FreiLacke

FREIOTHERM-Powder Coating
PP1301C

Characteristics	■ Powder coating for decorative use on exteriors ■ Application, e.g. in the vehicle construction sector ■ mat, smooth ■ Good mechanical resistance and surface hardness ■ Good light and weather resistance ■ Smooth to apply	
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	■ Binder-Base	polyester resin
	■ Colour	all common colour shades
	■ Gloss value DIN EN ISO 2813	mat 10-20 geometry 60°
	■ Test layer thickness	70 µm by colour RAL 7021
	■ Density calculated	1,2-1,7 g/cm³ colour-dependent
	■ Material usage	0,1 kg/m² with 70 µm mean test layer thickness
Mechanical Test on steel panel ST 1405	■ Cross-cut-test DIN EN ISO 2409	Gt 0
	■ Erichsen index DIN EN ISO 1520	>2 mm
	■ Impact-Test DIN EN ISO 6272-1	80 kg cm (front)
	■ Buchholz penetration test DIN EN ISO 2815	<1,2 mm
Resistance Test	■ on zinc phosphatized steel plate	
	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	1000 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, 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 chromatizing.	

DIN EN ISO 9001
IATF 16949
EMAS

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- **Touch-up coating:** on enquiry
- **Health & Safety at Work guidlines**

  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.

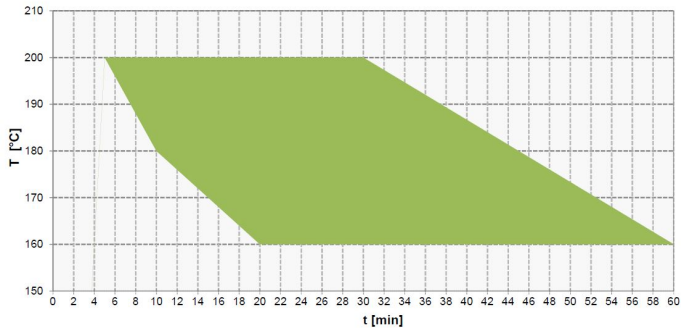
Curing

- **Object temperature**

  Recommended baking temperature 10 min./180 °C

  Baking window tested in colour shade RAL 7021
  green cross-hatching = baking conditions with good final properties

Objekt Temperatur | °C Object Temperature | °C		160	180	200	
Haltezeit Minimum | Minuten Holding time minimum | Minutes		20	10	5	
Haltezeit Maximum | Minuten Holding time maximum | Minutes		60	45	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 an 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.

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