





PF1011T

FREIOTHERM-Powder Coating Facade

Product description

Product technology	Powder coating for decorative use on exteriors	
Application area	e.g. in the building facade sector	
Surface finish	Metallic effect	
Surface	micro structure	
Gloss value	mat	
Property	stable in circulation	
Production process	Dry mixing	
Gas furnace stability	very good	
Approvals	 GSB Florida 1 141 h	 Qualicoat P-1860

General product properties

Binder-Base	polyester resin	
Colour	All common colour shades	
Density	1,2-1,7 g/cm ³ depending on the shade	theoretical
Resistance to storage	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. 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.	

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.	
Recommended coating thickness	Uniform surface structure across a range of 60 to 100 µm	
Material usage	approx. 0,1 kg/m ² , layer thickness 70 µm	theoretical
Processing	Corona	

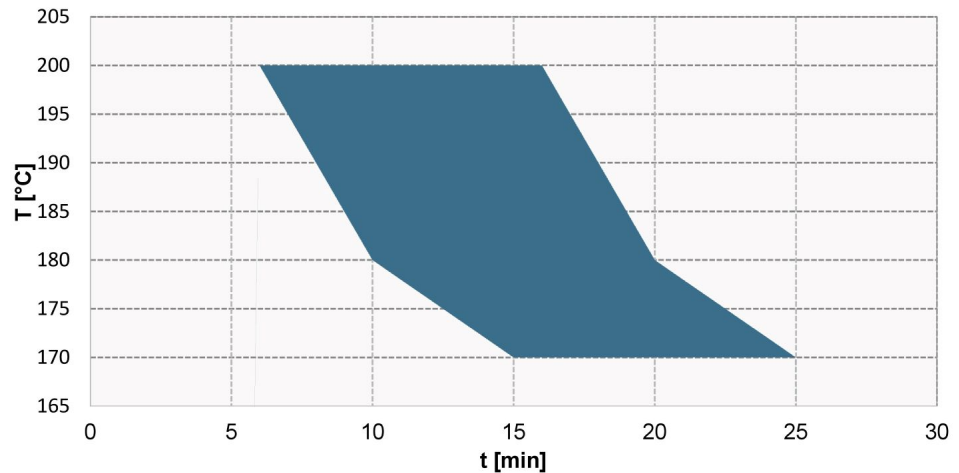


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Curing

Recommended object temperature 10 min/180 °C.
Baking window tested in colour shade RAL 9006.



Objekt Temperatur in °C Object Temperature in °C	170	180	190	200
Haltezeit Minimum in Minuten Holding time minimum in minutes	15	10	8	6
Haltezeit Maximum in Minuten Holding time maximum in minutes	25	20	18	16

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

Sample description	On aluminium-plated Q-panel AQT, 60-80 µm layer thickness, 10 minutes 180°C object temperature, product PF1011TRA906.		
Cross-cut-test	Gt 0		DIN EN ISO 2409
Cupping test	>5 mm		DIN EN ISO 1520
Mandrel bending test cylindrical	<=5 mm		DIN EN ISO 1519
Impact resistance test	>29 inch/lb (reverse)		ASTM D2794

Climatic tests

Sample description	On chromated aluminium plate product PF1011TRA906		
Condensate constant climate	Load duration	1000 h	DIN EN ISO 6270-2 (CH)
	Detachment Cut	<1 mm	DIN EN ISO 4628-8
SO2 industry atmosphere	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 <=3	DIN EN ISO 4628-1
Neutral salt spray test	Load duration	1000 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.
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 502.
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	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.