

TECHNICAL BULLETIN

Highlights

POWERCRON 935 is a high performance cathodic acrylic electrocoat technology available in an environmentally friendly package. Advantages include:

- Low bake with a cure as low as 325-350°F.
- Non-HAP coating.
- Corrosion resistance in excess of 500 hours.
- Excellent color and gloss retention.
- The ability to replace two-coat operations with a similarly performing one-coat process.
- Excellent hardness with a minimum hardness rating of 2H.
- Available in a wide range of colors and glosses.
- Heavy metal-free formulation.

Technical Properties

| Property | Test Method | Performance |
|---------------------|------------------|-------------------|
| Color | --- | All Colors |
| Film Thickness | --- | 0.5 - 1.5 Mils |
| Gloss - 60 Degree | ASTM D523 | 20 - 85 |
| Pencil Hardness | ASTM D3363 | 2H Minimum |
| Crosshatch Adhesion | ASTM D3359 | 95 - 100% |
| Direct Impact | ASTM D2794 | 30 in-lb Minimum |
| Humidity | ASTM D1735 | 500 Hours Minimum |
| Water Soak | ASTM D870 | 250 Hours Minimum |
| Gloss Retention | Florida (1 Year) | 50% + Retention |

Film properties based on iron phosphate pretreatment with chrome seal

| Property | Pretreatment | Salt Spray 300 Hours | Salt Spray 500 Hours | Salt Spray 750 Hours |
|----------------------|----------------------|-------------------------|-------------------------|-------------------------|
| Corrosion Resistance | Zinc Phos/Non Chrome | 0 - 1 mm | 0 - 3 mm | 0 - 7 mm |
| | Iron Phos/Chrome | 0 - 2 mm | 1 - 5 mm | 3 - 7 mm |

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

Commercial Uses

- Agricultural Implements
- Air Conditioners
- Clears for Brass and Other Plated Substrates
- Heavy Duty Equipment
- Lawn & Garden
- Microwave Ovens
- Refrigeration Products
- Switchgear
- Transformers
- Water Coolers
- Welding Equipment
- Wheels

Application Data

Bake: 20 minutes at 350°F (177°C) metal temperature – Standard Cure
VOC: 2.0 - 2.4 lbs per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None



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