# **Technical Datasheet**





| Characteristics  | Powder coating for interior                               | ruse  |  |  |  |  |
|--|---|---|--|--|--|--|
|  | Application, e.g. in the construction and sanitary sector |   |  |  |  |  |
|  | satin glossy, coarse struc                                | satin glossy, coarse structure  |  |  |  |  |
|  | ■ Metallic effect, non-bon                                | Metallic effect, non-bonded   |  |  |  |  |
|  | Uniform surface structure                                 | Uniform surface structure across a range of 100 to 150 µm   |  |  |  |  |
|  | ■ Good mechanical resistar                                | Good mechanical resistance and surface hardness   |  |  |  |  |
| System Coating   | System Liquid 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  | all common colour shades  |  |  |  |  |
|  | Gloss value   | satin glossy  |  |  |  |  |
|  | ■ Test layer thickness                                    | 80 µm by colour RAL 9006  |  |  |  |  |
|  | Density<br>calculated                                     | 1,2-1,7 g/cm³ colour-dependent  |  |  |  |  |
|  | ■ Material usage  | 0,13 kg/m² with 80 μm<br>mean test layer thickness  |  |  |  |  |
| Mechanical Test<br>on steel panel ST 1405                      | Cross-cut-test DIN EN ISO 2409                            | Gt 0  |  |  |  |  |
|  | ■ Erichsen index<br>DIN EN ISO 1520                       | >4 mm   |  |  |  |  |
|  | ■ Impact-Test DIN EN ISO 6272-1                           | 80 kg cm (front)  |  |  |  |  |
| Resistance Test  | on iron phosphated steel                                  | on iron phosphated steel panel  |  |  |  |  |
|  | Condensate constant clim                                  | nate 500 hours<br>Water ingress Wb < 1 mm<br>DIN EN ISO 4628-8  |  |  |  |  |
|  | Salt spray test (NSS) DIN EN ISO 9227                     | 240 hours<br>Water ingress Wb < 1 mm<br>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<br>Dependent on plant and buildings | Processing / Loading<br>Corona                            |   |  |  |  |  |
|  | rust, scale, rolling skin, wa<br>For more demanding requ  | Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. For more demanding requirements on corrosion inhibiting properties, we recommend suitable conversion processes (e.g. phosphatizing). |  |  |  |  |
|  |   | Touch-up coating: on enquiry  |  |  |  |  |
|  |   |   |  |  |  |  |

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.

Page: 1 / 2 Version: 0 21.11.2021 DIN EN ISO 9001 IATF 16949 EMAS Emil Frei GmbH & Co. KG Döggingen Am Bahnhof 6 78199 Bräunlingen | GERMANY Phone +49 [0] 7707.151-0 Fax +49 [0] 7707.151-238 www.freilacke.de info@freilacke.de





### 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.

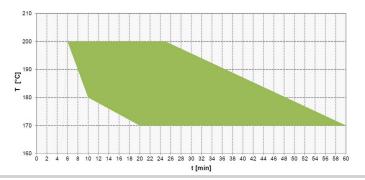
# Curing

# Object temperature

Recommended baking temperature 10 min./180 °C

Baking window tested in colour shade RAL 9006 green cross-hatching = baking conditions with good final properties

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



# 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
- **EFD-Info**

Refer to the EFD information for further technical information. No. 502

### 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.

Emil Frei GmbH & Co. KG