



TECHNICAL BULLETIN

Highlights

POWERCRON 6100 is PPG's sixth generation cationic epoxy technology. It meets the requirements of the automotive parts/body and heavy duty truck market segments in a lead-free formulation.

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

- Lead-free formulation
 - Lead-free film
 - Lead-free effluent
- Excellent corrosion resistance
- Low VOC
- Non-HAP coating
- Robust window of operation

Technical Properties

Property	Test Method	Performance
Color	---	Black, Gray, 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
Throwpower	GM9535P	12 - 15 inches

Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment.
0.8 mils Average Film Thickness, Cure 20 Minutes @ 350°F

Property	Substrate / Pretreatment	Salt Spray*	20 Cycle**
		1000 Hours	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 @ 350°F

Commercial Uses

- Compressors
- Computer Parts
- Fasteners
- Generators
- Heavy Duty Trucks
- Marine Engines
- Switchgear
- Transformers

Application Data

Standard Bake: 20 Minutes at 350°F Metal Temperature
VOC: < 0.6 lbs. per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None

Note: Cationic epoxy technologies are not color stable.



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