



PB8905S FREOPOX-Powder Coating

Product description

Product technology	Powder coating primer for light-alloy wheels
Application area	e.g. in the automotive sector
Running properties	very good
Degassing	very good

General product properties

Binder-Base	epoxy polyester resin		
Gloss value	high glossy	80-100 GU, Angle 60° at 10 min./200°C on aluminum sheet Q-Panel A36	DIN EN ISO 2813
Test layer thickness	90 +/- 5 µm		
Resistance to storage	<p>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.</p> <p>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.</p>		

Application and processing

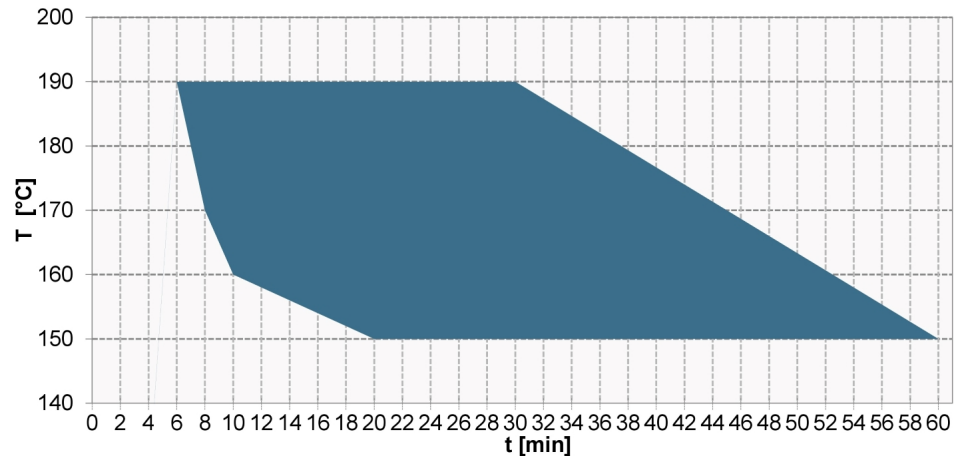
Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating, chromating) according to the requirements. For this we refer to the guidelines of Qualicoat, GSB and Qualisteelcoat.
Processing	Corona



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Curing

Baking window tested in colour shade RAL 9005.



Objekt Temperatur in °C Object Temperature in °C	150	160	170	180	190
Haltezeit Minimum in Minuten Holding time minimum in minutes	20	10	8	7	6
Haltezeit Maximum in Minuten Holding time maximum in minutes	60	52,5	45	37,5	30

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.

Further processing of coated pieces

Further processing

The coated surface must be dry and free of grease, silicone and dust before recoating, printing or bonding.
Pre-cleaning with a coating-compatible cleaning agent, such as a 50/50 isopropanol/water mixture, is applied during bonding.



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Mechanical tests

Cross-cut-test	Gt 0	DIN EN ISO 2409
Cupping test	>6 mm	DIN EN ISO 1520

Comments

Work-and Healthprotection	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.
Test conditions	<p>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.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>