FEYCOLOR®

Corrosion Protection

FEYCOLOR GmbH · Maxhüttenstraße 6 · D-93055 Regensburg
Tel. +49(0)941-60497-0 · Fax +49(0)941-60497-30 · info@feycolor.com

www.feycolor.com

INTRODUCTION

Corrosion preoccupies humankind since the usage of metals. Today the scope of corrosion protection ranges from the protection of a yard gate to famous examples of architecture like the Eiffel Tower or the Golden Gate Bridge.
These examples show that an appropriate anti-corrosion treatment extends substantially the lifetime of objects that are prone to corrosion.

Economic and ecological aspects are the driving factors in the selection of protective coatings. Our protective coatings contribute considerably to a long-lasting protection and reduction of damages amounting to billions.

For more than 50 years, corrosion protection has been one of the core businesses of FEYCOLOR. Thanks to our extensive experience and our modern research laboratories, we develope innovative and reliable products that are user-oriented for various application areas. From synthetic resin primers through solvent-free coating systems – we offer a perfect solution for your requirements.

Factory coating or maintenance and renovation of corrosion protection:
Our products comply with various national and international standards and factory standards. This is first and foremost the standard DIN EN ISO 12944 as well as the regulation ZTV-ING part 4 (Additional technical conditions of contract and guidelines for the civil engineering works, part 4: steel constructions).

This brochure serves as a guide to the successful execution of your corrosion protection project. In case of further question please don't hesitate to contact us. Our team will be happy to advise you individually.

Substrate Preparation

The accurate substrate preparation, the selection of the right coating system and the professional application of the coating are the most important factors affecting the total success of a corrosion protection system.

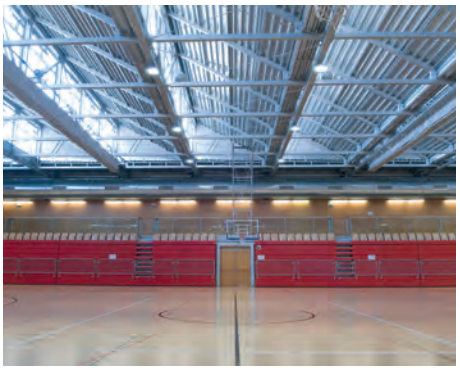
The most important information and details can be found in the European standard DIN EN ISO 12944 “corrosion protection of steel constructions by protective coating systems”.

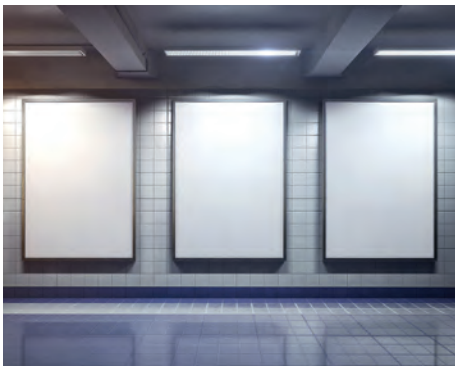
A thorough substrate pre-treatment is an important requirement for a long-term corrosion protection. Regardless of the contamination level, we always recommend to clean the steel surfaces thoroughly from i.e. mill scale, rust, old coatings and foreign matters. Any residual contamination must be adherent and may remain only as slight stains in the form of spots or stripes.

Depending on the intended use, suitable procedures are dry blasting, wet blasting, flame cleaning, high pressure water jetting, spot blasting, sweep blasting, acid pickling or alkaline cleaning. After the cleaning, the substrate must have the minimum surface preparation level of Sa 2,5 according to DIN EN ISO 12944-4 as well as an average maximum roughness depth of 40 - 80 µm.

Corrosivity categories	Exterior	Interior
C1 very low		Heated buildings with clean atmosphere, e. g. offices, shops, schools, hotels
C2 low	Atmospheres with low level of pollution, dry climate, rural areas	Unheated buildings where condensation may occur e. g. depots, sport halls
C3 medium	Urban and industrial atmospheres with moderate sulphur dioxide pollution and low salinity	Production rooms with high humidity, e. g. laundries, breweries
C4 stark	Industrial areas and coastal areas with moderate salinity	Swimming pools, boathouse, chemical plants
C5-I very high	Industrial areas with high humidity and aggressive atmosphere	Buildings or areas with almost permanent condensation and high pollution
C5-M very high	Coastal and offshore areas with high salinity	Buildings or areas with almost permanent condensation and high pollution

CORROSION PROTECTION C2





From the **corrosion protection classification C2** and onwards, commence the regulations which stipulate the protective period, the resin base and the dry film thickness.

The category C2 specifies the following corrosive environments:

Exterior:
✓ Dry climate
✓ Low pollution

Interior:
✓ Unheated buildings
✓ Temporary condensation
✓ Depots
✓ Sports halls
✓ Production halls

Coating system for corrosivity category C2

System number	Primer			Top coat			Complete coating		Aticipated durability		
	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Layer	NDFT µm	L	M	H
Table A2	Corrosion category C2 for low-alloy steel, surface preparation: blast cleaning to Sa 2,5, rust degree A, B or C (see ISO 8501-1)										
A2.01	1K KH Primer	1	40	1K KH Top coat	1	40	2	80			
A2.02	1K KH Primer	1 – 2	80	1K KH Top coat	1	40	2 – 3	120			
A2.03	1K KH Primer	1 – 2	80	1K KH Top coat	1 – 2	80	2 – 4	160			
A2.04	1K KH Direct To Metal	1 – 2	100				1 – 2	100			
A2.06	2K EP Primer	1 – 2	80	2K EP Top coat 2K PU Top coat 2K PU EG	1	40	2 – 3	120			
A2.07	2K EP Primer	1 – 2	80	2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	80	2 – 4	160			

NDFT = Nominal Dry Film Thickness
L = Low M = Medium H = High

CORROSION PROTECTION C3

C3 is the first category of high-quality corrosion protection. In this category two-component products are preferably used which meet the increasing requirements.

The category C3 specifies the following corrosive environments:

Exterior:

- ✓ Urban and industrial atmospheres with moderate sulphur dioxide pollution
- ✓ Coastal areas further from the sea with low salinity

Interior:

- ✓ Production rooms with high humidity and slight air pollution, e. g. facilities for food production, laundries, breweries, dairies
- ✓ Industrial buildings
- ✓ Residential building
- ✓ Roofs

Coating system for corrosivity category C3

System number	Primer			Top coat			Complete coating		Aticipated durability		
	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Layer	NDFT µm	L	M	H
Table A3	**Corrosion category C3 for low-alloy steel, Surface preparation: blast cleaning to Sa 2,5, rust degree A, B or C (see ISO 8501-1)**										
A3.01	1K KH Primer	1 – 2	80	1K KH Top coat	1	40	2 – 3	120			
A3.02	1K KH Primer	1 – 2	80	1K KH Top coat	1 – 2	80	2 – 4	160			
A3.03	1K KH Primer	1 – 2	80	1K KH Top coat	1 – 2	120	2 – 4	200			
A3.07	2K EP Primer	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1	40	2	120			
A3.08	2K EP Primer	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	80	2 – 3	160			
A3.09	2K EP Primer	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	120	2 – 3	200			
A3.11	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	100	2 – 3	160			
Table A7	**Corrosion category C3 for hot-dip galvanized steel**										
A7.09				2K EP Top coat 2K PU Top coat 2K PU EG	1	80	1	80			
A7.10	2K EP Primer	1	60	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	2	120			

NDFT = Nominal Dry Film Thickness
L = Low M = Medium H = High

CORROSION PROTECTION C4

The **corrosion protection classification C4** stands for excellent corrosion protection at the highest level. For these areas of application only three-coat systems or two-coat high-build systems are used.

The category C4 specifies the following corrosive environments:

Exterior:

- ✓ Industrial areas with permanent exposure as well as coastal areas with moderate salinity
- ✓ Industrial areas, industrial buildings and residential buildings in coastal areas with moderate salinity, chemical plants, bridges

Interior:

- ✓ Chemical plants
- ✓ Swimming pools

Coating system for corrosivity category C4

System number	Primer			Intermediate coat			Top coat			Complete coating		Aticipated durability		
	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Layer	NDFT µm	L	M	H
Table A4	**Corrosivity category C4 for low-alloy steel, Surface preparation: blast cleaning to Sa 2,5, rust degree A, B or C (see ISO 8501-1)**													
A4.01	1K KH Primer	1 – 2	80				1K KH Top coat	2 – 3	120	3 – 5	200			
A4.08	2K EP Primer	1 – 2	80	2K EP Primer 2K EP EG	1 – 2	100	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	2 – 3	240			
A4.09	2K EP Primer	1 – 2	80	2K EP Primer 2K EP EG	1 – 2	140	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	3 – 5	280			
A4.13	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60				2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	100	2 – 3	160			
A4.14	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Primer 2K EP EG	1	120	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	3	240			
A4.15	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Primer 2K EP EG	1 – 2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	3 – 4	280			
Table A7	**Corrosivity category C4 for hit-dip galvanized steel**													
A7.10	2K EP Primer	1	60				2K EP Top coat 2K PU Top coat 2K PU EG	1	60	2	120			
A7.11	2K EP Primer	1	80				2K EP Top coat 2K PU Top coat 2K PU EG	1	80	2	160			
A7.12	2K EP Primer	1	80	2K EP Primer 2K EP MIO	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	3	240			

NDFT = Nominal Dry Film Thickness L = Low M = Medium H = High

CORROSION PROTECTION C5-I

C5 is subdivided into **C5-I for industrial areas** and C5-M for marine areas. Both subcategories correspond to the highest corrosion protection in very aggressive environments. High film thickness and high-quality two-component coating systems have to be used.

The category C5-I specifies the following corrosive environments:

Exterior:

✓ Industrial areas with high humidity and aggressive atmosphere

Interior:

✓ Buildings and areas with almost permanent condensation and with high pollution.

Coating system for corrosivity category C5-I

System number	Primer			Intermediate coat			Top coat			Complete coating		Aticipated durability		
	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Layer	NDFT µm	L	M	H
Table A5-I	**Corrosivity category C5-I for low-alloy steel, surface preparation: blast cleaning to Sa 2,5, rust degree A, B or C (see ISO 8501-1)**													
A5I.02	2K EP Primer	1	80	2K EP Primer 2K EP EG	2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	2 – 4	320			
A5I.04	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Primer 2K EP EG	1 – 2	120	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	3 – 4	240			
A5I.05	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP EG	1 – 2	160	2K PU Top coat 2K PU EG	1 – 2	100	3 – 5	320			
Table A7	**Corrosivity category C5-I for hot-dip galvanized steel**													
A7.10	2K EP Primer	1	60				2K EP Top coat 2K PU Top coat 2K PU EG	1	60	2	120			
A7.11	2K EP Primer	1	80				2K EP Top coat 2K PU Top coat 2K PU EG	1	80	2	160			
A7.12	2K EP Primer	1	80	2K EP Primer 2K EP EG	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	3	240			
A7.13	2K EP Primer	1	80	2K EP Primer 2K EP EG	1 – 2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	3 – 4	320			

NDFT = Nominal Dry Film Thickness
L = Low M = Medium H = High

CORROSION PROTECTION C5-M

C5 is subdivided into C5-I for industrial areas and **C5-M for marine areas.** Both subcategories correspond to the highest corrosion protection in very aggressive environments. High film thickness and high-quality two-component coating systems have to be used.

The category C5-M specifies the following corrosive environments:

Exterior:

✓ Coastal and offshore areas with high salinity

Interior:

✓ Buildings and areas with almost permanent condensation and with high pollution.

Coating system for corrosivity category C5-M

System number	Primer			Intermediate coat			Top coat			Complete coating		Aticipated durability		
	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Product group	Layer	NDFT µm	Layer	NDFT µm	L	M	H
Table A5-M	**Corrosivity category C5-M for low-alloy steel, surface preparation: blast cleaning to Sa 2,5, rust degree A, B or C (see ISO 8501-1)**													
A5M.01	2K EP Primer	1	150				2K EP Top coat 2K PU Top coat 2K PU EG	1	150	2	300			
A5M.02	2K EP Primer	1	80	2K EP Primer 2K EP EG	2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	4	320			
A5M.05	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Primer 2K EP EG	2	120	2K EP Top coat 2K PU Top coat 2K PU EG	1	60	4	240			
A5M.06	2K EP Zinc rich primer 1K ESI Zinc rich primer	1	60	2K EP Primer 2K EP EG	2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1 – 2	100	4 – 5	320			
Table A7	**Corrosivity category C5-M for hot-dip galvanized steel**													
A7.10	2K EP Primer	1	60				2K EP Top coat 2K PU Top coat 2K PU EG	1	60	2	120			
A7.11	2K EP Primer	1	80				2K EP Top coat 2K PU Top coat 2K PU EG	1	80	2	160			
A7.12	2K EP Primer	1	80	2K EP Primer 2K EP EG	1	80	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	3	240			
A7.13	2K EP Primer	1	80	2K EP Primer 2K EP EG	1 – 2	160	2K EP Top coat 2K PU Top coat 2K PU EG	1	80	3 – 4	320			

NDFT = Nominal Dry Film Thickness
L = Low M = Medium H = High

ZTV-ING, TL/TP KOR, BLATT 87

Besides the DIN EN ISO 12944 and the ZTV-ING, another guideline from the Federal Highway Research Institute BASt exists: The TL/TP KOR-Steel Structures. This additional guideline defines the technical delivery terms and technical test specifications for the coating materials which are used for the corrosion protection of steel constructions.

The coatings systems for the initial coating of steel constructions listed in Blatt 87 are the basis for an initial coating or a complete renewal with a minimum of protection of 25 years according to TL/TP KOR.

FEYCOLOR offers the following certified coating systems according TL/TP KOR, Blatt 87

TL-Material Numbers	FEYCOLOR System	NDFT*
Steel Required Substrate Preparation: Blasting to Sa 2,5		
687.02 687.03	FEYCOPOX 507 2K EP-HS Primer, RAL 1002 or FEYCOZINK 515 2K EP ZR Primer, grey	70 µm
687.06 (Edge protection)	FEYCOPOX 507 2K EP-HS Primer, RAL 8012	(80 µm)
687.12/13/14	FEYCOPOX 533 2K EP MIO Coating DB Colors	80 µm
687.12/13/14	FEYCOPOX 533 2K EP MIO Coating DB Colors	80 µm
687.30 - 74 687.75 - 99	FEYCOPUR 623 2K PU MIO Coating, DB Colors or FEYCOPUR 626 2K PU DTM Coating, RAL Colors	80 µm
Total		**310 µm (390 µm)**
Galvanized Steel Required Substrate Preparation: Sweep Blasting		
687.12/13/14	FEYCOPOX 533 2K EP MIO Coating DB Colors	80 µm
687.12/13/14	FEYCOPOX 533 2K EP MIO Coating DB Colors	80 µm
687.30 - 74 687.75 - 99	FEYCOPUR 623 2K PU MIO Coating, DB Colors or FEYCOPUR 626 2K PU DTM Coating, RAL Colors	80 µm
Total		**240 µm**

*NDFT = Nominal Dry Film Thickness

TANK/CONTAINER CONSTRUCTION

Corrosion-protective coatings of tanks and containers meet additional requirements.

The external coatings have to stand up to the above-ground or underground influences and pressures, while simultaneously the internal coatings need to be resistant to the stress of the respective filling materials.

For theses special requirements offers FEYCOLOR with its coatings systems in accordance with DIN 12944 and by Blatt 87 of TL/TP KOR authorized products, a wide range of coatings systems.

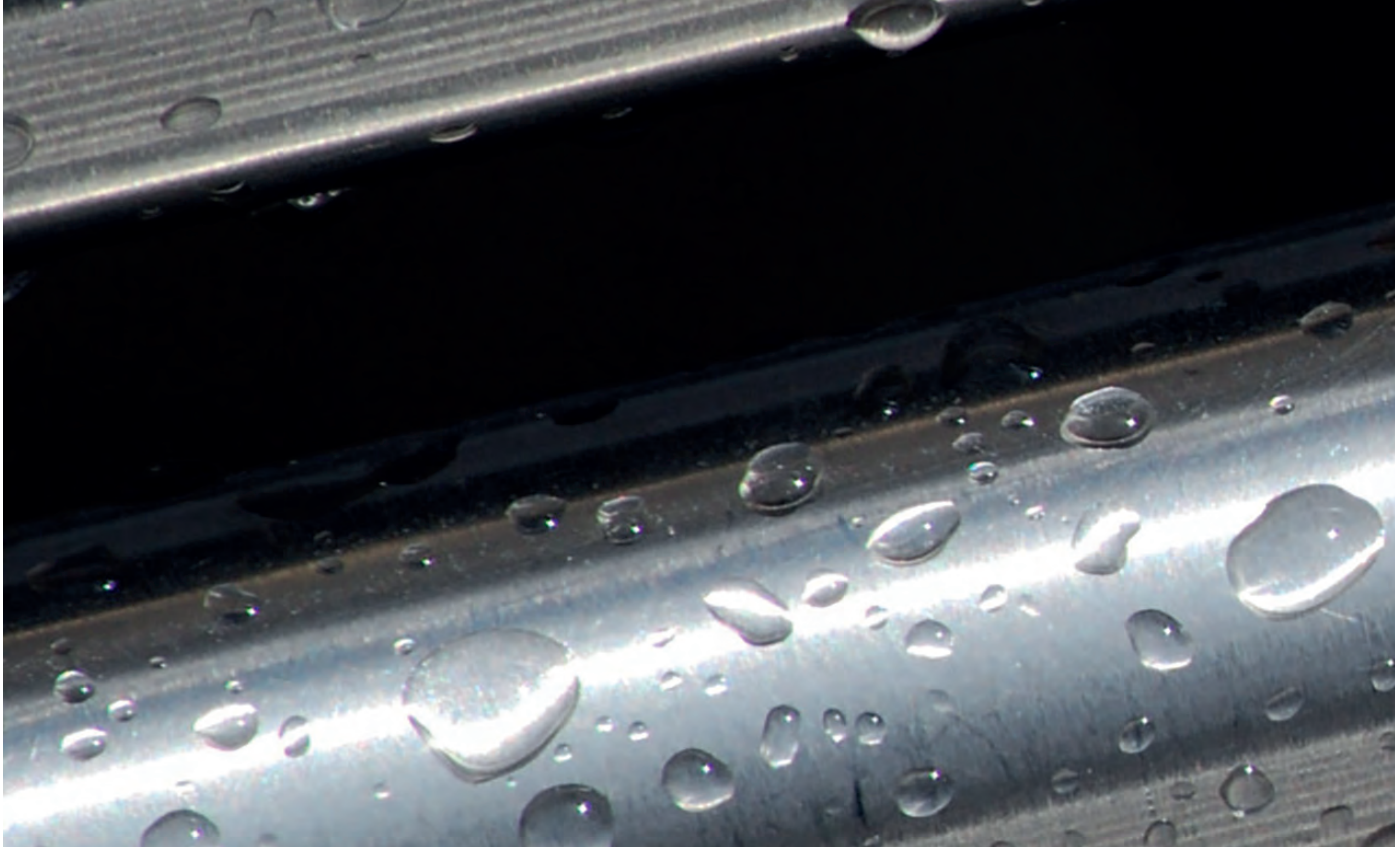
Additionally we offer special products for the following applications.

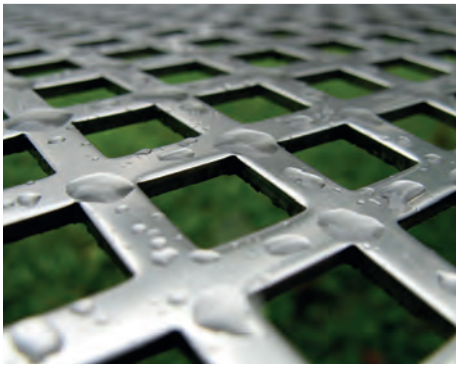
Products for Tank and Container Construction

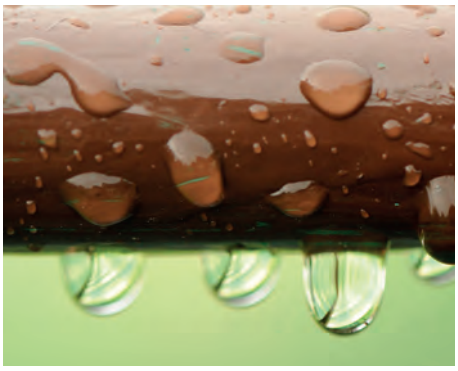
Product	Description	NDFT*
Internal Coating:		
Heating oil tanks – new construcion and renovation		
FEYCOPUR 437 2K PU Tank Coating	The emission-free and low-odor coating with excellent adhesion is easy to apply in high film thickness. The quick drying (6-12 h) provides a soon fillinig ot the tank.	300 µm
External Coating:		
Underground steel tanks (LPG, fuel oil or petrochemical products)		
ALPOTECT 568 2K EP Tank Coating	Pore-dense and impact-resistant external coating for underground tanks made of steel, certified by TÜV Süd according to DIN 4681-3.	1000 – 1500 µm
Above-ground tanks (LPG tanks and filling stations)		
FEYCOPUR 649 2K PU Tank Coating	For one-coat hot spraying application. High quality coating with high TSR effect, excellent corrosion protection, weather and UV resistance.	200 µm
Tank container, tank lorries		
FEYCOPOX 516 2K EP HB Primer	High build film primer with very good sanding properties and corrosion protection.	2 x 80 – 120 µm
FEYCOPUR 647 2K PU CV Coating	Highly cross-linked polyurethane coating with high gloss and excellent weather and UV resistance.	40 – 60 µm
Total		**200 – 300 µm**

*NDFT = Nominal Dry Film Thickness

TABLE OF DEW POINT







The dew point (in °C)

The dew point temperature is the temperature at which the air is saturated with water vapour. The lower the temperature the less water vapour can be absorbed by the air.
The water vapour condenses when the temperature decreases to the dew point temperature e. g. on cold substrates.

Air humidity	= amount of water vapour in the air
Absolute air humidity	= water in grams per cubic meter of air
Maximal air humidity	= highest amount of absolute air humidity without precipitation of water in liquid form
Relative air humidity	= depending on the variable ratio of absolute and maximal air humidity

Microscopically dispersed humidity due to e. g. dew, fog or condensing air humidity on substrates may affect the adhesion and performance of any paint coating applied.

The moisture content of the air has furthermore an impact on the drying process of paint and coating materials.

Dew point table

The dew point table shows at which substrate temperatures dependent on air temperature and relative air humidity condensate appears on the surface.

Example: At an air temperature of 22 °C and a relative air humidity of 65 %, condensate emerges on non-absorbent substrates that have a substrate temperature of less than 15 °C. Generally, the substrate temperature should be at least 3 °C above the dew point during the application process, in this case at 18 °C.

The detailed dew point table gives you an overview. See next page.

Selecting an appropriate paint system

After preparing the substrate the right coating system must be selected according to the requirement categories of DIN EN ISO 12944. The key to success lies firstly in recognising the corrosivity of the environment to which the surface will be exposed. To determine this criteria please see the tables “Corrosivity categories C2 to C5” on pages 4-13. Subsequently, the desired durability has to be specified.

The standard defines the following three durability ranges:

L(ow)	2 - 5 years
M(edium)	5 - 15 years
H(igh)	more than 15 years

Note:
The durability range is not a warranty period. Durability is a technical consideration that can help the owner set up a maintenance program.

Once the corrosivity category and the durability are specified, the question of an appropriate paint system must be considered. Commonly, a three-coat paint system consisting of primer, intermediate and top coat is selected.

The primer is of vital importance because it contains pigments that assure the cathodic protection. Furthermore, it is the base that provides adhesion to the substrate and acts as adhesion promoter for subsequent coats.
The following intermediate coating forms a barrier against penetrating corrosive substances. This effect is achieved by high dry film thicknesses and often supported by lamellar pigments. This layer, which varies depending on the requirements, evens also minor irregularities on the surface.
The top coat provides the final touch to the object. It offers another barrier against corrosive substances and gives the required appearance. The top coat also provides the first line of defence against sunlight and weather, aggressive atmosphere as well as chemical and/or mechanical stress.

In this brochure you will find different recommendations for coating systems according to tables A2 - A5 as well as A7 of DIN EN ISO 12944-5. In general, the following application recommendations are possibilities that have to be considered eventually in terms of individual requirements. Customer specific requirements such as special mechanical, chemical and weather resistance or other demands concerning e.g. gloss and tactile sensation may be better fulfilled by other products. Please contact us and we will offer you the coating solution for your specific requirements.

Application of paint coatings

In order to apply the coating correctly, please see product specifications in our technical data sheet. In case of any further question our application engineers will be happy to support you.

Coatings Material

Product group	Product	Product description	Density ca. kg/l	Solid Content % Vol.	Solid Content % Weight	MR by weight	NDFT	Theoretical Consumption ca. g/m²
1K ESI Zinc Rich	FEYCOZINK 291 1K ESI ZR Primer	1K Ethylsilikat Zinc Rich Primer grey, matt	3,0	65	90	–	50 – 100	240 – 480
1K AK Primer	FEYALKYD 302 ZN-Phosphate Primer	1K AK Primer for steel, matt	1,5	52	72	–	40 – 100	120 – 300
1K AK Top Coat	FEYCOFIX 340 AK Top Coat	1K AK Top Coat, glossy	1,3	49	66	–	60 – 80	130 – 210
	FEYCOFIX 346 AK Top Coat	1K AK Top Coat, satin gloss	1,4	50	70	–	60 – 80	140 – 230
1K AK DTM	FEYCOFIX 349 DTM Coat HB	1K AK DTM Coating for high build application on steel, satin gloss	1,3	52	69	–	60 – 100	160 – 260
2K EP Primer	FEYCOPOX 505 2K EP Primer	2K EP Primer with Zinc Phosphate, matt	1,5	48	68	5 : 1	60 – 100	170 – 280
	FEYCOPOX 507 2K EP HS Primer	2K EP HS Primer with Zinc Phosphate, matt	1,5	69	80	9 : 1	60 – 100	150 – 250
	ALPOMASTIC 519 2K EP HS Primer	2K EP HS Primer silver for hand derusted surfaces, satin gloss	1,4	90	94	1 : 1	60 – 100	100 – 160
2K EP Zinc Rich	FEYCOZINK 514 2K EP ZR Primer	2K EP Zinc Rich Primer with high coverage, matt	2,2	67	85	10 : 1	40 – 80	135 – 270
	FEYCOZINK 515 2K EP ZR Primer	2K EP Zinc Rich Primer grey/reddish grey, matt	2,7	51	83	12 : 1	40 – 80	225 – 450
2K EP MIO	FEYCOPOX 533 2K EP MIO Coating	2K EP Micaceous Iron Oxide Intermediate and Top Coat, matt	1,6	57	74	5 : 1	60 – 120	180 – 360
2K EP Top Coat	FEYCOPOX 535 2K EP HB Coating	2K EP High Build Coating, satin gloss	1,4	59	74	5 : 1	60 – 120	150 – 300
2K PU MIO	FEYCOPUR 623 2K PU MIO Coating	2K PU Micaceous Iron Oxide Top Coat, matt	1,6	63	78	10 : 1	60 – 100	165 – 275
2K PU Top Coat	FEYCOPUR 626 2K PU DTM Coating	2K PU Top Coat glossy, satin gloss, semi matt	1,3	55	69	10 : 1	60 – 100	140 – 240
	FEYCOMASTIC 650 2K PU	2K PU HS Top Coat, glossy	1,4	66	78	8 : 1	80 – 120	170 – 260
	FEYCOPUR 652 2K PU HS DTM	2K PU HS Top Coat, satin gloss	1,4	67	79	10 : 1	80 – 120	170 – 260

Products certified according to Blatt 87, TL/TP KOR Steel Structures

Air temperature in °C	Dew point temperature (rounded) in °C at a relative air humidity of														
	30 %	**35 %**	**40 %**	**45 %**	**50 %**	**55 %**	**60 %**	**65 %**	**70 %**	**75 %**	**80 %**	**85 %**	**90 %**	**95 %**	**100 %**
50	28	30	33	35	37	39	40	42	43	44	46	47	48	49	50
45	23	26	28	30	32	34	35	37	38	40	41	42	43	44	45
40	19	22	24	26	28	29	31	32	34	35	36	37	38	39	40
35	15	17	19	21	23	25	26	27	29	30	31	32	33	34	35
30	11	13	15	17	18	20	21	23	24	25	26	27	28	29	30
29	10	12	14	16	18	19	20	22	23	24	25	26	27	28	29
28	9	11	13	15	17	18	20	21	22	23	24	25	26	27	28
27	8	10	12	14	16	17	19	20	21	22	23	24	25	26	27
26	7	9	11	13	15	16	18	19	20	21	22	23	24	25	26
25	6	9	11	12	14	15	17	18	19	20	21	22	23	24	25
24	5	8	10	11	13	14	16	17	18	19	20	21	22	23	24
23	5	7	9	10	12	14	15	16	17	18	19	20	21	22	23
22	4	6	8	10	11	13	14	15	16	17	18	19	20	21	22
21	3	5	7	9	10	12	13	14	15	16	17	18	19	20	21
20	2	4	6	8	9	11	12	13	14	15	16	17	18	19	20
19	1	3	5	7	8	10	11	12	13	15	16	16	17	18	19
18	0	2	4	6	7	9	10	11	13	14	15	15	16	17	18
17	-1	1	3	5	7	8	9	10	12	13	14	15	15	16	17
16	-1	1	2	4	6	7	8	9	11	12	13	14	14	15	16
15	-2	0	2	3	5	6	7	9	10	11	12	13	13	14	15
14	-3	-1	1	2	4	5	6	8	9	10	11	12	12	13	14
13	-4	-2	0	1	3	4	6	7	8	9	10	11	11	12	13
12	-5	-3	0	0	2	3	5	6	7	8	9	10	10	11	12
11	-5	-3	-2	0	1	2	4	5	6	7	8	9	9	10	11
10	-6	-4	-3	-1	0	1	3	4	5	6	7	8	8	9	10
8	-8	-7	-5	-3	-2	0	1	2	3	4	5	6	6	7	8
6	-10	-8	-7	-5	-3	-2	-1	0	1	2	3	4	4	5	6
4	-12	-10	-8	-7	-5	-4	-3	-2	-1	0	1	2	2	3	4
2	-14	-12	-10	-9	-7	-5	-4	-3	-3	-2	-1	0	1	1	2
0	-15	-14	-12	-10	-8	-7	-6	-5	-4	-3	-2	-2	-1	0	0

typical temperatures during processing

FEYCOLOR GmbH · Maxhüttenstraße 6 · D-93055 Regensburg
Tel. +49(0)941-60497-0 · Fax +49(0)941-60497-30 · info@feycolor.com

www.feycolor.com

02-2016