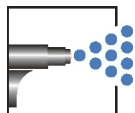


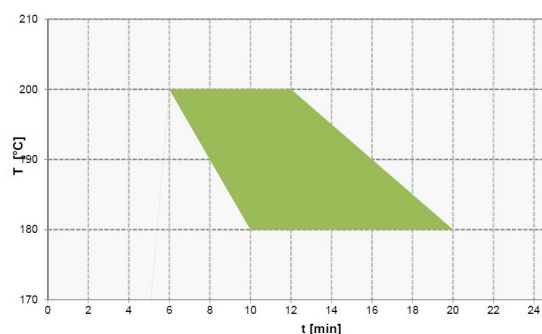
FREOCRYL-Powder Coating PX6000BRA999

| | | | | | | | | | |
|---|---|---------------|-------------------|-------------------------|----------|------------------------|----------------------|-------------------------|-----------|
| Characteristics | <ul style="list-style-type: none"> ■ Powder coating for decorative use on exteriors ■ Application, e.g. in the vehicle construction sector ■ tuff mat, smooth ■ Smooth to apply | | | | | | | | |
| System Coating | <ul style="list-style-type: none"> ■ System Liquid Coating <p>For various applications, there are coatings available, whose optical appearance regarding colour, gloss degree and surface is in optimum balance.</p> | | | | | | | | |
| Technical / Physical Data | <table> <tr> <td>■ Binder-Base</td><td>polyester acrylic</td></tr> <tr> <td>■ Gloss value visual</td><td>tuff mat</td></tr> <tr> <td>■ Test layer thickness</td><td>80 µm by colour 9099</td></tr> <tr> <td>■ Density calculated</td><td>1,2 g/cm³</td></tr> </table> | ■ Binder-Base | polyester acrylic | ■ Gloss value visual | tuff mat | ■ Test layer thickness | 80 µm by colour 9099 | ■ Density calculated | 1,2 g/cm³ |
| ■ Binder-Base | polyester acrylic | | | | | | | | |
| ■ Gloss value visual | tuff mat | | | | | | | | |
| ■ Test layer thickness | 80 µm by colour 9099 | | | | | | | | |
| ■ Density calculated | 1,2 g/cm³ | | | | | | | | |
| Mechanical Test on steel panel ST 1405 | <ul style="list-style-type: none"> ■ Impact-Test DIN EN ISO 6272-1 <p>10 kg cm (front)</p> | | | | | | | | |
| Resistance Test | <ul style="list-style-type: none"> ■ Chemical resistance <p>Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.</p> | | | | | | | | |
| Processing and application Dependent on plant and buildings | <ul style="list-style-type: none"> ■ Processing / Loading Corona ■ Pretreatment The substrate must be free of adhesion-impairing substances ■ 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 | <ul style="list-style-type: none"> ■ Baking window Baking window tested in colour shade RAL 999 green cross-hatching = baking conditions with good final properties <p>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.</p> | | | | | | | | |



FREOCRYL-Powder Coating PX6000BRA999

| | | | |
|--------------------------------|-----|-----|-----|
| Objekt Temperatur °C | 180 | 190 | 200 |
| Object Temperature °C | 180 | 190 | 200 |
| Haltezeit Minimum Minuten | 10 | 8 | 6 |
| Holding time minimum Minutes | 10 | 8 | 6 |
| Haltezeit Maximum Minuten | 20 | 16 | 12 |
| Holding time maximum Minutes | 20 | 16 | 12 |



Resistance to storage

- Approx. 12 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

- Not compatible with other powder coatings (crater formation).

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.

Subsequent treatment

The coated surface must be dry and free of grease, silicone and dust before recoating, printing or bonding.

Pre-cleaning with a coating-compatible cleaning agent, such as a 50/50 isopropanol/water mixture, is applied during bonding.