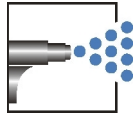


FREIOTHERM-Powder Coating

PS5603F

Characteristics	■ Powder coating for decorative use on exteriors ■ Application, e.g. in the vehicle construction sector ■ satin glossy, smooth ■ Metallic effect, bonded ■ Good mechanical resistance and surface hardness ■ Very good light and weather 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>all common colour shades</td></tr> <tr> <td>■ Gloss value visual</td><td>satin glossy</td></tr> <tr> <td>■ Test layer thickness</td><td>80 µm by colour K2850</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	all common colour shades	■ Gloss value visual	satin glossy	■ Test layer thickness	80 µm by colour K2850	■ 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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Mechanical Test on steel panel ST 1405	<table> <tr> <td>■ Cross-cut-test DIN EN ISO 2409</td><td>Gt 0</td></tr> <tr> <td>■ Erichsen index DIN EN ISO 1520</td><td>>3 mm</td></tr> <tr> <td>■ Impact-Test DIN EN ISO 6272-1</td><td>80 kg cm (front)</td></tr> </table>	■ Cross-cut-test DIN EN ISO 2409	Gt 0	■ Erichsen index DIN EN ISO 1520	>3 mm	■ Impact-Test DIN EN ISO 6272-1	80 kg cm (front)						
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Resistance Test	■ on blasted steel plate with suitable primer (i.e. cathodic dip paint or powder coating base) ■ 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 500 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.												
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 chromatizing. ■ 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.

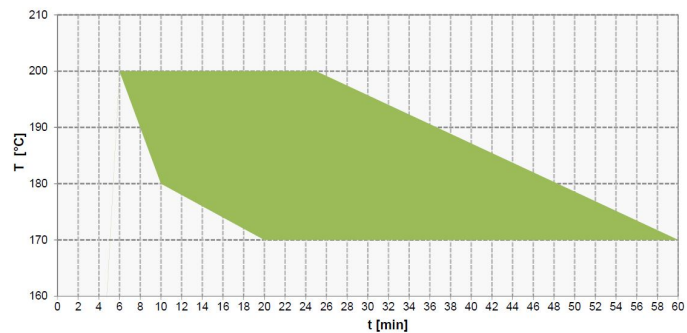
Curing

Object temperature

Recommended baking temperature 10 min./180 °C

Baking window tested in colour shade K2850
green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C Object Temperature °C	170	180	190	200	
Haltezeit Minimum Minuten Holding time minimum Minutes	20	10	8	6	
Haltezeit Maximum Minuten Holding time maximum Minutes	60	45	35	25	



Resistance to storage

- Approx. 24 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.