



FREOPOX-Powder Coating

PB6804A

Characteristics	■ Powder coating for interior use ■ Application, e.g. in the construction and sanitary sector ■ glossy, smooth ■ Gas oven-resistant setting ■ Good mechanical resistance and surface hardness ■ For overcoating of e-coats, white												
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>glossy 75-80 geometry 60°</td></tr> <tr> <td>■ Test layer thickness</td><td>70 µm by colour RAL 9010</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	glossy 75-80 geometry 60°	■ Test layer thickness	70 µm by colour RAL 9010	■ 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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Processing and application Dependent on plant and buildings	■ Processing / Loading Corona, Tribo ■ 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. ■ Touch-up coating: on enquiry ■ Health & Safety at Work guidelines												

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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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./160 °C

Baking window tested in colour shade RAL 9010

green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C	160	180	200		
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Haltezeit Minimum Minuten	10	8	5		
Holding time minimum Minutes	10	8	5		
Haltezeit Maximum Minuten	60	30	15		
Holding time maximum Minutes	60	30	15		



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.