



FREOPOX-Powder Coating

PL6504A

Characteristics	■ Powder coating for interior use ■ Application, e.g. in the construction and sanitary sector ■ glossy, smooth ■ Good mechanical resistance and surface hardness ■ Good temperature resistance ■ For overcoating of e-coats, white												
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>epoxy polyester resin</td></tr> <tr> <td>■ Colour</td><td>all common colour shades</td></tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td><td>glossy 70-80 geometry 60°</td></tr> <tr> <td>■ Test layer thickness</td><td>70 µm by colour RAL 9016</td></tr> <tr> <td>■ Density calculated</td><td>1,2-1,7 g/cm³ colour-dependent</td></tr> <tr> <td>■ Material usage</td><td>0,1 kg/m² with 70 µm mean test layer thickness</td></tr> </table>	■ Binder-Base	epoxy polyester resin	■ Colour	all common colour shades	■ Gloss value DIN EN ISO 2813	glossy 70-80 geometry 60°	■ Test layer thickness	70 µm by colour RAL 9016	■ Density calculated	1,2-1,7 g/cm³ colour-dependent	■ Material usage	0,1 kg/m² with 70 µm mean test layer thickness
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Resistance Test	■ on iron-phosphatized steel sheet <table> <tr> <td>■ Condensate constant climate DIN EN ISO 6270-2 (CH)</td><td>500 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8</td></tr> <tr> <td>■ Salt spray test (NSS) DIN EN ISO 9227</td><td>240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8</td></tr> <tr> <td>■ Chemical resistance</td><td>Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.</td></tr> </table>	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	500 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8	■ Salt spray test (NSS) DIN EN ISO 9227	240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8	■ Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.						
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Processing and application Dependent on plant and buildings	■ Processing / Loading Corona, Tribo ■ 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 chromating. ■ Touch-up coating: on enquiry ■ Health & Safety at Work guidelines												

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms of business and delivery.

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EMAS

Emil Frei GmbH & Co. KG
Döggingen
Am Bahnhof 6
78199 Bräunlingen | GERMANY
Phone +49 [0] 7707.151-0
Fax +49 [0] 7707.151-238
www.freilacke.de
info@freilacke.de



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Curing

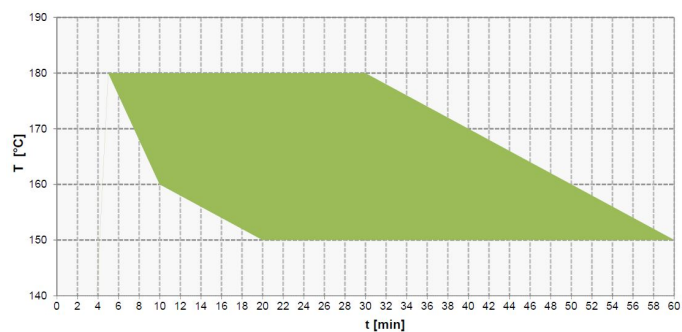
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

■ Baking window

Baking window tested in colour shade RAL 9016
green cross-hatching = baking conditions with good final properties

The displayed baking conditions are based on results from laboratory tests and therefore merely serve as a guideline when configuring the processing company's coating systems. The processing company is responsible for ensuring that the coating is fully cured. The complete curing of the coating must be checked by means of additional analytical and resistance tests using representative original parts under production conditions. Please do not hesitate to contact us if you require consultation.

Objekt Temperatur °C Object Temperature °C	140	150	160	180	
Haltezeit Minimum Minuten Holding time minimum Minutes	0	20	10	5	
Haltezeit Maximum Minuten Holding time maximum Minutes	0	60	50	30	



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

■ 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.