

POWERCRON® XP

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
 - HAPs-free

TECHNICAL PROPERTIES

Property	Test Method	Performance
Color	---	Any other than white
Film Thickness	---	0.5- 1.2 Mills
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

Cure 20 Minutes @ 350°F Metal Temperature
 Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment
 0.8 Mil Average Film Thickness

Property	Substrate / Pretreatment	Salt Spray* 1000 Hours	20 Cycle** Scab
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	< 1mm	2 - 3 mm
	CRS/Iron Phos/Non-Chrome	2 - 4 mm	3 - 5 mm

Cure 20 Minutes @ 350°F Metal Temperature
 Cold Rolled Steel Lab Panels
 (Average Total Scribe Creep)
 * Salt Spray - ASTM B117

** Actual fastener testing uses 40 Cyclic Corrosion - GM 9540

COMMERCIAL USES/APPROVAL

- Automotive Fasteners
- Construction Fasteners
- Fasteners Requiring Torque Properties

APPLICATION DATA

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