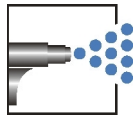




FREIOTHERM-Powder Coating

PI3012F

Characteristics	■ Powder coating for interior use ■ Application, e.g. in the functional furniture and storage technology sector ■ satin mat, micro structure ■ Metallic effect, bonded ■ Uniform surface structure across a range of 70 to 110 µm ■ Good mechanical resistance and scratch resistance												
System Coating	■ System Liquid Coating For various applications, there are coatings available, whose optical appearance regarding colour, gloss degree and surface is in optimum balance.												
Technical / Physical Data	<table> <tr> <td>■ Binder-Base</td><td>polyester resin</td></tr> <tr> <td>■ Colour</td><td>Pure bright colour shades and white-dependent tones cannot be created.</td></tr> <tr> <td>■ Gloss value visual</td><td>satin mat</td></tr> <tr> <td>■ Test layer thickness</td><td>80 µm by colour RAL 9006</td></tr> <tr> <td>■ Density calculated</td><td>1,2-1,7 g/cm³ colour-dependent</td></tr> <tr> <td>■ Material usage</td><td>0,12 kg/m² with 80 µm mean test layer thickness</td></tr> </table>	■ Binder-Base	polyester resin	■ Colour	Pure bright colour shades and white-dependent tones cannot be created.	■ Gloss value visual	satin mat	■ Test layer thickness	80 µm by colour RAL 9006	■ Density calculated	1,2-1,7 g/cm³ colour-dependent	■ Material usage	0,12 kg/m² with 80 µm mean test layer thickness
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Processing and application Dependent on plant and buildings	■ Processing / Loading Corona ■ Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. If requirements are more demanding than this, we recommend appropriate levels of phosphatizing or chromatising. ■ Touch-up coating: on enquiry												



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Health & Safety at Work guidelines

The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

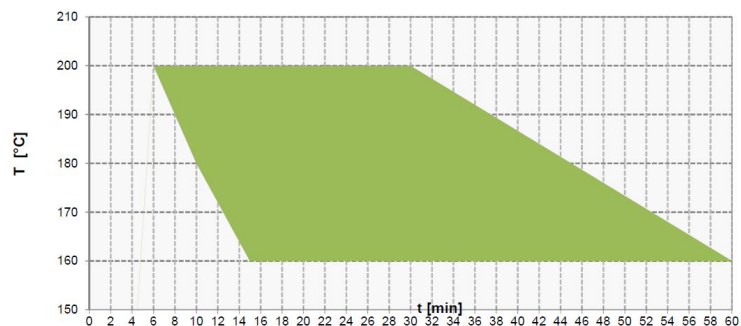
Curing

Object temperature

Recommended baking temperature 10 min./180 °C

Baking window tested in colour shade RAL 9006
green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C	160	180	200		
Object Temperature °C					
Haltezeit Minimum Minuten	10	10	6		
Holding time minimum Minutes					
Haltezeit Maximum Minuten	60	45	30		
Holding time maximum Minutes					



Resistance to storage

- Approx. 36 month in original packagings at an ambient temperature of 5 to 25 °C. Powder coatings must be stored in a cool and dry place.

The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.

Specific comments

- Protective screening:** 160 µm

- Compatibility with other powder coatings:** Needs to be checked

EFD-Info

Refer to the EFD information for further technical information.
No. 502

Test conditions

All information is based on a standard climate 23/50 DIN EN 23270.
All information is based on our product knowledge and experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.
The information provided here contains reference values and does not constitute a specification.