



## TECHNICAL BULLETIN

### Highlights

POWERCRON XP is PPG's high edge coverage sixth generation cationic epoxy technology optimized specifically for fasteners. Its advantages include:

- Wide operating window
- Built-in torque control
- Non-sticking formulation
  - Dry to touch
- No recess fill issues
- No thread fill
- State-of-the-art corrosion resistance
- Sharp edge coverage
- Environmentally friendly, heavy metal-free formulation
  - Lead-free film
  - Lead-free effluent
  - Chrome-free system
- Lower applied cost
  - Reduced film shrinkage
  - Reduced cure temperature
  - Reduced oven maintenance
- Reduced emissions
  - Low solvent content
  - VOC less than 0.6 lbs/gal
  - Non-HAP coating

### Technical Properties

Property	Test Method	Performance
Color	---	Any other than white
Film Thickness	---	0.5 - 1.2 Mils
Gloss - 60 Degree	ASTM D523	25 - 55
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	4B - 5B
Salt Spray	ASTM B117	1000 Hours Minimum
Humidity	ASTM D1735	1000 Hours Minimum
Water Immersion	ASTM D870	240 Hours Minimum
Gravelometer	GM9508P	6 Minimum
Rust Spot	GM9632P	Zero (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	20 Cycle** Scab
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	< 1 mm	2 - 3 mm
	CRS/Iron Phos/Non-Chrome	2 - 4 mm	3 - 5 mm

Cold Rolled Steel Lab Panels  
(Average Total Scribe Creep), \* Salt Spray - ASTM B117  
\*\*Actual fastener testing uses 40 cyclic corrosion - GM9540  
0.8 mils Average Film Thickness, Cure 20 Minutes @ 350°F

### Commercial Uses

- Automotive Fasteners
- Construction Fasteners
- Fasteners Requiring Torque Properties

### Application Data

**Standard Bake:** 20 Minutes at 350°F Metal Temperature, depending on desired performance properties. Higher temperatures may be required for specific properties.

**VOC:** < 0.6 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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