




## PF2004F

## FREIOTHERM-Powder Coating Facade

### Product description

<b>Product technology</b>	Powder coating for decorative use on exteriors
<b>Application area</b>	e.g. in the building facade sector
<b>Surface finish</b>	Metallic effect
<b>Surface</b>	smooth
<b>Gloss value</b>	glossy
<b>Running properties</b>	good
<b>Production process</b>	bonded
<b>Gas furnace stability</b>	very good
<b>Approvals</b>	 GSB Florida 3 141 g

### General product properties

<b>Binder-Base</b>	polyester resin
<b>Colour</b>	All common colour shades
<b>Gloss visually</b>	glossy
<b>Density</b>	1,2-1,7 g/cm <sup>3</sup> depending on the shade <span style="float: right;">theoretical</span>
<b>Resistance to storage</b>	<p>approx. 24 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

<b>Pretreatment</b>	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.
<b>Recommended coating thickness</b>	60-80 µm
<b>Material usage</b>	approx. 0,1 kg/m <sup>2</sup> , layer thickness 70 µm <span style="float: right;">theoretical</span>
<b>Processing</b>	Corona



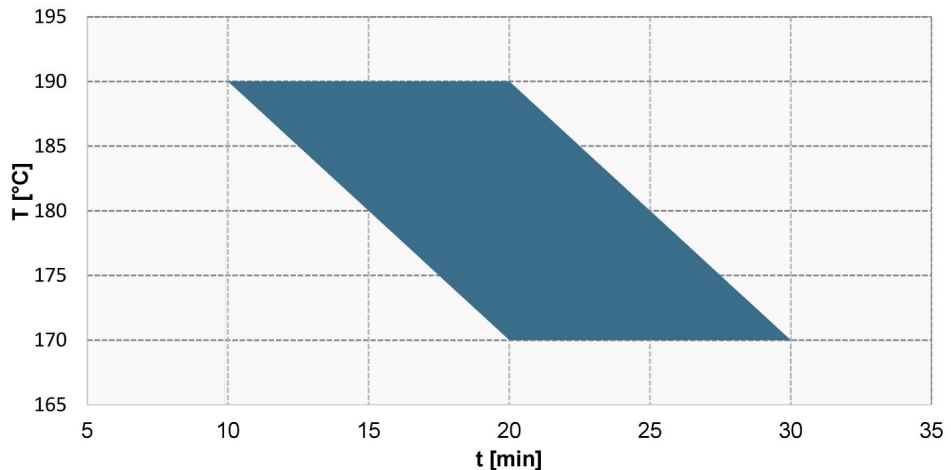
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### Curing

Recommended object temperature 15 min/180 °C.

Baking window tested in colour shade RAL 9006.



Objekt Temperatur in °C			
Object Temperature in °C	170	180	190

Haltezeit Minimum in Minuten			
Holding time minimum in minutes	20	15	10

Haltezeit Maximum in Minuten			
Holding time maximum in minutes	30	25	20

### 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

#### Touch-up coating

on request. For details see EFD Info No. 4..



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### Mechanical tests

<b>Sample description</b>	On aluminium-plated Q-panel AQT, 60-80 µm layer thickness, 15 minutes 180°C object temperature, product PF2004FRA906.		
<b>Cross-cut-test</b>	Gt 0		DIN EN ISO 2409
<b>Cupping test</b>	>5 mm		DIN EN ISO 1520
<b>Mandrel bending test cylindrical</b>	<=5 mm		DIN EN ISO 1519
<b>Impact resistance test</b>	>29 inch/lb (reverse)		ASTM D2794

### Climatic tests

<b>Sample description</b>	On chromated aluminium plate product PF2004FRA906		
<b>Condensate constant climate</b>	Load duration	1000 h	DIN EN ISO 6270-2 (CH)
	Detachment Cut	<1 mm	DIN EN ISO 4628-8
<b>SO2 industry atmosphere</b>	Load duration	30 cycles with 0.2 l	DIN EN ISO 3231
	Bubble degree Surface	0(S0)	DIN EN ISO 4628-2
	Detachment Cut	<=1 mm	DIN EN ISO 4628-8
	Change in colour and visual effect	Characteristic value <=2	DIN EN ISO 4628-1
<b>Neutral salt spray test</b>	Load duration	1000 h	DIN EN ISO 9227 (NSS)
	Detachment Cut	<1 mm	DIN EN ISO 4628-8

### Chemical resistance

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

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 502.
<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 and 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.
<b>Approvals</b>	GSB Florida 3 141g for colour shade RAL 9007 not available.