IGP POWDER COATINGS

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app.print.technical_data_sheet.title

IGP-DURA®*pol* 681TA-G0 care

Matt low-temperature powder coating with fine structure, ideal for indoor and outdoor applications. Finished with biocides.

app.print.technical_data_sheet.characteristics.title

- Deep matte
- Fine texture
- Uni colours
- Industrial outdoor quality
- Contains biocides

app.print.technical_data_sheet.application.title

- Protected by Sanitized®

app.print.technical_data_sheet.powder_properties.title

app.print.technical_data_sheet.powder_properties.particle_size:
< 100 µm
app.print.technical_data_sheet.powder_properties.solid:
≈ 99 %
app.print.technical_data_sheet.powder_properties.density:
1.3 kg/l - 1.6 kg/l
app.print.technical_data_sheet.powder_properties.storage_suitability:
app.print.technical_data_sheet.powder_properties.storage_suitability.prefix
24 months
app.print.technical_data_sheet.powder_properties.storage_suitability.at
25 °C
in an unopened original container
app.print.technical_data_sheet.powder_properties.color_tones:
On request

app.print.technical_data_sheet.processing.title

app.print.technical_data_sheet.processing.substrates
The substrate must be free from oil, grease and oxidation products. The pretreatment depends on the type of substrate and the corrosion protection to be achieved. We recommend the following pretreatments:

Aluminium
- Chromating according to DIN EN 12487
- Pre-anodization
- Chrome-free pretreatment according to GSB International and QUALICOAT specifications

Steel
- Zinc phosphating

Galvanised steel
- Zinc phosphating
- Chrome (III) passivation
- Chromating according to DIN EN 12487

For improved corrosion protection for applications on steel / galvanised steel, the use of corrosion protection primer IGP-KORROPRIMER 18 is recommended.

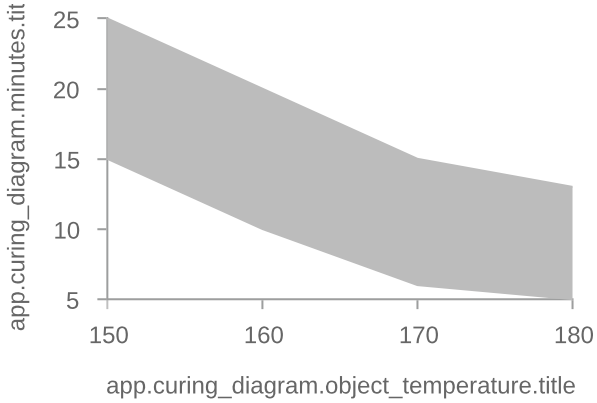
The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. The minimum requirement for aluminium substrates / galvanised steel components is to carry out a boiling water test with a subsequent cross-cut adhesion and tape test. We refer to the guidelines of the GSB International, Qualicoat and Qualisteelcoat certifications. For further information: see also our special leaflet on pre-treatment (IGP-TI 100).

app.print.technical_data_sheet.processing.coating_devices
All commercially available electrostatic systems, both corona and tribo charge systems.
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

app.print.technical_data_sheet.processing.recommended_film_thickness
60 µm - 80 µm

A homogeneous coating result with textured coatings or article-and color specific differences in hiding power may require higher coating thicknesses. The corresponding processing guidelines must be observed.
For a pre-calculation of the required powder coating quantity, the necessary coating thickness must be determined for each article.

app.print.technical_data_sheet.processing.curing_condition_recommendation



app.print.technical_data_sheet.processing.curing_conditi
150 °C
160 °C
170 °C
180 °C

In order to determine ideal curing conditions, we recommend practical trials with the respective object and curing oven.

app.print.technical_data_sheet.processing.reclaimability
Small portions of recycled powder can be added, automatically if possible, to the fresh powder. Important: Keep overspray to an absolute minimum. Processing instruction VR214 must be observed.

app.print.technical_data_sheet.film_properties.title

app.print.technical_data_sheet.film_properties.tested_on.title

app.print.technical_data_sheet.film_properties.tested_on: Aluminium (AlMg1), 0.8 mm, chromated
app.print.technical_data_sheet.film_properties.film_thickness: 60 µm - 80 µm
app.print.technical_data_sheet.film_properties.object_temperature: 160 °C, 10 min

app.print.technical_data_sheet.film_properties.mechanical_tests

Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Mandrel bending test	≤ 5 mm	DIN EN ISO 1519 2011
Impact test	≥ 10 inchp.	ASTM D 2794 1993
Erichsen cupping	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10

app.print.technical_data_sheet.film_properties.corrosion_tests

Condensation water test, 1000h	No infiltration, no blisters	DIN EN ISO 6270-2 2018-04
Natural salt spray test, 1000h	No infiltration, no blisters	DIN EN ISO 9227 2017-07

app.print.technical_data_sheet.film_properties.chemical_tests

Acids and alkalis	Good resistance to many dilute acids and alkalis. Contact to sulfur containing compounds could lead to deactivation of the silver based additive. The usage in industrial atmosphere should be therefore avoided.

app.print.technical_data_sheet.more_information.title

app.print.technical_data_sheet.packaging.title
20 kg cardboard box with inserted antistatic PE liner
500 kg cardboard container with 25 antistatic PE-liners each 20kg

app.print.technical_data_sheet.more_information.protection_of_coated_parts
Coated parts should be packed after cooling with suitable materials without plasticizers. They should be stored protected from the weather to avoid the formation of condensation and thus water spots on the coating.

app.print.technical_data_sheet.more_information.cleaning
The coated parts must be cleaned according to the directives RAL-GZ 632 or SZFF 61.01.

app.print.technical_data_sheet.more_information.paint_removal_and_disposal
After use, coated goods should be supplied to the normal recycling process. The disposal methods for sludges or residual powders must be observed in accordance with the local official provisions whilst taking Waste Code “080201 Coating Powder Wastes” in accordance with the European Waste Catalogue into consideration.

app.print.technical_data_sheet.infobox