Technical Data Sheet





PP5101A FREIOTHERM-Powder Coating

Product description

Product technology Powder coating for decorative use on exteriors

Application area e.g. in the functional furniture and storage technology sector

Surface smooth

Running properties very good

Resistance to light and

weather

good

General product properties

Binder-Base polyester resin

Colour Pure bright colour shades ans white-dependent tones cannot be created.

Gloss value 15-25 GU, Angle 60° **DIN EN ISO 2813**

Density 1,2-1,7 g/cm3 depending on the shade theoretical

Resistance to storage approx. 24 month in original packagings at an ambient temperature of 5 to 25 °C. Powder

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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.

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, delivery and payment.

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Application and processing

Pretreatment

The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.

Recommended coating thickness

70-90 um

Corona, Tribo

Material usage

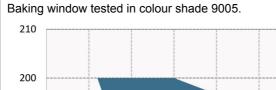
approx. 0,1 kg/m², layer thickness 80 µm

theoretical

Processing

Curing

Recommended object temperature 10 min/180 °C.



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Objekt Temperatur in °C Object Temperature in °C	180	200
Haltezeit Minimum in Minuten Holding time minimum in minutes	10	6
Haltezeit Maximum in Minuten Holding time maximum in minutes	45	15

Note on curing

Coloured area = stoving conditions with good end 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.

Compatibility

Compatibility with other powder coatings must be checked.

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DIN EN ISO 9001 | IATF 16949 | EMAS

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Further processing of coated pieces

Mechanical tests

Sample description On steel plate

70-90 µm layer thickness

10 minutes 180°C object temperature

product PP5101ARA905

Cross-cut-test Gt 0 **DIN EN ISO 2409 Cupping test** >6 mm **DIN EN ISO 1520 DIN EN ISO 6272-1** Impact-test >60 kg cm (front)

Climatic tests

climate

Sample description On zinc-phosphated steel plate

product PP5101ARA905

Condensate constant Load duration 240 h DIN EN ISO 6270-2 (CH)

> **Detachment Cut** <1 mm **DIN EN ISO 4628-8**

Neutral salt spray test Load duration 240 h **DIN EN ISO 9227 (NSS)**

Detachment Cut <1 mm **DIN EN ISO 4628-8**

Chemical resistance

Influencing factors The chemical resistance depends on the concentration, temperature, exposure time and test method. This has to be checked depending on the application.

Comments

Work-and The standard personal safety precautions must be observed when handling painting Healthprotection materials. Detailed information about dangerous goods, safety data and

recommendations concerning Health and Safety at Work and environmental protection

can be found in the corresponding safety data sheet.

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

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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.

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