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**PPG IdeaScapes Guide Specification –  
Coil and Extrusion Coatings, Liquid and Powder Coating Systems**

**SECTION 050513 - SHOP-APPLIED COATINGS FOR METAL**

**SECTION 05080 - FACTORY-APPLIED METAL COATINGS**

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**[SECTION 050513 - SHOP-APPLIED COATINGS FOR METAL]**

**[SECTION 05080 - FACTORY-APPLIED METAL COATINGS]**

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Shop-applied coatings for architectural metals.

B. Related Sections:

1. Division 01 Section "Sustainable Design Requirements".
2. Division 05 Section "Pipe and Tube Railings".
3. Division 05 Section "Decorative Metal".
4. Division 05 Section "Decorative Metal Railings".
5. Division 05 Section "Decorative Formed Metal".
6. Division 07 Section "Metal Roof Panels".
7. Division 07 Section "Metal Wall Panels".
8. Division 07 Section "Sheet Metal Roofing".
9. Division 07 Section "Sheet Metal Flashing and Trim".
10. Division 07 Section "Roof Specialties".
11. Division 08 Section "Overhead Coiling Doors".
12. Division 08 Section "Overhead Coiling Grilles".
13. Division 08 Section "Aluminum-Framed Entrances and Storefronts".
14. Division 08 Section "All-Glass Entrances and Storefronts".
15. Division 08 Section "Automatic Entrances".
16. Division 08 Section "Revolving Door Entrances".
17. Division 08 Section "Glazed Aluminum Curtain Walls".
18. Division 08 Section "Structural-Sealant-Glazed Curtain Walls".
19. Division 08 Section "Aluminum Windows".
20. Division 08 Section "Metal-Framed Skylights".
21. Division 08 Section "Louvers And Vents".
22. Division 10 Section "Metal Lockers".
23. Division 13 Section "Metal Building Systems".
24. Division 08 Section "Louvers And Vents".

1.2 REFERENCES

A. American Architectural Manufacturers Association (AAMA):

1. AAMA 611 - Voluntary Specification for Anodized Architectural Aluminum.
2. AAMA 620 - Voluntary Specification for High Performance Organic Coatings on Coil Coated Architectural Aluminum.

3. AAMA 621 - Voluntary Specification for High Performance Organic Coatings on Coil Coated Architectural Hot Dipped Galvanized (HDG) and Zinc-Aluminum Coated Steel Substrates.
  4. AAMA 2604 - Voluntary Specification, Performance Requirements and Test Procedures for High Performance Organic Coatings on Aluminum Extrusions.
  5. AAMA 2605 - Voluntary Specification, Performance Requirements and Test Procedures for Superior Performing Organic Coatings on Aluminum Extrusions.
- B. ASTM International (ASTM):
1. ASTM B 117 - Practice for Operating Salt Spray (Fog) Apparatus.
  2. ASTM D 1400 - Standard Test Method for Nondestructive Measurement of Dry Film Thickness of Nonconductive Coatings Applied to a Nonferrous Metal Base.
  3. ASTM D 1654 - Standard Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments.
  4. ASTM D 2244 - Test Method for Calculation of Color Differences from Instrumentally Measured Color Coordinates.
  5. ASTM D 2247 - Standard Practice for Testing Water Resistance of Coatings in 100% Relative Humidity.
  6. ASTM D 3363 - Standard Test Method for Film Hardness by Pencil Test.
  7. ASTM D 4214 - Test Methods for Evaluating Degree of Chalking of Exterior Paint Films.
  8. ASTM E 1980 - Practice for Calculating Solar Reflectance Index of Horizontal and Low-Sloped Opaque Surfaces.
- C. U.S. Green Building Council (USGBC): LEED Green Building Rating System, NC (New Construction). Version 2.2.

### 1.3 PERFORMANCE REQUIREMENTS

- A. Solar Reflective Index: Provide metal roof panel coatings with solar reflectance index of not less than 78 for slopes of 2:12 or less and 29 for slopes greater than 2:12, per ASTM E 1980.
- B. Energy Star Compliance: Provide metal roof panel coatings identical to those listed on U.S Department of Energy's ENERGY STAR Roof Products Qualified Product List.
- C. CEC-Title 24 Compliance: Provide metal roof panel coatings with initial solar reflectance not less than **[0.70]** and emissivity not less than **[0.75]** per CRR-1.

### 1.4 SUBMITTALS

- A. Product Data: For each type of coating product specified.
- B. LEED Submittals:
  1. Product Test Reports for Credit SS 7.2: For metal roof panel coatings to document compliance with solar reflectance index requirement.
- C. Samples for Selection: For each color, gloss specified.
- D. Samples for Verification: For each coating product, for each color, gloss, and texture specified, on specified substrate.
- E. Product test reports.

- F. Qualifications: For shop-applied coatings Applicator.
- G. Maintenance data.
- H. Warranty: Sample of special warranty.

#### 1.5 QUALITY ASSURANCE

- A. Applicator Qualifications: Coating manufacturer's **[approved]** **[certified]** Applicator who is equipped, trained and approved for application of coatings required for this Project, and is approved to provide warranty specified in this Section.

#### 1.6 DELIVERY, STORAGE, AND HANDLING

- A. Deliver, unload, and store shop-coated items so that they remain free of damage or deformation. Package and protect items during shipping and handling. Protect stored items from water; stack to facilitate drainage. Keep shop-coated items out of contact with materials that may adversely affect the coating.
- B. Protect shop-coated items with protective covering until installed.

#### 1.7 COORDINATION

- A. Coordinate submittal and selection procedures for items to receive shop-applied coatings. Where items are indicated to match coatings selected for other items, adjust formulations as required to achieve match. Submit samples for verification indicating compliance with matching requirements.

#### 1.8 WARRANTY

- A. Coating Warranty: Coating Applicator's warranty in which Applicator agrees to repair finish or replace coated items that demonstrate deterioration of shop-applied finishes within warranty period indicated.
  - 1. Exposed Coating: Deterioration includes but is not limited to:
    - a. Color fading in excess of 5 Delta E Hunter units per ASTM D 2244.
    - b. Peeling, checking, or cracking of coating adhesion to metal.
    - c. Chalking in excess of a No. 8 per ASTM D 4214, when tested per Method D 659.
    - d. Corrosion of substrate in excess of a No. 6 on cut edges and a No. 8 on field surfaces, when measured per ASTM D 1654.
  - 2. Warranty Period: **[10]** **[20]** **[25]** years from date of Substantial Completion.

## PART 2 - PRODUCTS

### 2.1 MANUFACTURERS

- A. Basis-of-Design Product: Provide shop-applied coatings manufactured by PPG Industries, Inc., Pittsburgh, PA, (888) 774-4332, Email: [ideascales@ppg.com](mailto:ideascales@ppg.com); Website: [www.ppgideascales.com](http://www.ppgideascales.com) [ or comparable products of another manufacturer approved by Architect prior to bid].

### 2.2 APPROVED COATING APPLICATORS

- A. Acceptable Applicators: Provide shop-applied coatings applied by one of the following [manufacturer-approved] [manufacturer-certified] applicators:
1. <Insert list of acceptable applicators>.

### 2.3 HIGH-PERFORMANCE ORGANIC FINISH MATERIALS - EXTRUSIONS

- A. Liquid Fluoropolymer Aluminum Extrusion Coatings, AAMA 2605: Minimum 70 percent PVDF resin, by weight, in color coat [and clear topcoat].
1. Product: PPG **Industries, Inc., [Duramar] [Duramar Sunstorm] [Duramar XL]**.
  2. Pencil Hardness, ASTM D 3363: F, minimum.
  3. Dry Film Thickness, ASTM D 1400: 0.20mil primer coat plus 1.0 mil color coat, 1.20 mil total, minimum thickness.
  4. Dry Film Thickness, ASTM D 1400: 0.20 mil primer coat plus [1.0 mil barrier coat,] 1.0 mil color coat and 0.4 mil clear topcoat, [1.6 mil] [2.6 mil] total, minimum thickness.
- B. Liquid Fluoropolymer Aluminum Extrusion Coatings, AAMA 2605: 100 percent FEVE resin, by weight, in color coat [and clear topcoat].
1. Product: PPG **Industries, Inc., [Corafon] [Corafon XL]**.
  2. Pencil Hardness, ASTM D 3363: F, minimum.
  3. Dry Film Thickness, ASTM D 1400: 0.20 mil primer coat plus 1.0 mil color coat, 1.20 mil total, minimum thickness.
  4. Dry Film Thickness, ASTM D 1400: 0.20 mil primer coat plus 1.0 mil color coat and 0.7 mil clear topcoat, 1.90 mil total, minimum thickness.
- C. Liquid Fluoropolymer Aluminum Extrusion Coatings, AAMA 2604: 50% PVDF resin, by weight, in color coat.
1. Product: **PPG Industries, Inc., Acrynar**
  2. Pencil Hardness, ASTM D 3363: F, minimum.
  3. Dry Film Thickness, ASTM D 1400: 0.20 mil primer coat plus 1.0 mil color coat, 1.2 mil total, minimum thickness.

### 2.4 POWDER COATING MATERIALS - EXTRUSIONS

- A. Powder Coatings, Fluoropolymer, meeting performance requirements of AAMA 2605:
1. Product: **PPG Industries, Inc., Duramar Powder Coating.**
  2. Pencil Hardness, ASTM D 3363: F, minimum.

3. Salt Spray Resistance, ASTM B 117: 4,000 hours.
4. Humidity Resistance, ASTM D 2247: 4,000 hours.
5. Dry Film Thickness, ASTM D 1400: 0.20-0.30 mil primer coat plus 1.5 to 2.5 mil Duranar Powder Topcoat, 1.7 mil total, minimum thickness.

B. Powder Coatings, Fluoropolymer, meeting performance requirements of AAMA 2605:

1. Product: **PPG Industries, Inc., Corafion Powder Coating.**
2. Pencil Hardness, ASTM D 3363: F, minimum.
3. Salt Spray Resistance, ASTM B 117: 4,000 hours.
4. Humidity Resistance, ASTM D 2247: 4,000 hours.
5. Dry Film Thickness, ASTM D 1400: **[2.0]** mil, minimum thickness.

C. Powder Coatings, Polyester, meeting performance requirements of AAMA 2604.

1. Product: PPG **Industries, Inc., Envirocron Ultra-Durable Powder Coating.**
2. Pencil Hardness, ASTM D 3363: H – 2H.
3. Salt Spray Resistance, ASTM B 117: 3,000 hours.
4. Humidity Resistance, ASTM D 2247: 3,000 hours.
5. Dry Film Thickness, ASTM D 1400: **[2.0]** mil, minimum thickness.

## 2.5 HIGH-PERFORMANCE ORGANIC FINISH MATERIALS – COIL COATINGS

A. Liquid Fluoropolymer Aluminum Sheet Coil Coatings, AAMA 620: 70 percent PVDF resin, by weight, in color coat **[and clear topcoat]**.

1. Product: PPG Industries, Inc., **[Duranar] [Duranar Sunstorm] [Duranar SPF] [Duranar XL] [Duranar Plus] [Duranar XL Plus]**.
2. Pencil Hardness, ASTM D 3363: HB - H.
3. Salt Spray Resistance, ASTM B 117: 3,000 hours.
4. Humidity Resistance, ASTM D 2247: 3,000 hours.
5. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat, 0.85 mil total, minimum thickness.
6. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus **[0.70 mil barrier coat,]** 0.70 mil color coat and 0.45 mil clear topcoat, **[1.25 mil] [2.0 mil]** total, minimum thickness.
7. Dry Film Thickness, ASTM D 1400: 0.80 mil primer coat plus 0.80 mil color coat, 1.60 mil total, minimum thickness.
8. Dry Film Thickness, ASTM D 1400: 0.80 mil primer coat plus 0.80 mil color coat and 0.80 clear topcoat, 2.40 mil total, minimum thickness.

B. Liquid Fluoropolymer Aluminum Sheet Coil Coatings, AAMA 620: 100 percent FEVE resin, by weight, in color coat **[and clear topcoat]**.

1. Product: **PPG Industries, Inc., [Corafion] [Corafion XL]**.
2. Pencil Hardness, ASTM D 3363: HB - H.
3. Salt Spray Resistance, ASTM B 117: 3,000 hours.
4. Humidity Resistance, ASTM D 2247: 3,000 hours.
5. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat, 0.85 mil total, minimum thickness.
6. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat and 0.60 mil clear topcoat, 1.45 mil total, minimum thickness.

C. Liquid Fluoropolymer Steel Sheet Coil Coatings, AAMA 621: Minimum 70 percent PVDF resin, by weight, in color coat **[and clear topcoat]**.

1. Product: **PPG Industries, Inc., [Duramar] [Duramar Sunstorm] [Duramar SPF] [Duramar XL] [Duramar Plus] [Duramar XL Plus].**
  2. Pencil Hardness, ASTM D 3363: HB - H.
  3. Salt Spray Resistance, ASTM B 117: 1,000 hours.
  4. Humidity Resistance, ASTM D 2247: 1,000 hours.
  5. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat, 0.85 mil total, minimum thickness.
  6. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus **[0.70 mil barrier coat,]** 0.70 mil color coat and 0.45 mil clear topcoat, **[1.25 mil] [2.0 mil]** total, minimum thickness.
  7. Dry Film Thickness, ASTM D 1400: 0.80 mil primer coat plus 0.80 mil color coat, 1.60 mil total, minimum thickness.
  8. Dry Film Thickness, ASTM D 1400: 0.80 mil primer coat plus 0.80 mil color coat and 0.80 clear topcoat, 2.40 mil total, minimum thickness.
- D. Liquid Fluoropolymer Steel Sheet Coil Coatings, AAMA 621: Minimum 100 percent FEVE resin, by weight, in color coat **[and clear topcoat].**
1. Product: **PPG Industries, Inc., [Corafalon] [Corafalon XL].**
  2. Pencil Hardness, ASTM D 3363: HB - H.
  3. Salt Spray Resistance, ASTM B 117: 1,000 hours.
  4. Humidity Resistance, ASTM D 2247: 1,000 hours.
  5. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat, 0.85 mil total, minimum thickness.
  6. Dry Film Thickness, ASTM D 1400: 0.15 mil primer coat plus 0.70 mil color coat and 0.60 mil clear topcoat, 1.45 mil total, minimum thickness.

## 2.6 FINISHES

- A. Pretreatment: Mechanically clean and chemically pretreat fabricated items in accordance with coating manufacturer's requirements and AAMA requirements for finish indicated.
- B. Application: Apply primer and finish coats in accordance with coating manufacturer's requirements for finish indicated.

## 2.7 SHOP-APPLIED COATINGS SCHEDULE

- A. High-Performance Organic Finish for Aluminum Extruded Items: **[2-coat] [3-coat]** fluoropolymer finish: **[AAMA 2604] [AAMA 2605].**
  1. Coated Items: **<Insert list of extruded items to receive high-performance organic finish>.**
  2. Color: **[Match custom sample] [As selected from manufacturer's full range] [As designated or scheduled] <Insert color>.**
  3. Gloss: **[Low, less than 20] [Medium, 20 - 79] [High, 80 and above] [As selected from manufacturer's full range] [As designated or scheduled].**
- B. High-Performance Organic Finish for Aluminum Sheet Items: **[2-coat] [3-coat]** fluoropolymer finish: AAMA 620.
  1. Coated Items: **<Insert list of extruded items to receive high-performance organic finish>.**

2. Color: **[Match custom sample] [As selected from manufacturer's full range] [As designated or scheduled] <Insert color>**.
  3. Gloss: **[Low, less than 20] [Medium, 20 - 79] [High, 80 and above] [As selected from manufacturer's full range] [As designated or scheduled]**.
  4. Concealed/ Backer Finish: Pretreat substrate and apply coating applicator's standard acrylic, polyester or epoxy finish in accordance with manufacturers' requirements.
- C. High-Performance Organic Finish for Steel Sheet Items: **[2-coat] [3-coat]** fluoropolymer finish: AAMA 621.
1. Coated Items: **<Insert list of extruded items to receive high-performance organic finish>**.
  2. Color: **[Match custom sample] [As selected from manufacturer's full range] [As designated or scheduled] <Insert color>**.
  3. Gloss: **[Low, less than 20] [Medium, 20 - 79] [High, 80 and above] [As selected from manufacturer's full range] [As designated or scheduled]**.
  4. Concealed/ Backer Finish: Pretreat substrate and apply coating applicator's standard acrylic, polyester or epoxy finish in accordance with manufacturers' requirements.
- D. Powder-Coat Finish for **[Aluminum Extruded Items]** AAMA **[2604] [2605]** **[and] [Steel Items Fabricated from Shapes and Plates]**:
1. Coated Items: **<Insert list of extruded items to receive high-performance organic finish>**.
  2. Color: **[Match custom sample] [As selected from manufacturer's full range] [As designated or scheduled] <Insert color>**.
  3. Gloss: **[Low, less than 20] [Medium, 20 - 79] [High, 80 and above] [As selected from manufacturer's full range] [As designated or scheduled]**.
  4. Surface: **[Smooth] [Rough texture, glossy surface] [Fine texture] [As selected from manufacturer's full range] [As designated or scheduled]**.
- E. Clear Anodic Finish for Aluminum Extruded Items: AAMA 611, **[AA-M12C22A41, Class I, 0.018 mm] [AA-M12C22A31, Class II, 0.010 mm]** or thicker.
1. Coated Items: **<Insert list of extruded items to receive clear anodic finish>**.
- F. Color Anodic Finish for Aluminum Extruded Items: AAMA 611, **[AA-M12C22A42/A44, Class I, 0.018 mm] [AA-M12C22A32/A34, Class II, 0.010 mm]** or thicker.
1. Coated Items: **<Insert list of extruded items to receive color anodic finish>**.
  2. Color: **[Light bronze] [Medium bronze] [Dark bronze] [Black] [Match custom sample] [As selected from manufacturer's full range] [As designated or scheduled]**.

## PART 3 - EXECUTION

### 3.1 INSTALLATION

- A. Refer to individual specifications sections for installation requirements for items receiving shop-applied coatings.

3.2 PROTECTION

- A. Remove protective wrap from coated items at time of installation.

**[END OF SECTION 05 05 13]**

**[END OF SECTION 05080]**

