ENVIROCRON® HTE Powder Coat

Polyester HAA Ultra Durable

PCST89138 - Wheel White Max

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" High Transfer Efficiency Powder Coatings provide a combination of good physical and chemical resistance properties. This extensive line of HTE Powders is engineered to meet the increasing requirement demands of the industrial wire and complex metal surface markets. They are available in both standard durable and ultradurable formulations with a first-pass transfer efficiency rate of 85% or better resulting in superior application build rates. These sophisticated Powders are the solution to your durability and physical property requirements. An unsurpassed application development program enables consistently friendly use on a variety of substrates.

- Available in a wide range of colors and glosses
- Excellent exterior durability
- Fortified with corrosion inhibitor
- Good chemical resistance
- Low cure capabilities

PRODUCT CHARACTERISTICS

Formulated without the use of TGIC
Outstanding monocoat corrosion protection
Formulated for excellent outgassing (OGF) properties

TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated steel panels
Recommended Thickness	ASTM D 7091	2.5 - 3.5 mils
Curing Conditions	Metal Temperature	10 min @ 350 °F

Corrosion testing performed on shot blasted untreated CRS. (when applied 3.0+ mils above blast profile)

PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 60°	ASTM D 523	85 Minimum
Adhesion	ASTM D 3359	100% (5B Pass)
Hardness	ASTM D 3363	2H Pencil (Eagle)
Impact - Direct	ASTM D 2794	80 in-lbs - No flaking
Impact - Reverse	ASTM D 2794	80 in-lbs - No flaking
Conical Mandrel	ASTM D 522	1/4" Mandrel - No flaking
Salt spray	ASTM B 117	Up to 3000 hrs
Humidity	ASTM D 4585 @ 38° C	100 °F, 100% RH - 1000+ hrs
Exterior Weathering		
South Florida Exposure	45° South - 60 months	
Gloss Retention	ASTM D 523	30% gloss retention
Specific gravity	Calculated	1.68 ± .05
Theoretical coverage	Calculated	114 ft²/lbs at 1.0 mil 23.4 m²/kg at 25 µm

CURING WINDOW* (object temperature)

See Cure Curve PCS-004

20 min @ 300 °F (149 °C)
10 min @ 350 °F (177 °C)
5 min @ 400 °F (204 °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.

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.

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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