





## PP5101A FREIOTHERM-Powder Coating

### 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 µm

#### Material usage

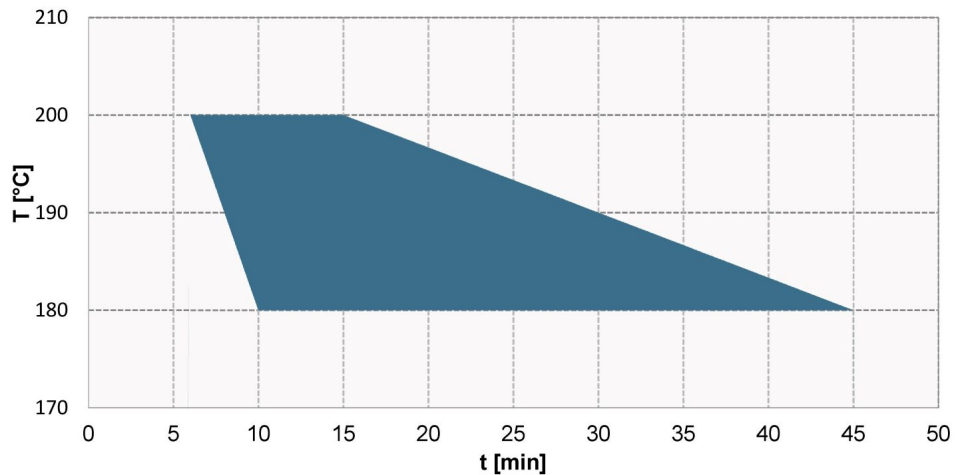
approx. 0,1 kg/m<sup>2</sup>, layer thickness 80 µm theoretical

#### Processing

Corona, Tribo

#### Curing

Recommended object temperature 10 min/180 °C.  
Baking window tested in colour shade 9005.



Objekt Temperatur in °C	<b>180</b>	<b>200</b>
Object Temperature in °C		

Haltezeit Minimum in Minuten	<b>10</b>	<b>6</b>
Holding time minimum in minutes		

Haltezeit Maximum in Minuten	<b>45</b>	<b>15</b>
Holding time maximum in minutes		

#### 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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### Further processing of coated pieces

**Touch-up coating** on request. For details see EFD Info No. 4..

### Mechanical tests

<b>Sample description</b>	On steel plate 70-90 µm layer thickness 10 minutes 180°C object temperature product PP5101ARA905		
<b>Cross-cut-test</b>	Gt 0		DIN EN ISO 2409
<b>Cupping test</b>	>6 mm		DIN EN ISO 1520
<b>Impact-test</b>	>60 kg cm (front)		DIN EN ISO 6272-1

### Climatic tests

<b>Sample description</b>	On zinc-phosphated steel plate product PP5101ARA905		
<b>Condensate constant climate</b>	Load duration	240 h	DIN EN ISO 6270-2 (CH)
	Detachment Cut	<1 mm	DIN EN ISO 4628-8
<b>Neutral salt spray test</b>	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

<b>Work-and Healthprotection</b>	The standard personal safety precautions must be observed when handling painting 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.
<b>Test conditions</b>	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.