ENVIROCRON® XMR Powder Coat

Polyester TGIC Ultra Durable

PCTT39211 - Kubota Orange

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 appliance 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.

- Available in a wide range of colors and glosses
- Excellent exterior durability
- Good chemical resistance

PRODUCT APPROVALS

Specifically formulated to meet the requirements of Kubota specification 013-0015 Class 1 / Extreme and Severe B (T1).

TEST CONDITIONS

Property	Test method	Value
Substrate		Pretreated steel panels
Recommended Thickness	ASTM D 7091	2.0 - 3.0 mils
Curing Conditions	Metal Temperature	10 min @ 375 °F

PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 60°	ASTM D 523	80 - 100
Adhesion	ASTM D 3359	Dry: 100% (5B Pass) Wet: 100% (5B Pass) Boiling Water: 100% (5B Pass)
Hardness	ASTM D 3363	2H Pencil (Eagle)
Impact - Direct	ASTM D 2794	120 in-lbs
Impact - Reverse	ASTM D 2794	100 in-lbs
Conical Mandrel	ASTM D 522	1/4" Mandrel - No cracking
Salt spray	ASTM B 117	1000+ hrs
Humidity	ASTM D 4585 @ 38° C	1000 hrs
Specific gravity	Calculated	1.46 ± .05
Theoretical coverage	Calculated	132 ft²/lbs at 1.0 mil 27 m²/kg at 25 µm

CURING WINDOW* (object temperature)

See Cure Curve PCT-050

15-23 min @ 340 °F (171 °C)
10-21 min @ 360 °F (182 °C)
5-10 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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