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## 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" Hybrid Powder Coatings provide a combination of good physical and chemical resistance properties. This extensive line of Hybrid Powders is manufactured to meet the increasing requirement demands of the appliance, automotive and industrial markets. These sophisticated Hybrids 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.

## Product Features

Available in a wide range of colors and glosses  
Good chemical resistance

## Technical Properties

Property	Test Method	Value
Color	_____	Muted Black Hybrid
Appearance		Smooth
Gloss	ASTM D-523	15 - 25 @ 60°
Adhesion	ASTM D-3359	100% (5B Pass)
Hardness	ASTM D-3363	2H Pencil (Eagle)
Impact Resistance	ASTM D-2794	80 In.-lbs. Direct 80 In.-lbs. Reverse
Conical Mandrel	ASTM D-522	1/8" Mandrel- No Cracking
Salt Spray	ASTM B-117	1000 Hrs. Pass <1/8" Scribe Creep - No Blisters
Humidity	ASTM D-1735	1000 Hrs. Pass <1/16" Scribe Creep - No Blisters

*Film Properties were determined using 2.0 - 3.0 mils powder film over iron phosphated, non-chrome rinse pretreated, 22 gauge, polished cold rolled steel test panels.*

## Application Data

Application Type:	Electrostatic Spray
Recommended Bake:	20 Minutes at 375 °F Metal Temperature See Cure Curve PCF-002
Specific Gravity:	1.59 ± .05
Theoretical Coverage:	121 Sq. Ft. per pound at 1.0 mil
Shelf Life from Date of Manufacture (@ 40-60% RH):	80 °F Maximum - 24 Months

*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.*

\* Statements and methods described herein are based upon the best information and practices known to PPG Industries, Inc. ("PPG"). Any statements or methods mentioned herein are general suggestions only and are not to be construed as representations or warranties as to safety, performance, or results. Since the suitability and performance of the product is highly dependent on the product user's processes, operations, and numerous other user-determined conditions, the user is solely responsible for, and assumes all responsibility, risk and liability arising from, the determination of whether the product is suitable for the user's purposes, including without limitation substrate, application process, pasteurization and/or processing, and end use. No testing, suggestions or data offered by PPG to the user shall relieve the user of this responsibility. PPG does not warrant freedom from patent infringement in the use of any formula or process set forth herein. Continuous improvements in coatings technology may cause future technical data to vary from what is in this bulletin. Contact your PPG representative for the most up to date information.

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# PCF90215

## ENVIROCRON® XMR Powder Coat

### Product Information

PCF90213 is a powder primer designed for use with PPG's ultradurable polyester powder topcoats. Prior to the powder topcoat application, PC90213 can be either fused baked or fully cured. The recommended fused bake is a 2-10 minute bake cycle with a peak metal temperature of 225-400F using infrared heating or 250-425F peak metal temperature using forced air convection heating. Inadequate fusion of PCF90213 will affect the appearance of the powder topcoat, resulting in haze and lower gloss. In this situation, increasing the fuse bake temperature for PCF70283 is recommended. PCF90213 primer will be fully cured in the subsequent powder topcoat cure process for PPG's ultradurable polyester powder topcoats.

Full curing of PCF90213 is always recommended for situations where the powder topcoat application might be delayed or not used.



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