



TECHNICAL BULLETIN

Highlights

POWERCRON 935 is a high performance cathodic acrylic electrocoat technology available in an environmentally friendly package. Advantages include:

- Low bake with a cure as low as 325-350°F.
- Non-HAP coating.
- Corrosion resistance in excess of 500 hours.
- Excellent color and gloss retention.
- The ability to replace two-coat operations with a similarly performing one-coat process.
- Excellent hardness with a minimum hardness rating of 2H.
- Available in a wide range of colors and glosses.
- Heavy metal-free formulation.

Technical Properties

Property	Test Method	Performance
Color	---	All Colors
Film Thickness	---	0.5 - 1.5 MILS
Gloss - 60 Degree	ASTM D523	20 - 85
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	95 - 100%
Direct Impact	ASTM D2794	30 in-lb Minimum
Humidity	ASTM D1735	500 Hours Minimum
Water Soak	ASTM D870	250 Hours Minimum
Gloss Retention	Florida (1 Year)	50% + Retention

Film properties based on iron phosphate pretreatment with chrome seal

Property	Pretreatment	Salt Spray 300 Hours	Salt Spray 500 Hours	Salt Spray 750 Hours
Corrosion Resistance	Zinc Phos/Non Chrome	0 - 1 mm	0 - 3 mm	0 - 7 mm
	Iron Phos/Chrome	0 - 2 mm	1 - 5 mm	3 - 7 mm

(Average Total Scribe Creep), * Salt Spray - ASTM B1175

Commercial Uses

- Agricultural Implements
- Air Conditioners
- Clears for Brass and Other Plated Substrates
- Heavy Duty Equipment
- Lawn & Garden
- Microwave Ovens
- Refrigeration Products
- Switchgear
- Transformers
- Water Coolers
- Welding Equipment
- Wheels

Application Data

Bake: 20 minutes at 350°F (177°C) metal temperature – Standard Cure
VOC: 2.0 - 2.4 lbs per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None



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

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