Technical Datasheet





Characteristics	Powder coating for decora	tive use on exteriors				
	Application, e.g. in the vehicle construction sector					
	■ high glossy, smooth					
	■ Good mechanical resistan	Good mechanical resistance and surface hardness				
	Smooth to apply	Smooth to apply				
	Degassing setting	Degassing setting				
System Coating	System Liquid Coating	System Liquid Coating				
	For various applications, there are coatings available, whose optical appearegarding colour, gloss degree and surface is in optimum balance.					
Technical / Physical Data	■ Binder-Base	polyester resin				
	Colour	all common colour shades				
	Gloss value DIN EN ISO 2813	glossy >85 geometry 60°				
	Test layer thickness	80 μm by colour RAL 9010				
	■ Density calculated	1,2-1,7 g/cm³ colour-dependent				
	■ Material usage	0,12 kg/m² with 80 μm mean test layer thickness				
Mechanical Test on steel panel ST 1405	Cross-cut-test DIN EN ISO 2409	Gt 0				
	■ Erichsen index DIN EN ISO 1520	>6 mm				
	■ Impact-Test DIN EN ISO 6272-1	80 kg cm (front)				
Resistance Test	on iron phosphated steel panel					
	Condensate constant clim	ate 500 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8				
	■ Salt spray test (NSS) DIN EN ISO 9227	240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8				
	■ Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.				
Processing and application Dependent on plant and buildings	Processing / Loading Corona					
	rust, scale, rolling skin, wa If requirements are more of	Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. If requirements are more demanding than this, we recommend appropriate levels of phosphatizing or chromatizing.				
	Touch-up coating: on enquiry					

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 and delivery.

Page: 1 / 2 Version: 1 22.11.2022 DIN EN ISO 9001 IATF 16949 EMAS Emil Frei GmbH & Co. KG Döggingen Am Bahnhof 6 78199 Bräunlingen | GERMANY Phone +49 [0] 7707.151-0 Fax +49 [0] 7707.151-238 www.freilacke.de info@freilacke.de





Health & Safety at Work guidlines

The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

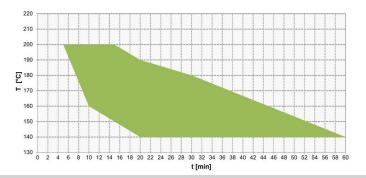
Curing

Baking window

Baking window tested in colour shade RAL 9010 green cross-hatching = baking conditions with good final 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.

Objekt Temperatur °C Object Temperature °C	140	150	160	180	200
Haltezeit Minimum Minuten Holding time minimum Minutes	20	15	10	8	5
Haltezeit Maximum Minuten Holding time maximum Minutes	60	50	50	30	15



Resistance to storage

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.

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.

Specific comments

■ Protective screening: 160 µm

Compatibility with other powder coatings: Needs to be checked

■ 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 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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