

# POWERCRON<sup>®</sup> 394

## 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, including white.
- 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 - 80
Pencil Hardness	ASTM D3363	F - H
Crosshatch Adhesion	ASTM D3359	4B - 5B
Direct Impact	ASTM D2794	40 - 60 in-lb Minimum
Salt Spray	ASTM B117	168 - 240 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* 168 Hours	Salt Spray* 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

- Office Furniture
- Toolboxes
- Assemblies
- Switchgear
- Consumer Appliances
- Sheet Metal / Lockers
- Shelving
- Hardware

## APPLICATION DATA

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