



TECHNICAL BULLETIN

Highlights

POWERCRON 394 is PPG's newest anodic acrylic technology. Its advantages include:

- Reduced bake capabilities as low as 300°F
- Designed for high throw-power needed for painting metal cabinetry.
- Wide variety of colors available.
- Superior corrosion properties for anodic technology.
- Environmentally friendly with low VOC levels.
- Robust tank operation and easy bath maintenance make the product very user friendly

Technical Properties

Property	Test Method	Performance
Color	---	All
Film Thickness	---	0.7 - 1.3 Mils
Gloss - 60 Degree	ASTM D523	20 - 70
Pencil Hardness	ASTM D3363	H - 2H
Crosshatch Adhesion	ASTM D3359	4B - 5B
Direct Impact	ASTM D2794	60 in-lb Minimum
Salt Spray	ASTM B117	175 - 225 Hours
Humidity	ASTM D1735	500 Hours Minimum
Water Soak	ASTM D870	250 Hours Minimum

Film properties based on iron phosphate pretreatment

Property	Substrate / Pretreatment	Salt Spray*	Salt Spray*
		168 Hours	240 Hours
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	1 - 2 mm	2 - 3 mm
	CRS/Iron Phos/Non-Chrome	1 - 3 mm	2 - 4 mm

(Average Total Scribe Creep), * Salt Spray - ASTM B117
Cold Rolled Steel Lab Panels
Cure 20 Minutes @ 325°F

Commercial Uses

- Air Conditioners
- Air Diffusers
- Assemblies
- Consumer Appliances
- Furnaces
- Hangers
- Hardware
- Metal Office Furniture
- Metal Strapping
- Range Hoods
- Sheet Metal/Lockers
- Shelving
- Switchgear
- Toolboxes
- Wire Screen

Application Data

Bake: 20 minutes at 325°F (163°C) metal temperature
VOC: 0.3 - 0.5 lbs per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None



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