EFD-Info

Guideline for the processing of article group PB8904B – “No Bake Primer”

Coating structure

FREOPOX-Powder Coating PB8904B
FREIOTHERM-Metallic-Basecoat KO1808 or FREIOTHERM-Hydro-Basecoat WO1869
FREOCRYL-Powder Coating PY1005BR999x*

‘No Bake Primer’ processing proposal

Pre-heating of the wheel at a 220°C setting for the recirculating air. The length of pre-heat time depends on the workpiece (dimension). A minimum wheel-object temperature of at least 200°C must be present when applying the primer coating.

The primed wheel is then, without any further baking process, coated directly with liquid basecoat (FREIOTHERM-Metallic-Basecoat KO1808 or FREIOTHERM-Hydro-Basecoat WO1869).
During this process step, the wheel temperature should be between 60°C and 100°C, depending on the type of basecoat. Following application of the liquid coating, the wheel should be allowed to air-dry for approx. 10 minutes.

The air-dried wheel is then coated with acrylic powder PY1005BR999x* and then the entire coated surface is baked in accordance with the baking specifications on technical data sheet PY1005BR999x*.

The important thing here, in order to achieve a consistent shade of colour from one wheel to another, is to apply the basecoat to wheels that are at the same temperature.

This suggested application sequence is based on data obtained under laboratory conditions so it may differ under practical conditions. Any deviation from this application sequence, e.g. high-gloss turning, may result in the FREOPOX-Powder coating PB8904B having to be baked before further processing in order to fulfil all the required properties. This must be checked in all cases by the processing operative.
All information is given without guarantee.

x describes the variant (A-Z)*

Our safety and technical data sheets contain all further information.

DIN EN ISO 9001
ISO TS 16949
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