



## TECHNICAL BULLETIN

### Highlights

POWERCRON 6100HE is PPG's sixth generation high edge cationic epoxy technology.

Compared to earlier generation high edge cationic epoxies, POWERCRON 6100HE features include:

- High edge coverage
- Excellent corrosion resistance
- Heavy metal free
  - Lead-free film
  - Lead-free effluent
- Low VOC
- Non-HAP coating

### Technical Properties

Property	Test Method	Performance
Color	---	Various
Film Thickness	---	0.5 - 1.5 Mils
Gloss - 60 Degree	ASTM D523	50 - 80
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
Rust Spot	GM9632P	< 5 (Avg.)
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* 1000 Hours
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	1 - 3 mm

(Average Total Scribe Creep), \* Salt Spray - ASTM B117  
0.8 mils Average Film Thickness, Cure 20 Minutes @ 350°F

### Commercial Uses

- Automotive Parts & Accessories
- Compressors
- Computer Parts
- Condensers
- Fasteners
- Generators
- Heavy Duty Trucks
- Marine Engines
- Metal Furniture
- Switchgear
- Transformers

### Application Data

**Standard Bake:** 20 Minutes at 350°F Metal Temperature  
**VOC:** < 0.7 lbs. per gallon minus water (as supplied)  
**HAPs:** None  
**Heavy Metals:** None

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

The technical data presented in this bulletin is based upon information believed to be currently accurate. However, no guarantees of accuracy, comprehensiveness, or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in the bulletin. Contact your PPG representative for the most up-to-date information.



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