



FREOPOX-Powder Coating

PB6405BR721A

Characteristics	■ Powder coating primer for light-alloy wheels ■ Application, e.g. in the automotive sector ■ high glossy, smooth ■ Good mechanical resistance and surface hardness ■ Degassing setting ■ Very 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	<table> <tr> <td>■ Binder-Base</td><td>epoxy polyester resin</td></tr> <tr> <td>■ Colour</td><td>RAL7021 Black grey</td></tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td><td>high glossy 80-100 geometry 60° at 10 min./200°C on aluminium Q-Panel A36</td></tr> <tr> <td>■ Test layer thickness</td><td>90 +/- 5 µm</td></tr> <tr> <td>■ Density calculated</td><td>1,2-1,4 g/cm³</td></tr> <tr> <td>■ Material usage</td><td>0,12 kg/m² with 90 µm mean test layer thickness</td></tr> </table>	■ Binder-Base	epoxy polyester resin	■ Colour	RAL7021 Black grey	■ Gloss value DIN EN ISO 2813	high glossy 80-100 geometry 60° at 10 min./200°C on aluminium Q-Panel A36	■ Test layer thickness	90 +/- 5 µm	■ Density calculated	1,2-1,4 g/cm³	■ Material usage	0,12 kg/m² with 90 µm mean test layer thickness
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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.												

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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IATF 16949
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	■ Touch-up coating: on enquiry
	■ 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	■ Baking window Baking window tested in colour shade RAL RA721 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.
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. 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.