



BONDERITE® M-PP 930™ Autodeposition Coating

Henkel's BONDERITE® M-PP 930™ coating delivers enhanced corrosion performance for demanding applications like vehicle frames and chassis components.

BONDERITE® M-PP 930™ coating has achieved high levels of performance on Neutral Salt Spray (NSS) testing and automotive Original Equipment Manufacturer (OEM) cyclic corrosion tests. This epoxy-acrylic urethane coating has excellent thermal stability, topcoatability, edge protection and flexibility.

BONDERITE® M-PP 930™ Coating Anti-Corrosion Properties

THESE TESTS WERE PERFORMED AND MET OR EXCEEDED OEM SPECIFICATIONS.
504 HRS. NSS, ASTM B-117
GMW 14872 (UB) Exposure D
60 CYCLES SAE J2334
CETP:L-467 (9 weeks)

The information contained herein is based on information believed by Henkel to be accurate at the date of publication. No guarantee of performance is given. Additional information and assistance may be obtained by contacting Henkel Corporation.

Product Features & Benefits:

- Environmentally sustainable — no toxic heavy metals, very low VOCs (<0.03 lbs./gal.)
- Compliant with environmental regulations ELV, REACH, RoHS and WEEE
- Lower maintenance requirements — no ultrafiltration, no rectifiers, no electrodes, fewer stages

Process/Application Advantages:

- Unlimited throwing (wetting) power with uniform coverage
- Coats fully assembled parts (withstanding high temperature cure)
- Inside and outside part protection
- No electrical contacts required
- No special rack stripping required
- Lower energy costs
- Lower applied costs

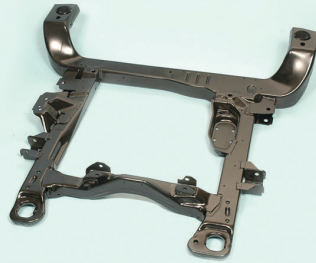
Excellent Physical Properties:

- Excellent cyclic corrosion protection
- Heat stability [230°C (450°F) for 16 hours]
- Excellent flexibility and impact resistance
- Uniform low-gloss appearance

BONDERITE® Co-Cure Process

BONDERITE® M-PP 930™ and powder coating topcoats are commercially "co-cured" together in a single oven, reducing energy requirements and the production footprint significantly.





BONDERITE® M-PP 930™ Coating Film Properties

TEST	PERFORMANCE
FILM THICKNESS (MILS)	0.8 – 1.0 (20 – 25 µm)
CROSS HATCH ADHESION	No Failure
GLOSS	10-30 @ 60°
PENCIL HARDNESS	H – 3H
COLOR	Black
REVERSE IMPACT	> 80 in. lbs.

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Product Line Support

Henkel's BONDERITE® team is made up of chemists, engineers, application specialists and pilot plant facilities that can assist you in the evaluation, design and installation of autodeposition coating processes. For more information, please contact the Henkel BONDERITE® Coatings Group at 1.866.332.7024 in the U.S., 1.905.814.6511 in Canada.

Autodeposition Application Benefits

Compared to conventional coating operations, autodeposition:

- Requires significantly less manpower and equipment, less cycle time, energy, part rework, handling, packaging and transportation
- Can be used in a combined cure sequence with some topcoats due to low VOC in the BONDERITE® M-PP 930™ coating
- Is self-limiting — cannot be over-applied
- Provides uniform coating thickness on all part surfaces, including edges and complex shapes

“Where it wets, it coats,” is a familiar attribute of the autodeposition coating process. The process uniformly coats the inside, outside and edges of complex shapes and tubular structures, increasing corrosion resistance on the most corrosion-prone part locations. The performance, application, and process benefits translate into a more flexible supply chain with lower total cost. That's why BONDERITE® M-PP 930™ is “The Smart Coating Solution.”

Application Information

Application Equipment: Autodeposition coatings are applied with common industrial cleaning methods, followed by a three-step immersion coating process using hoist or conveyor systems.

- Typical cure schedule for BONDERITE® M-PP 930™ with the BONDERITE® M-PT E2™ Reaction Rinse is in a two-zone oven: in zone one for 10 minutes at 150°F to 165°F (65°C to 75°C) and, a second zone for 20-30 minutes at 325°F to 350°F (163°C to 177°C) metal temperature. Typical Cure Schedule for BONDERITE® M-PP 930™ with the BONDERITE M-PT E3™ Reaction Rinse is in a two-zone oven: in zone one for 10 minutes at 150°F to 165°F (65°C to 75°C) and, then, a second zone for 20-30 minutes at 375°F to 400°F (191°C to 204°C) metal temperature.
- VOC: Less than 0.03 pounds per gallon minus water (as calculated based on U.S. EPA Method 24.)
- Hazardous Air Pollutants: None
- Hazardous Heavy Metals: None in coating or process chemistry.
- A Henkel representative can assist you in the evaluation of products, process parameters and cure schedule.

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