



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” Polyester Powder Coatings provide a combination of good physical and chemical resistance properties. 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
- Exterior durability
- Good chemical resistance



PRODUCT APPROVALS

UL Approved
Compliant to fire protection specifications NFPA130 and 49CFR238 – Fixed Guideway Transit and Passenger Rail Systems
ISO12944 C4L Compliant

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 @ 340 °F

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	160 in-lbs
Impact - Reverse	ASTM D 2794	160 in-lbs
Conical Mandrel	ASTM D 522	1/8" Mandrel - No cracking
Salt spray	ASTM B 117	1000 hrs
Humidity	ASTM D 4585 @ 38° C	100 °F, 100% RH - 1000+ hrs
Surface Flammability	ASTM E 162	Is < 25
Optical Density of Smoke	ASTM E 662	Ds(1.5) < 25, Ds(4.0) < 100
Toxicity of Smoke	BS 7239	
Carbon Monoxide CO		< 3,500 ppm
Hydrogen Fluoride HF		< 200 ppm
Nitrous Oxides NOx		< 100 ppm
Hydrogen Chloride HCl		< 500 ppm
Hydrogen Cyanide HCN		< 150 ppm
Sulfurous Oxides SOx		< 100 ppm
Specific gravity	Calculated	1.65 ± .05
Theoretical coverage	Calculated	117 ft²/lbs at 1.0 mil 23.9 m²/kg at 25 µm



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CURING WINDOW* (object temperature)

See Cure Curve PCT-049

15-25 min @ 300 °F (149 °C)
6-20 min @ 360 °F (182 °C)
3-8 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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