

## TECHNICAL BULLETIN

### Highlights

FrameCoat II is PPG's high performance cationic epoxy technology that provides excellent edge coverage with the added benefit of an improved surface profile. Its advantages include:

- State-of-the-art corrosion resistance
- High edge coverage/corrosion protection
- Smoother film appearance
- Environmentally friendly formulation.
  - Lead-free film
  - Lead-free effluent
- Reduced emissions
  - Low solvent content
  - VOC less than 0.7 lbs/gal
  - Non-HAP coating
- Cure capability as low as 325°F, depending on requirements
- Excellent film uniformity
- Approvals
  - Small parts specification approvals
  - Frame specification approvals

### Technical Properties

Property	Test Method	Performance
Color	---	Black
Film Thickness	ASTM D7091	0.8 - 1.4 Mils
Gloss - 60 Degree	ASTM D523	50 – 80
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	4B – 5B
Humidity	ASTM D1735	1000 Hours Minimum, 5B
Water Immersion	ASTM D870	500 Hours Minimum, 5B
Gravelometer	GM9508P	6 Minimum
Edge Coverage	GM9632P	< 5 Rust Spots Average
Throwpower	GM9535P	12 – 15 inches

Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment.  
0.8 mils Average Film Thickness, Cure 20 Minutes @ 350°F  
Film properties vary with substrate, pretreatment, and film thickness

Property	Substrate / Pretreatment	Salt Spray*	40 Cycle **	50 Cycle***
		1000 Hours	Corrosion	Scab
Corrosion Resistance	HRS/Zinc Phos/Non-Chrome	< 3 mm	2 – 3 mm	2 – 3 mm

Hot Rolled Frame Stock (Average Total Scribe Creep)  
\* Salt Spray - ASTM B117, \*\*Cycle Corrosion - GM9540, \*\*\*Cycle Scab - FLTM BI-123  
Cure 20 Minutes @ 350°F

### Commercial Uses

- Automotive Parts & Accessories
- Cast Iron Sewer Pipes
- Compressors
- Computer Parts
- Control Arms
- Engine Cradles
- Fasteners
- Generators
- Heavy Duty Truck
- Knockdown Parts
- Military Cabs/Parts
- Radiators
- Spring Clips
- Suspension Components
- Switchgear
- Torsion Bars
- Tow Hooks
- Trailer Hitches
- Truck Frames

### Application Data

**Standard Bake:** 20 Minutes at 350°F Metal Temperature  
**VOC:** < 0.7 lbs. per gallon minus water (as supplied)  
**HAPs:** None  
**Heavy Metals:** None

The technical data presented in this bulletin is based upon information believed to be currently accurate. However, no guarantees of accuracy, comprehensiveness, or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in the bulletin. Contact your PPG representative for the most up-to-date information.



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