
Hardness (HRB)	60 ± 5HRB/90± 5HRB
Guard film-optional (microns)	30-40 (Customised also)
Standards	ASTM A 755, EN 10169-1, IS 14246-1995 (IS is only for Physical testing)

Pre-Painted Profiles

(a) Corrugated / Sinusoidal Profile (PPG-C / PPGL-C)

Thickness	:	0.35 to 0.80 mm
Coil Input Width	:	910 mm
Supply Width	:	800 ± 25 mm
Covered Width	:	686
Pitch	:	75 ± 5 mm
Crest Height	:	17.5 ± 2.5 mm



(b) Trapezoidal Profile (PPG-TP / PPGL-TP)

Thickness	:	0.35 to 0.80 mm
Coil Input Width	:	1250 mm
Supply Width	:	1060 ± 10mm
Covered Width	:	980 mm
Pitch	:	196 mm
Crest Height	:	32 ± 2 mm
Crest Width	:	45 mm



(c) Ribbed Trapezoidal Profile (PPG-RTP / PPGL-RTP)

Thickness	:	0.35 to 0.80 mm
Coil Input Width	:	1220 mm
Covered Width	:	1020 mm
Supply Width	:	1060 ± 10 mm
Pitch	:	255 mm
Crest Height	:	28 ± 2 mm
Crest Width	:	26 mm
Lip	:	10 mm



(d) Mangalore Tile Profile (PPG-MTP / PPGL-MTP)

Thickness	:	0.35 to 0.80 mm
Coil Input Width	:	1220 mm
Covered Width	:	1000 mm
Supply Width	:	1100 ± 10 mm
Pitch	:	200 mm
Crest Height	:	28 ± 2 mm



Other Specifications

Paint System *

Primers: Epoxy, PU

polyester / universal

Top coat: Regular Modified

Polyester (RMP) / SMP / PVDF / SDP

Backer coat: Epoxy, polyester and PU

Characteristics	Primer top coat (micron) subject to substrate & coating type	7 (max)
	Top coat RMP(micron) (coating based)	15 (min)
	Primer + Backer coat (micron)	10 (min)
	Colour	As per RAL code / customer's requirement
	Gloss	Matt 35% (+/- 5%) / semi-gloss 60% (+/- 5%) / high gloss > 70%

Performance testing

Pencil Hardness	H (min)
Impact test (in Joules) (Thickness based soft material)	As per JIS G 3312
Salt spray test (specific to coating type)	750-1000 hrs
Adhesion test (cross-hatch)	100%
Erichsen cupping test	up to 7 mm
Humidity test	1000 hrs
T- Bend test (T = substrate thickness of soft material)	2 T (no tape loss)
Solvent rub test (MEK- double rub)	>50 rubs
Chemical resistance 5% NAOH, 5% HSSO4	No blistering, discolouration and softening of paint film
Max. operating temp	up to 120 °C