



FREOPOX-Powder Coating PB4905A

Characteristics	■ Powder coating for interior use ■ Application, e.g. in the mechanical engineering and plant construction sector ■ high glossy, smooth ■ Good mechanical resistance and surface hardness ■ Cost-effective basic quality												
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>all common colour shades</td></tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td><td>high glossy >75 geometry 60°</td></tr> <tr> <td>■ Test layer thickness</td><td>70 µm by colour RAL N1232</td></tr> <tr> <td>■ Density calculated</td><td>1,2-1,7 g/cm³ colour-dependent</td></tr> <tr> <td>■ Material usage</td><td>0,1 kg/m² with 70 µm mean test layer thickness</td></tr> </table>	■ Binder-Base	epoxy polyester resin	■ Colour	all common colour shades	■ Gloss value DIN EN ISO 2813	high glossy >75 geometry 60°	■ Test layer thickness	70 µm by colour RAL N1232	■ Density calculated	1,2-1,7 g/cm³ colour-dependent	■ Material usage	0,1 kg/m² with 70 µm mean test layer thickness
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Resistance Test	■ on iron-phosphatized steel sheet <table> <tr> <td>■ Condensate constant climate DIN EN ISO 6270-2 (CH)</td><td>240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8</td></tr> <tr> <td>■ Salt spray test (NSS) DIN EN ISO 9227</td><td>120 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8</td></tr> <tr> <td>■ Chemical resistance</td><td>Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.</td></tr> </table>	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8	■ Salt spray test (NSS) DIN EN ISO 9227	120 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.						
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Processing and application Dependent on plant and buildings	■ Processing / Loading Corona, Tribo ■ Pretreatment The substrate must be free of adhesion-improving 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 chromating. ■ Touch-up coating: on enquiry ■ Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting												

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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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.

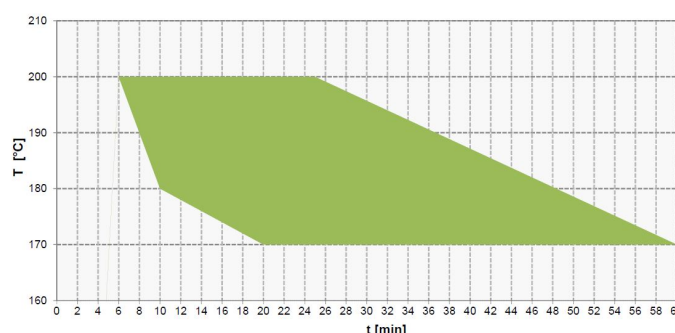
Curing

■ Object temperature

Recommended baking temperature 10 min./180 °C

Baking window tested in colour shade RAL N1232
green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C	170	180	190	200	
Object Temperature °C					
Haltezeit Minimum Minuten	20	10	8	6	
Holding time minimum Minutes					
Haltezeit Maximum Minuten	60	45	35	25	
Holding time maximum Minutes					



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.