



# ENVIROCRON® XMR Powder Coat

Polyester TGIC Ultra Durable

PCTT99259 - RAL 9005 OGF Trailer Black

## POWDER COATING

## Technical Data Sheet

### Highlights

PPG's Envirocyl™ 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.

- Automotive grade jetness
- Excellent exterior durability
- Fast and low cure capability
- Good chemical resistance

### PRODUCT APPROVALS

Specifically formulated to meet the requirements of AAMA 2604.  
Can be applied over primer to achieve ISO12944: C5M (marine grade) performance.

### PRODUCT CHARACTERISTICS

High flow but rheological control to avoid drips  
World class abrasion from XMR (Extreme Mar Resistance) technology  
Outgas friendly especially suited for shot blasted and cast metals  
Industry leading transfer efficiency from enhanced manufacturing control

### 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 @ 325 °F

Corrosion testing performed on shot blasted untreated CRS.

### PRODUCT PROPERTIES

Property	Test method	Value
Appearance	Visual Inspection	Smooth
Gloss 60°	ASTM D 523	93 Minimum
Adhesion	ASTM D 3359	Dry: 100% (5B Pass) Wet: 100% (5B Pass) Boiling Water: 100% (5B Pass)
Hardness	ASTM D 3363	H Pencil (Eagle)
Impact - Direct	ASTM D 2794	100 in-lbs
Conical Mandrel	ASTM D 522	1/4" Mandrel - No flaking
Salt spray	ASTM B 117	3000 hrs <1/8" scribe creep No blisters
Specific gravity	Calculated	1.42 ± .05
Theoretical coverage	Calculated	135 ft²/lbs at 1.0 mil 27.7 m²/kg at 25 µm





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### CURING WINDOW\* (object temperature)

See Cure Curve PCT-043

20 min @ 300 °F (149 °C)

10 min @ 325 °F (163 °C)

5 min @ 350 °F (177 °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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