FreiLacke

FREOPOX-Powder Coating
PB5333M

Characteristics	■ Powder coating for interior use	
	■ Application, e.g. in the construction and sanitary sector	
	■ satin glossy, coarse structure	
	■ Metallic effect, bonded	
	■ Uniform surface structure across a range of 100 to 150 µm	
	■ Good mechanical resistance and surface hardness	
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	epoxy polyester resin
	■ Colour	all common colour shades
	■ Gloss value visual	satin glossy
	■ Test layer thickness	80 µm by colour RAL 9006
	■ Density calculated	1,2-1,7 g/cm³ colour-dependent
	■ Material usage	0,13 kg/m² with 80 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	>4 mm
	■ Impact-Test DIN EN ISO 6272-1	80 kg cm (front)
Resistance Test	■ on iron-phosphatized steel sheet	
	■ 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.
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. For more demanding requirements on corrosion inhibiting properties, we recommend suitable conversion processes (e.g. phosphatizing).	
	■ **Touch-up coating:** on enquiry	
	■ **Health & Safety at Work guidlines**	

DIN EN ISO 9001
IATF 16949
EMAS

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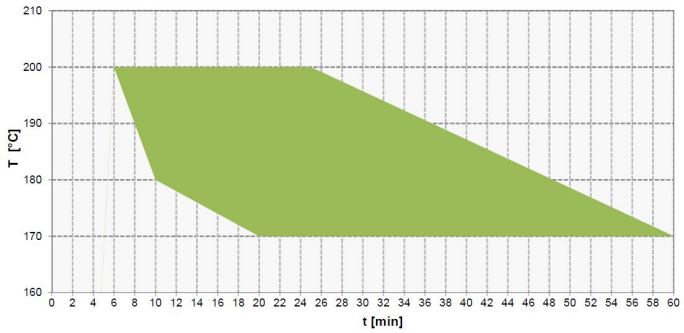
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

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 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. 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 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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