PRIMERON® Versa Powder Coat

Epoxy

PCMT70101 - Ultra Primer (PCEL160002)

POWDER COATING **Technical Data Sheet**

Highlights

PPG's Primeron powder coatings are durable primers with exceptional corrosion protection for a variety of market segments.

PPG's "World Class" Primer Powder Coatings provide a combination of good physical and chemical resistance properties. This specialized line of zinc-rich epoxy, epoxy, and epoxy-polyester primers are manufactured to meet the increasing requirement demands of the automotive and industrial markets. These sophisticated products are the solution to your corrosion, durability, and physical property requirements. An unsurpassed application development program enables consistently friendly use on a variety of substrates.

- Excellent corrosion resistance
- Fortified with corrosion inhibitor

PRODUCT APPROVALS

Compliant to ISO 12944-6 C5-M High requirements over 2-3 mil profile blasted cold rolled steel and top coated with an appropriate polyester powder coating
UL Approved

PRODUCT CHARACTERISTICS

Semi-conductive to help with acceptance of electrostatically applied topcoat

TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated steel panels
Recommended Thickness	ASTM D 7091	1.5 - 2.5 mils
Curing Conditions	Metal Temperature	10 min @ 340 °F

Also tested were iron phosphate treated CRS(cold rolled steel). Ziroconium oxide treated CRS and Sa2.5 grit blasted HRS.

PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 60°	ASTM D 523	10 Maximum
Adhesion	ASTM D 3359	100% (5B Pass)
Hardness	ASTM D 3363	2H Pencil (Eagle)
Impact - Direct	ASTM D 2794	80 in-lbs
Conical Mandrel	ASTM D 522	1/8" Mandrel - No cracking
Salt spray	ASTM B 117	5000 hrs 1000 hrs (degrease only)
Humidity	ASTM D 4585 @ 38° C	100 °F, 100% RH - 2000+ hrs
Cyclic Corrosion	SAE J2334	120 Cycles-Pass
Specific gravity	Calculated	1.53 ± .05
Theoretical coverage	Calculated	126 ft²/lbs at 1.0 mil 25.7 m²/kg at 25 µm

CURING WINDOW* (object temperature)

See Cure Curve PCM-028

20-30 min @ 280 °F (138 °C)
5-20 min @ 330 °F (166 °C)
4-6 min @ 390 °F (199 °C)

*Temperature and time to be adjusted to accomplish proper curing of coating. This can be achieved using infrared, convection, or combination ovens.

STORAGE STABILITY

12 months at 77 °F maximum

Materials need to be stored in sealed plastic bags under dry and cool conditions. Do not expose to sunlight.

PPG recommends that all material be used in FIFO order (first in - first out). Materials that exceed the recommended shelf life should be tested prior to use.

SUBSTRATE PREPARATION

Surface preparation should be chosen according to the type of substrate and required performance.
The coater should test the suitability of the surface preparation before the application using appropriate test methods.

APPLICATION RECOMMENDATIONS

Electrostatic Spray
Coating can be applied with automatic and manual devices.
Substrate should be correctly cleaned before use.
Do not mix this product with other powder coatings.
Color and finish influenced by film thickness: a good control of the film thickness will help the consistency of the aspect.
It is recommended to partially cure or gel the primer if it will be overcoated with a topcoat and fully baked. 30-50% cure of primer is recommended to maximize intercoat adheasion.

HEALTH AND SAFETY

For comprehensive Health, Safety, and Environmental advice, please refer to the relevant Safety Data Sheets, and information printed on the product label.

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