

Advancements in corrosion protection



PPG PRIMERON® high-performance powder primer series



AMERICAS



We protect and beautify the world®



Why use a powder primer?

After blasting the metal surfaces, primers can be applied to slow down the speed of oxidation, create more consistency in the application of the powder coatings and allow the powder coatings to more easily bond to metal edges.



Do I really need a powder primer?

The question really depends on the problem you are solving and the job you are doing. Metals, such as iron and steel, that are prone to corrosion will benefit from the extra protection provided by a powder primer to help guard against puncturing and flaking long term. Powder primer is commonly recommended for these metals:

- Cast and forged aluminum
- Cast and wrought iron
- Zinc alloys

Do PPG powder primers meet industry specifications?

PPG powder primers meet ISO 12944. This specification serves as the industry benchmark for safeguarding steel structures against corrosion through protective paint systems. Initially introduced in 1998, this standard is a collaborative effort involving representatives from pivotal countries and companies vested in steel structure protection.

ISO 12944 encompasses nine parts, covering aspects such as environment classification, protective paint systems, laboratory test methods and systems for offshore structures.



ISO 12944 corrosivity categories

The environmental conditions and, thus, the severity of the environmental impact can vary greatly depending on the region. For this purpose, ISO 12944 distinguishes between different corrosivity categories with examples of typical environments.

Category and Typical Environment		Class	ISO 6270-1 Water Condensation	ISO 9227 Neutral Salt Spray	ISO 12944-6 Cyclic Aging
			Hours Tested		
LEAST SEVERE	C1 Indoor: Heated indoor spaces without elevated condensation.	Low	-	-	-
		Medium	-	-	-
		High	-	-	-
		Very High	-	-	-
	C2 Indoor: Unheated indoor spaces with increased condensation. Outdoor: Atmospheres with low level of pollution. Mainly rural areas.	Low	48	-	-
		Medium	48	-	-
		High	120	-	-
		Very High	240	480	-
	C3 Indoor: Production rooms with high humidity and low contamination. Outdoor: Urban and industrial atmospheres with moderate sulfur dioxide pollution. Coastal areas with low salinity.	Low	48	120	-
		Medium	120	240	-
		High	240	480	-
		Very High	480	720	-
	C4 Indoor: chemical facilities, swimming pools. Outdoor: Industrial areas and coastal areas with moderate salinity.	Low	120	240	-
		Medium	240	480	-
		High	480	720	-
		Very High	720	1,440	1,680
C5 Indoor: Buildings with almost permanent condensation and heavy air pollution. Outdoor: Industrial areas with high humidity and aggressive atmosphere.	Low	240	480	-	
	Medium	480	720	-	
	High	720	1,440	1,680	
	Very High	-	-	2,688	
MOST SEVERE CX Outdoor: Coastal and offshore areas with high salinity and industrial areas with extreme humidity.	Low	-	-	-	
	Medium	-	-	-	
	High	-	-	-	
	Very High	-	-	4,200	



PPG *Primeron* primer portfolio

Corrosion protection is a decisive factor for the durability of a part and one of the most significant challenges for the coatings industry.

PPG's *Primeron* primer product portfolio is designed to provide high corrosion resistance for a variety of substrates, including steel, hot-dip-galvanized steel, metalized steel and aluminum.

Each of the five product lines were designed with special features that meet various substrate, environmental and end-use requirements.

Suggested end uses

Gas or liquid tanks and pipelines

Truck, trailer and automotive parts

Agricultural and construction machinery

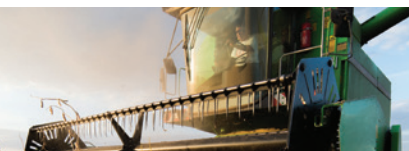
Automotive underbody and other parts

Seacoast or applications with high corrosion performance requirements



Primeron Legacy

A traditional zinc-rich primer offering our best corrosion protection in this technology



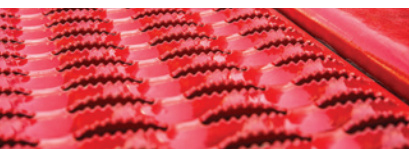
Primeron Optimal

A zinc-rich primer that delivers exceptional corrosion protection and a balanced offering of other properties



Primeron Auto

Designed for layered protection in automotive specialty markets, with options for exceptional flexibility, chip and corrosion resistance, UV durability and outgassing



Primeron Edge

High-edge primer technology offering best-in-class corrosion protection for substrates with sharp and laser-cut edges



Primeron Versa

Outgas-friendly, zinc-alternative primers that provide very excellent corrosion protection for multiple substrates





Zinc-rich primer with exceptional corrosion protection



Products, benefits and characteristics

- **PCM70140:** A traditional zinc-rich primer for use on mechanically pretreated steel, offering our best corrosion protection in this technology



ISO 12944 C4 primer that passes C5 specification for corrosion resistance



Very good flow and appearance



Low bake capability

Properties	Test Method	Value
Color	-	Dark gray
Surface	-	Semi-gloss, smooth
Gloss at 60°	ISO 2813	55-70
Specific Gravity	Calculated	3.6 g/cm ³
Impact Resistance	ISO 6272 / ASTM D2794	80 in./lbs. direct 80 in./lbs. reverse
Adhesion	ISO 2409	5B, pass
Conical Mandrel	ISO 6860	1/8", pass

Suggested Industries

Energy applications

General industrial

Automotive parts and accessories

Suggested End Uses

Gas or liquid tanks and pipelines

Seacoast walls, fences or metal objects

ISO 12944 Corrosivity Category

C4

Partial Curing

7 - 10 minutes	275° F (135° C)
3 - 5 minutes	300° F (149° C)
1 - 2 minutes	350° F (177° C)

Full Curing

20 minutes	275° F (135° C)
10 minutes	300° F (149° C)
5 minutes	350° F (177° C)

Storage Conditions

12 months / 77° F (25° C)



Zinc-rich primer with balanced performance properties



Products, benefits and characteristics

- **PCMT70149:** Exceptional corrosion resistance and a balanced offering of other properties, including better coverage, applied cost, adhesion, semi-conductivity, recoatability and transfer efficiency than traditional zinc primers



Corrosion performance on all substrates



Recoatable with higher transfer efficiency than traditional zinc primers



Almost double the theoretical coverage of *Primeron Legacy* primer

Properties	Test Method	Value
Color	-	Dark gray
Surface	-	Semi-gloss, smooth
Gloss at 60°	ISO 2813	55-70
Specific Gravity	Calculated	2.0 g/cm ³
Impact Resistance	ISO 6272 / ASTM D2794	160 in./lbs. direct
Adhesion	ISO 2409	5B, pass
Conical Mandrel	ISO 6860	1/8", pass

Suggested Industries

Heavy-duty equipment

General industrial

Automotive parts and accessories

Suggested End Uses

Construction/agricultural equipment

Seacoast walls, fences or metal objects

ISO 12944 Corrosivity Category

C5

Partial Curing

7 - 10 minutes	275° F (135° C)
3 - 5 minutes	300° F (149° C)
1 - 2 minutes	350° F (177° C)

Full Curing

20 minutes	275° F (135° C)
10 minutes	300° F (149° C)
5 minutes	350° F (177° C)

Storage Conditions

12 months / 77° F (25° C)



Layered protection for automotive and specialty markets



Products, benefits and characteristics

- **PCF90202, PCF70406:** polyester epoxy primers for aluminum wheels with great adhesion to liquid topcoats and excellent outgassing
- **PCT99157:** UV-durable polyester primer for aluminum wheels with great adhesion to liquid topcoats and excellent outgassing
- **PCM90133:** epoxy primer for steel/aluminum underbody applications with excellent performance over electrocoat or used as a monocoat
- **PCF70404:** polyester epoxy primer for steel/aluminum with excellent chip resistance when used over electrocoat
- **PCT90111M:** multi-use, polyester primer optimized for alkyd topcoats



Excellent layering over e-coat or under liquid topcoats



Good flow, appearance and mechanical properties



Options for chip resistance, UV durability and outgassing

Suggested Industries

Automotive parts and accessories

Suggested End Uses

Aluminum wheels

Automotive underbody parts

Automotive body

ISO 12944 Corrosivity Category

C4: PCM90133

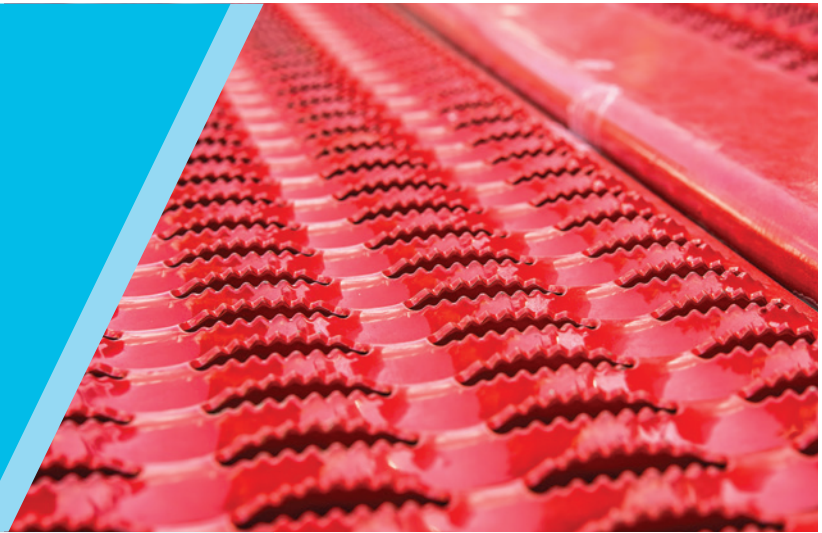
C3: All other products

Properties*	PCF90202	PCF70406	PCT99157	PCM90133	PCF70404	PCT90111M
Color	Black	Gray	Black	Black	Gray	Black
Surface	Smooth	Smooth	Smooth	Smooth	Smooth	Smooth
Gloss at 60°	70 minimum	70 minimum	80 minimum	80 minimum	10-25	55-70
Specific Gravity	1.3 g/cm ³	1.3 g/cm ³	1.2 g/cm ³	1.5 g/cm ³	1.3 g/cm ³	1.6 g/cm ³
Impact Resistance	100 in./lbs. direct	100 in./lbs. direct	80 in./lbs. direct	160 in./lbs. direct	100 in./lbs. direct	80 in./lbs. direct
Adhesion	5B, pass	5B, pass	5B, pass	5B, pass	5B, pass	5B, pass
Conical Mandrel	1/8", pass	1/8", pass	1/8", pass	1/8", pass	1/8", pass	1/8", pass
Full Curing	20 minutes 350° F (171° C)	30 minutes 350° F (171° C)	30 minutes 350° F (171° C)	5 minutes 350° F (171° C)	30 minutes 350° F (171° C)	25 minutes 350° F (177° C)

* Properties on this page use the same test methods as other Primeron products. For information about full curing at other temperatures, partial curing or storage conditions, please contact your PPG sales representative or email ic-na@ppg.com.



Designed for best-in-class sharp edge protection



Products, benefits and characteristics

- **PCMT30105:** A semi-conductive product that allows for easier topcoating and provides excellent sharp edge protection
- **PCF70283:** A preferred primer for heavy-duty equipment, offering good edge corrosion resistance and overall protection



Strong corrosion protection



Enhanced edge coverage for sharp, complex or laser-cut parts



Can help eliminate edge rounding equipment / extra machining

Properties	Test Method	Value*
Color	-	Medium gray (PCF70283) Light tan (PCMT30105)
Surface	-	Smooth
Gloss at 60°	ISO 2813	Varies by product
Specific Gravity	Calculated	1.6 g/cm ³
Impact Resistance	ISO 6272 / ASTM D2794	80 in./lbs. direct
Adhesion	ASTM D3359	5B, pass
Conical Mandrel	ASTM D522	1/8", pass

* Values indicate a range of performance across the entire family of products. For product-specific values, please contact your PPG sales representative or email ic-na@ppg.com.

Suggested Industries

Heavy-duty equipment

Electrical and power generation

Suggested End Uses

Vents, steps and louvres

Electrical boxes and air conditioners

ISO 12944 Corrosivity Category

C4: PCMT30105

C3: PCF70283

Partial Curing*

5 - 7 minutes	350° F (177° C)
4 - 5 minutes	375° F (191° C)
3 - 4 minutes	400° F (204° C)

Full Curing*

16 - 20 minutes	350° F (177° C)
12 - 15 minutes	375° F (191° C)
8 - 12 minutes	400° F (204° C)

Storage Conditions

12 -24 months / 77° F (25° C)



Versatile primers for multi-substrate use



Products, benefits and characteristics

- **PCMT70101:** Surface-tolerant epoxy primer that has good adhesion, great coverage and easy application with semi-conductivity that facilitates topcoat application
- **PCMB70102:** A user-friendly epoxy primer that can adapt to many different applications; especially outgas-friendly when used over galvanized steel and cast metals



Strong corrosion protection across a broad range of substrates



Good intercoat adhesion and compatibility with a wide range of topcoats



Excellent alternatives to zinc-rich primers

Properties	Test Method	Value*
Color	-	Gray
Surface	-	Smooth
Gloss at 60°	ISO 2813	Varies by product
Specific Gravity	Calculated	1.6 g/cm ³
Impact Resistance	ISO 6272 / ASTM D2794	80 in./lbs. direct
Adhesion	ASTM D3359	5B, pass
Conical Mandrel	ASTM D522	1/8", pass

* Values indicate a range of performance across the entire family of products. For product-specific values, please contact your PPG sales representative or email ic-na@ppg.com.

Suggested Industries

Electrical and power generation

General industrial

Suggested End Uses

Fencing, utility poles, lamp posts

Stadium seating

ISO 12944 Corrosivity Category

C5: PCMT70101

C4: PCMB70102

Partial Curing*

6 - 9 minutes	275° F (135° C)
3 - 5 minutes	300° F (149° C)
2 - 3 minutes	350° F (177° C)

Full Curing*

20 - 30 minutes	275° F (135° C)
10 - 20 minutes	300° F (149° C)
5 - 10 minutes	350° F (177° C)

Storage Conditions

12 months / 77° F (25° C)

Primeron primers key feature summary

	Primeron Legacy	Primeron Optimal	Primeron Auto*	Primeron Edge*	Primeron Versa*
Key Features	Zinc primer offering our best corrosion protection in this technology	Zinc-rich primer with excellent corrosion protection and a balance of other properties	Layer with liquid topcoats or over e-coat for automotive-grade performance	Very good sharp edge coverage, hides casting defects	Multi-substrate capable, good intercoat adhesion, excellent alternative to zinc
Chemistry	Epoxy	Epoxy	Epoxy, polyester, polyester epoxy	Epoxy, polyester epoxy	Epoxy
Density	3.6 g/cm ³	2.0 g/cm ³	1.7 g/cm ³	1.6 g/cm ³	1.6 g/cm ³
Overall Corrosion Performance	★★★★	★★★★	★★★	★★★	★★★★
Edge Protection	★	★★★	★★	★★★	★★
Mechanical Properties	★★	★★	★★★	★★	★★
Coverage	★	★★	★★	★★★	★★★

* Values indicate a range of performance across the entire family of products. For product-specific values, please contact your PPG sales representative or email ic-na@ppg.com.





PPG: WE PROTECT AND BEAUTIFY THE WORLD®



A trusted global coatings leader

Operations in 70+ countries, with 100+ manufacturing facilities and ~50,000 employees



Renowned color expertise

Trend-setting palettes for home, auto and industry paired with unrivaled color matching



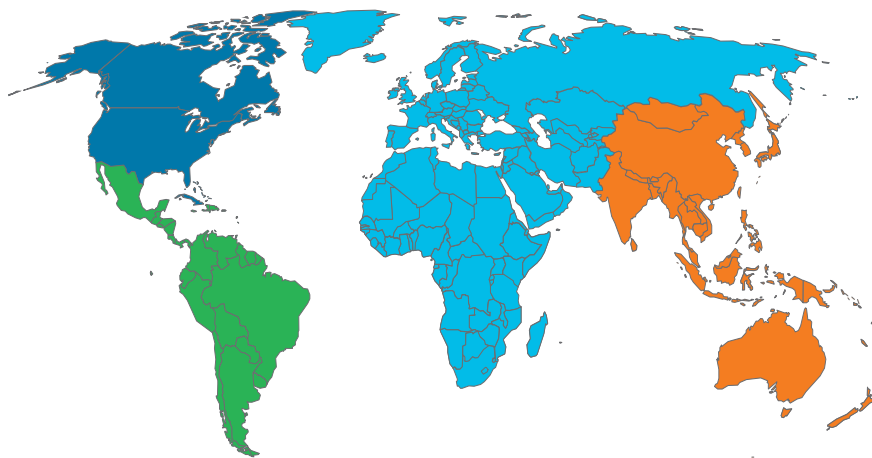
Commitment to sustainability

Over 38% of annual sales from sustainably advantaged products and processes



Dedication to innovation

3,500+ technical employees and \$463 MM average annual R&D investment



Industrial coatings from PPG

- World-class technical services and training
- Help meeting specific, coatings-related environmental mandates
- Assistance setting up new equipment and identifying areas where your processes may be streamlined
- Troubleshooting production issues
- **SECURE LAUNCH EXCELLENCE®** accelerated custom product formulation and color development process

To learn more about PPG coatings, please visit us online at ppgindustrialcoatings.com, or contact one of the international sales offices listed below.

PPG Regional Headquarters

■ PPG Global Headquarters / PPG North America
Pittsburgh, PA USA
ic-na@ppg.com

■ PPG Latin America
Sumare, Sao Paulo, Brazil
+ 55.19.3864.6000
ic-latam@ppg.com

■ PPG Europe, Middle East and Africa
Rolle, Switzerland
+ 41.21.822.3000
ic-emea@ppg.com

■ PPG Asia Pacific
Hong Kong, China
+ 852.2860.4500
ic-ap@ppg.com

■ PPG China HQ
Shanghai, China
+86 21 60918500
ic-cn@ppg.com

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