



PD6504A FREOPOX-Powder Coating

Product description

Product technology	Powder coating primer for powder-in-powder application
Application area	e.g. in the vehicle construction sector
Surface	smooth
Gloss value	glossy
Over-coating capability	very good
Corrosion protection	very good

General product properties

Binder-Base	epoxy polyester resin
Colour	All common colour shades
Gloss visually	glossy
Density	1,2-1,7 g/cm ³ depending on the shade theoretical
Resistance to storage	<p>approx. 12 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

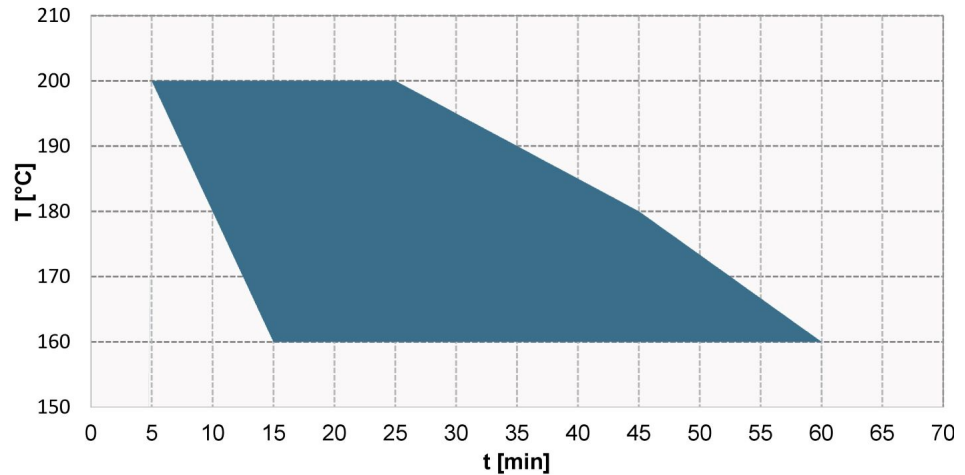
Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.
Recommended coating thickness	60-80 µm
Material usage	approx. 0,12 kg/m ² , layer thickness 80 µm theoretical
Processing	Tribo



PD6504A FREOPOX-Powder Coating

Curing

Recommended object temperature 15 min/160 °C.
Baking window tested in colour shade 9002.



Objekt Temperatur in °C Object Temperature in °C	160	180	200
Haltezeit Minimum in Minuten Holding time minimum in minutes	15	10	5
Haltezeit Maximum in Minuten Holding time maximum in minutes	60	45	25

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..



PD6504A FREOPOX-Powder Coating

Mechanical tests

Sample description	On steel plate 60-80 µm layer thickness 15 minutes 160°C object temperature product PD6504ARG902	
Cross-cut-test	Gt 0	DIN EN ISO 2409
Cupping test	>3 mm	DIN EN ISO 1520
Impact-test	>70 kg cm (front)	DIN EN ISO 6272-1

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.	
EFD info	Further technical information can be found in the EFD Info. No. 511	
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.	