IGP POWDER COATINGS

4T

Technical data sheet

IGP-DURA®*match* 4T07A-Z0

Silk gloss, smooth powder coating with very good resistance to cleaning agents, ideal for objects in public spaces.

Characteristics

- Silk gloss
- Smooth finish
- Uni, without effect
- Standard facade quality,
  1 year Florida > 50% residual gloss
- Clean Effect

Material approvals

- GSB 109 c - Florida 1

GSB INTERNATIONAL

Powder properties

Particle size:	< 100 µm
Solids:	> 99 %
Density:	1.3 kg/l-1.6 kg/l
Suitability for storage:	min. 18 months at ≤ 25 °C in an unopened original container
Color tones:	RAL and NCS-S shades, individual colors on request

Processing

Pre-treatment

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 10 or IGP-KORROPRIMER 60 is recommended.

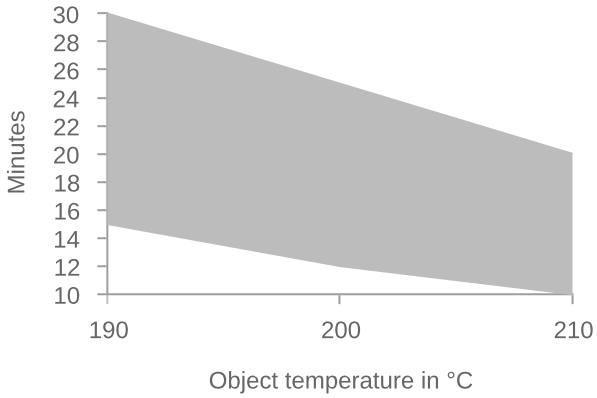
The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. The minimum requirement for aluminium substrates / galvanised steel components is to carry out a boiling water test with a subsequent cross-cut adhesion and tape test. We 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).

Coating devices
All conventional electrostatic systems with corona charging.
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.

Recommended film thickness
60 µm - 80 µm

To achieve a uniform finish with textured coatings, or where there are colour- or product-specific differences in hiding power, higher film thicknesses may be required. The relevant processing guidelines must be followed. To estimate the quantity of powder coating required in advance, the necessary Film thickness must be determined on a product-by-product basis.

Curing conditions



T_{Object}	t_{min}	t_{max}
190 °C	15 minutes	30 minutes
200 °C	**12 minutes**	**25 minutes**
210 °C	10 minutes	20 minutes

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

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

Film properties

Tested on

Substrate:	Aluminum (AlMg1), 0.8 mm chrom-free
Film thickness:	60 µm - 80 µm
Object temperature:	200 °C, 12 min.

Appearance		
Gloss level	65-85 R'/60°	DIN EN ISO 2813 2015-02

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	≥ 20 inchp.	ASTM D 2794 1993
Erichsen cupping	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10 (Anhang A)

Weathering tests		
1 year Florida, 5° south	> 50 % residual gloss	DIN EN ISO 2810 2021-01
QUV/SE-B-313, 300h	> 50 % residual gloss	DIN EN ISO 16474-3 2014-03

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

Chemical tests		
Mortar resistance	Easily removable after 24h with no residues.	ASTM D 3260 2001

Further information

Packaging
20 kg cardboard box with inserted antistatic PE liner

Overcoating suitability
Preliminary tests are mandatory for overcoating painted surfaces.

Printing and glueing
Preliminary tests are mandatory for printing and glueing of painted surfaces.

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.

Cleaning
The coated parts must be cleaned according to the directives RAL-GZ 632 or SZFF 61.01.

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.

This application-related advice is given to the best of our knowledge. However, this information is non-obligatory and does not exempt you from carrying out your own tests. Application, use and processing of these products are beyond our control and are therefore on your responsibility.

Consult the Safety Data Sheet prior to use. Article-specific safety data sheet and comprehensive risk management measures available at: **igp-powder.com**