ENVIROCRON® Powder Coat

Polyester HAA Ultra Durable

PCST25104 - BONDED OIL RUBBED BRONZE

POWDER COATING **Technical Data Sheet**

Highlights

PPG's Enviracryl™ and Envirocron™ powder coatings are aesthetically pleasing, produce a durable uniform finish and can be custom formulated with finishes from high gloss to low gloss, and in a variety of textures.

PPG's "World Class" Ultradurable Polyester Powder Coatings provide a combination of good physical and chemical resistance properties with excellent resistance to outdoor weathering. This extensive line of Polyester Powders is manufactured to meet the increasing requirement demands of the automotive and industrial markets. These sophisticated Polyesters are the solution to your smoothness, low-bake, durability and physical property requirements. An unsurpassed application development program enables consistently friendly use on a variety of substrates.

TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated aluminum panels
Recommended Thickness	ASTM D 7091	2.0 - 3.0 mils
Curing Conditions	Metal Temperature	15 min @ 400 °F

PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Metallic
Gloss 60°	ASTM D 523	15 - 30
Adhesion	ASTM D 3359	100% (5B Pass)
Hardness	ASTM D 3363	2H Pencil (Eagle)
Impact - Direct	ASTM D 2794	40 in-lbs - No flaking
Impact - Reverse	ASTM D 2794	20 in-lbs - No flaking
Conical Mandrel	ASTM D 522	1/2" Mandrel - No flaking
Specific gravity	Calculated	1.52 ± .05
Theoretical coverage	Calculated	127 ft²/lbs at 1.0 mil 25.9 m²/kg at 25 µm

CURING WINDOW* (object temperature)

See Cure Curve PCS-013

15-30 min @ 380 °F (193 °C)
10-20 min @ 410 °F (210 °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

24 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.

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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