

TECHNICAL BULLETIN

Highlights

POWERCRON 840R has excellent exterior durability in an acrylic formulation. Its advantages include:

- Exceptional UV resistance.
- Available in a wide range of colors and glosses
- Excellent overbake resistance.
- Salt spray capability of 200 hours.
- Excellent color and gloss retention.
- Non-HAP coating.
- Heavy metal free formulation.

Technical Properties

Property	Test Method	Performance
Color	---	Any Color
Film Thickness	---	0.5 - 1.5 Mils
Gloss - 60 Degree	ASTM D523	20 – 85
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	5B (90 - 100%)
Impact Resistance – Direct	ASTM D2794	30 in-lb Minimum
Humidity	ASTM D1735	500 Hours Minimum

Film properties based on zinc phosphate non-chrome pretreatment

Property	Substrate / Pretreatment	Salt Spray* 100 Hours	Salt Spray* 200 Hours
Corrosion Resistance	CRS/Zinc Phos/Non-Chrome	0 - 3 mm	3 - 6 mm

(Average Total Scribe Creep), * Salt Spray - ASTM B117

Property	Product	Percent Gloss Retention* (60° meter) 1000 Hrs
Weatherometer Durability	POWERCRON 840R	90-100%

Method-SAE-J1960 with Boro Boro filters

Commercial Uses

- Agricultural Implements

Application Data

Bake: 20 minutes at 350°F (177°C) metal temperature
VOC: 2.1 - 2.5 lbs per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None



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