POWERCRON® 6000CX

POWERCRON 6000CX FEATURES

POWERCRON 6000CX is PPG's sixth generation cationic epoxy technology. It meets the requirements of the automotive parts and body specifications in a lead-free formulation.

Compared to early generation cationic epoxies, POWERCRON 6000CX features include:

- Lead-free formulation
  - Lead-free film
  - Lead-free effluent
- Excellent corrosion resistance
- Low VOC
- Haps-Free
- Small parts specification approval
- Approved for use with Topcoat (GM)

Revised: 3/22/2007

PRODUCT DESCRIPTION

POWERCRON 6000CX is a new cationic epoxy electrocoat from PPG Industries that offers significant benefits for the industrial marketplace. This product is recognized by automotive Original Equipment Manufacturers and demonstrates several improvements over early generation cationic epoxies.

POWERCRON 6000CX was formulated to meet automotive industry corrosion requirements without the use of heavy metals, namely lead and chrome. The resulting product is free of heavy metals in the coating film and in any effluent that is discharged from the system. This will allow painting operations to meet both the performance and environmental requirements of the automotive industry while at the same time eliminating the costs of hazardous waste disposal.

POWERCRON 6000CX meets the performance requirements of the automotive body and small parts specifications with a cure cycle of 20 minutes at 350°F metal temperature.

Other advantages of using this product are its very limited solvent usage and effluent discharge. It also has good throwpower, film appearance, and topcoatability.

APPROVALS

Automotive Parts and Accessories

	Specification No.	Status
• DaimlerChrysler	MS-PB45-1, MS-PB45-2	Approved
	MS-PB60-2B, MS-PB60-2C	Approved
• Ford	WSS-M2P177A2	Approved
	ESB-M64J12, ESB-M64J19	Approved
	ESB-M64J20, ESB-M64J23	Approved
	ESB-M64J25, ESE-M2P128A	Approved
	ESL-M2P122	Approved
	WSB-M64J28, WSB-M64J30	Approved
	WSB-M64J36, WSB-M64J38	Approved
	WSS-M64J39, WSS-M64J41	Approved
	WSS-M64J125	Approved
• General Motors	9984120, 9984136, 9984094	Approved
• Delphi	DX551400	Approved
• Underwriters Laboratories	UL1332	Recognized

POWERCRON® 6000CX

APPLICATION DATA

Standard Bake: 20 Minutes at 350°F Metal Temperature
VOC: < 0.6 lbs. per gallon minus water (as supplied)
HAPs: None
Heavy Metals: None

FILM PROPERTIES

Property	Test Method	Performance
Color	---	Black
Film Thickness	---	0.4 - 1.2 Mils
Gloss - 60 Degree	ASTM D523	55 – 75%
Pencil Hardness	ASTM D3363	2H Minimum
Crosshatch Adhesion	ASTM D3359	4B – 5B
Direct Impact	ASTM D2794	100 in-lb Minimum
Reverse Impact	ASTM D2794	60 in-lb Minimum
Humidity	ASTM D1735	500 Hours Minimum
Water Soak	ASTM D870	250 Hours Minimum
Gravelometer	GM9508P	6 Minimum
Throwpower	GM9535P	11 – 13 inches

Cold Rolled Steel Lab Panels, Zinc Phosphate Pretreatment.
0.8 mils Average Film Thickness, Cured 20 Minutes @ 350°F

CORROSION RESISTANCE

Substrate / Pretreatment	Salt Spray* 500 Hours	Salt Spray* 1000 Hours	20 Cycle** Scab
CRS/Zinc Phos/Chrome	0 – 1 mm	0 - 2 mm	1 – 2 mm
CRS/Zinc Phos/Non-Chrome	0 – 1 mm	1 – 2 mm	1 – 2 mm
CRS/Zinc Phos/DI Water	0 – 1 mm	1 – 3 mm	1– 4 mm
CRS/Iron Phos/Chrome	0 – 3 mm	3 – 6 mm	3– 8 mm
CRS/Iron Phos/Non-Chrome	0 – 3 mm	3 – 6 mm	3– 8 mm
CRS/Iron Phos/DI Water	4 – 8 mm	6 – 14 mm	10 – 20 mm
CRS/Untreated	3 - 5 mm	5 - 8 mm	11 – 15 mm
Galvanized/Zinc Phos/Chrome	-----	-----	0 - 2 mm

(Average Total Scribe Creep), * Salt Spray - ASTM B117
**** Cycle Scab - GM9511P, Cold Rolled Steel Lab Panels**
Cured 20 Minutes @ 350°F