



## TECHNICAL BULLETIN

### Highlights

POWERCRON 6100AP is PPG's sixth generation cationic epoxy technology. It meets the requirements of the appliance industry in a lead-free and low-solvent formulation.

Compared to early generation cationic epoxies, POWERCRON 6100AP features include:

- Lead-free formulation
  - Lead-free film
  - Lead-free effluent
- Excellent corrosion resistance
- Excellent chemical resistance
- Detergent resistance
- Low VOC
- Non-HAP coating
- Wide window for topcoatability

### Technical Properties

Property	Test Method	Performance
Color	---	Black, Earthtones
Film Thickness	---	0.5 - 1.5 Mils
Gloss - 60 Degree	ASTM D523	55 - 75
Pencil Hardness	ASTM D3363	2H Minimum
Direct Impact	ASTM D2794	100 in-lb Minimum
Reverse Impact	ASTM D2794	60 in-lb Minimum
Crosshatch Adhesion	ASTM D3359	4B - 5B
Humidity	ASTM D1735	1000 Hours Minimum
Water Immersion	ASTM D870	250 Hours Minimum
Gravelometer	GM9508P	6 Minimum
Detergent Resistance	ASTM D2248	100 Hours

Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment.  
0.4 mils Average Film Thickness, Cure 20 Minutes @ 375°F

Property	Substrate / Pretreatment	Salt Spray* 1000 Hours	20 Cycle** Scab
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	1 - 2 mm	1 - 2 mm
	CRS/Iron Phos/Non-Chrome	3 - 6 mm	3 - 8 mm

(Average Total Scribe Creep), \* Salt Spray - ASTM B117  
\*\* Cycle Scab - GM9511P, Cold Rolled Steel Lab Panels  
Cure 20 Minutes @ 375°F

### Commercial Uses

- Appliance Parts
- Appliances
- Laboratory Furniture
- Microwave Ovens
- Refrigeration
- Storage Racks

### Application Data

**Standard Bake:** 20 Minutes at 375 - 400°F Metal Temperature  
**VOC:** < 0.5 lbs. per gallon minus water (as supplied)  
**HAPs:** None  
**Heavy Metals:** None

**Note:** Cationic epoxy technologies are not color stable.



PPG Industries  
151 Colfax Street  
Springdale, PA 15144  
1-800-PPG-ECOAT  
www.ppgcoat.com  
ecoatinfo@ppg.com

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