

# POWERCRON® 6100

## HIGHLIGHTS

POWERCRON 6100 is PPG's sixth generation cationic epoxy technology. It meets the requirements of the automotive parts/body and heavy duty truck market segments in a lead-free formulation.

Compared to early generation cationic epoxies, POWERCRON 6100 features include:

- Lead-free formulation
  - Lead-free film
  - Lead-free effluent
- Excellent corrosion resistance
- Low VOC
- Haps-Free
- Robust window of operation

## TECHNICAL PROPERTIES

Property	Test Method	Performance
Color	---	Black, Gray, Earthtones
Film Thickness	---	0.4 - 1.2 MILS
Gloss - 60 Degree	ASTM D523	55 - 75%
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	4B - 5B
Direct Impact	ASTM D2794	100 in-lb Minimum
Reverse Impact	ASTM D2794	60 in-lb Minimum
Humidity	ASTM D1735	1000 Hours Minimum
Water Soak	ASTM D870	250 Hours Minimum
Gravelometer	GM9508P	6 Minimum
Throwpower	GM9535P	12 - 15 inches

**Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment.  
0.8 mils Average Film Thickness, Cured 20 Minutes @ 350°F**

Property	Substrate / Pretreatment	Salt Spray* 1000 Hours	20 Cycle** Scab
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	1 - 2 mm	1 - 2 mm
	CRS/Iron Phos/Non-Chrome	3 - 6 mm	3 - 8 mm

(Average Total Scribe Creep); \* Salt Spray - ASTM B117  
 \*\* Cycle Scab - GM9511P, Cold Rolled Steel Lab Panels  
 Cured 20 Minutes @ 350°F

## COMMERCIAL USES/APPROVAL

- Heavy Duty Trucks
- Compressors
- Computer Parts
- Fasteners
- Generators
- Marine Engines
- Switchgear
- Transformers

## APPLICATION DATA

**Standard Bake:** 20 Minutes at 350°F Metal Temperature  
**VOC:** < 0.6 lbs. per gallon minus water (as supplied)  
**HAPs:** None  
**Heavy Metals:** None