FreiLacke

FREOPOX-Powder Coating
PB6405BR905

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	■ Binder-Base	epoxy polyester resin
	■ Colour	RAL 9005 jet black
	■ 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
Mechanical Test on steel panel ST 1405	■ Cross-cut-test DIN EN ISO 2409	Gt 0
	■ Erichsen index DIN EN ISO 1520	>3 mm
	■ Impact-Test DIN EN ISO 6272-1	>60 kg cm (front)
Resistance Test	■ on aluminium Q-Panel AQT	
	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8
	■ Salt spray test (CASS) 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. 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.

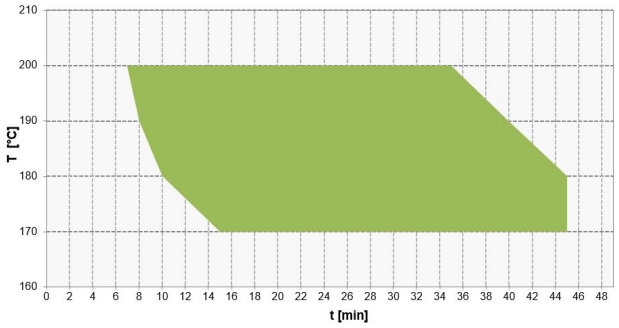
Curing

- **Baking window**

  Baking window tested in colour shade RAL 9005
  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.

Objekt Temperatur | °C Object Temperature | °C	170	180	190	200
Haltezeit Minimum | Minuten Holding time minimum | Minutes	15	10	8	7
Haltezeit Maximum | Minuten Holding time maximum | Minutes	45	45	40	35



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.

Subsequent treatment

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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.

This data sheet is valid for the variant A-Z.

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