



## A versatile primer for multi-substrate use

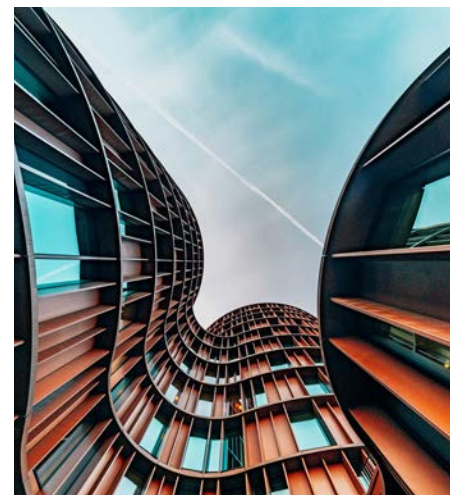


### A flexible solution

One of the most frequent substrates coated with powder coatings is steel. However, other substrates, such as metalized steel, hot-dip galvanized steel and aluminum, also need protection from corrosion. PPG ENVIROCRON<sup>®</sup> PRIMERON<sup>™</sup> FLEX is a specially developed hybrid powder coating optimally suited for various substrates. At the same time, the system offers excellent inter-coat adhesion to different topcoat systems and can be used flexibly in the truest sense of the word. In addition, various Qualisteelcoat approvals confirm its good corrosion protection properties.

### Benefits

- Strong corrosion protection
- Suitable for various substrates
- Very good flow and appearance
- High chemical resistance
- Good application stability
- Good intercoat adhesion
- Low consumption
- Formulated without Zinc NIA\*



\*Not intentionally added



## Product Properties

Properties	Test Method	Value
Gloss at 60°	ISO 2813	20-40 gloss units
Specific Gravity	Calculated	1,54 g/cm <sup>3</sup>
Impact Resistance	ISO 6272 / ASTM D2794	40 inch-pound - Direct 20 inch-pound - Reverse
Adhesion	ISO 2409	GTO
Conical Mandrel Bending	ISO 6860	0 - 10 mm

## Corrosion Performance

Test	Test Method	Substrate	Corrosion from Scribe	Surface Defects
NSS (Neutral Salt Spray Test) - 720 h	ISO 9227	Steel pretreated (1)	< 1 mm	No blisters, no rust
		Blasted steel (2)	< 1 mm	No blisters, no rust
CCT (Cyclic Corrosion Testing) - 1680 h	-	Steel pretreated (1)	< 1 mm	No blisters, no rust
		Blasted steel (2)	< 1 mm	No blisters, no rust
Humidity Resistance (40°C, 100% RH) - 720 h	-	Steel pretreated (1)	-	No blisters, no rust
		Blasted steel (2)	-	No blisters, no rust

(1): Chemical pretreatment - Alkaline (Iron phosphate) - Chrome free

(2): Blasted steel - Sanding media: Grit blast, Sanding rating: Sa 2 ½, Rugosity: 6<Ra<12 µm, 50 < Rt <75 µm

## Estimated Durability according to ISO 12944 Standard

Pretreatment	Substrate	C2	C3	C4	C5
Chemical	Steel	PE-0163, ST2 C4H			
Mechanical	Steel				
Chemical	Hot-dip galvanized				PE-0165, HD2 C5H
Mechanical	Hot-dip galvanized				PE-0166, HD2 C5H

## Curing Conditions

Partial Curing	
7 - 10 min	130°C
5 - 7 min	140°C
3 - 5 min	150°C

Full Curing	
20 - 40 min	170°C
15 - 35 min	180°C
10 - 25 min	190°C

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