

Scheda tecnica

## IGP-KORROPRIMER 1808A-A0

Low-temperature primer for high-quality corrosion protection, especially for solid steel parts and aluminum, curable at 140°C.



### Proprietà

- lucido
- superficie liscia
- Tinte unite
- Indoor quality
- Bassa temperatura



### Proprietà delle polveri

Granulometria:	< 100 µm
Corpi solidi:	> 99 %
Densità:	1.6 kg/l-1.7 kg/l
Stoccaggio:	min. 9 months a ≤ 25 °C in an unopened original container
Color tones:	ca. RAL 7035



### Applicazione

#### Pretrattamento

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:

#### Alluminio

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

#### Acciaio

- Blasting: Electro corundum or conditioned cut wire shot should be used. After blasting, the norm purity degree must be at least SA 2 ½ (white metallic polish) in accordance with DIN EN ISO 12944-4. Further details can be found in this norm. Sharp edges, overlaps, etc., should be avoided (see DIN EN ISO 12944-3).

Acciaio zincato

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

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).

### Impianti di verniciatura

All commercially available electrostatic systems, both corona and tribo charge systems.

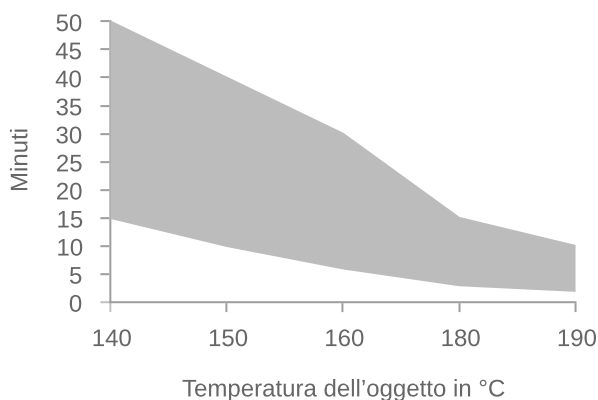
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

### Spessore del film consigliato

60 µm - 100 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.

### Condizioni di cottura



<b>T<sub>oggetto</sub></b>	<b>t<sub>min</sub></b>	<b>t<sub>max</sub></b>
140 °C	15 minutes	50 minutes
<b>150 °C</b>	<b>10 minutes</b>	<b>40 minutes</b>
160 °C	6 minutes	30 minutes
180 °C	3 minutes	15 minutes
190 °C	2 minutes	10 minutes

When curing thick steel components we recommend to gel the primer and fully cure the part with the top coat.

To avoid intercoat adhesion problems the maximum air temperature should be limited to 200°C. The maximum object temperature should be limited to 190°C.

When curing in directly heated gas ovens, a sample should be done in advance to ensure the intercoat adhesion with the following top coat.

Please contact our technical customer support.

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

### Application

Please follow the application guideline VR211.

## Recupero

Small portions of recycled powder can be added, automatically if possible, to the fresh powder. Important: Keep overspray to an absolute minimum.



## Caratteristiche del film

### Testato per

Substrati:	Steel, 0.5mm
Spessore:	60 µm - 80 µm
Temperatura dell'oggetto:	150 °C, 10 min.

### Prove meccaniche

Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Impact test	≥ 20 inchp.	ASTM D 2794 1993
Erichsen cupping	≥ 3 mm	DIN EN ISO 1520 2007-11



## Altre informazioni

### Imballaggio

20 kg cardboard box with inserted antistatic PE liner

### Rimozione e smaltimento della pittura

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.

Le presenti informazioni di natura tecnica relative all'utilizzo sono fornite sulla base delle conoscenze attuali. Tuttavia devono essere considerate come indicazioni non vincolanti che non esonerano dall'effettuazione di controlli autonomi. Utilizzo, destinazione e applicazione di prodotti hanno luogo senza possibilità di controllo da parte nostra e, pertanto, soggiacciono esclusivamente alla vostra responsabilità.

Prima dell'applicazione consultare la scheda di sicurezza. Scheda di sicurezza specifica per l'articolo e misure più approfondite sulla gestione del rischio alla pagina: [igp-powder.com](http://igp-powder.com)