



Technical data sheet

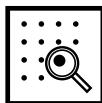
## IGP-DURA®match 7T09A-A0

Superdurable, low-temperature powder coatings, curable at 140 °C or above, for heavy steel parts and constructions.



### Characteristics

- Gloss
- Smooth finish
- Uni, without effect
- High weather resistant industrial quality



### Powder properties

Particle size:	< 100 µm
Solids:	> 99 %
Density:	1.3 kg/l-1.6 kg/l
Suitability for storage:	min. 24 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:

Steel

- Zinc phosphating and cathodic dip coating

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 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.

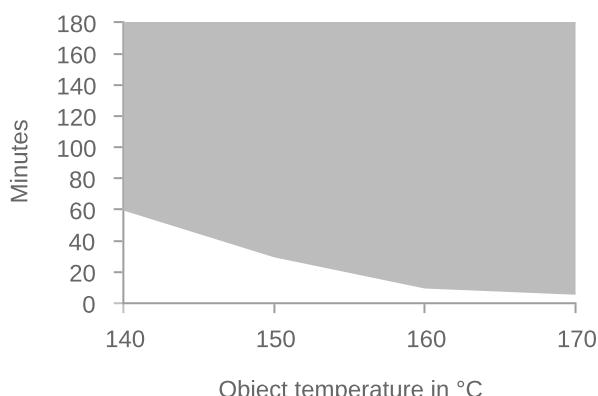
## Recommended film thickness

60 µm - 100 µm

A homogeneous coating result with textured paints or colour or article-specific differences in hiding power may require higher Film thicknesses. The corresponding processing guidelines must be observed.

For a preliminary calculation of the required powder coating quantity, the required Film thickness must be determined for each specific article.

## Curing conditions



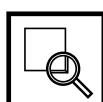
T Object	t min	t max
140 °C	60 minutes	180 minutes
150 °C	30 minutes	180 minutes
<b>160 °C</b>	<b>10 minutes</b>	<b>180 minutes</b>
170 °C	6 minutes	180 minutes

The oven temperature should be limited to 200°C

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: Steel, 0.5mm  
Film thickness: 80 µm - 100 µm  
Object temperature: 160 °C, 10 min.

### Appearance

Gloss level 85-100 R'/60° DIN EN ISO 2813 2015-02

### Mechanical tests

Cross-cut adhesion test Gt 0 DIN EN ISO 2409 2020-12  
Erichsen cupping / Tape test ≥ 2 mm DIN EN ISO 1520 2007-11

### Weathering tests

QUV-SE-B-313, 600h > 50 % residual gloss DIN EN ISO 16474-3 2014-03  
Xenon-arc lamps, 1500h > 70 % residual gloss DIN EN ISO 16474-2 2014-03

## Corrosion tests

---

Condensation water test, 500-1000h*	No infiltration, no blisters. *depending on pretreatment	DIN EN ISO 6270-2 2018-04
Natural salt spray test, 500-1000h*	No infiltration, no blisters. *depending on pretreatment.	DIN EN ISO 9227 2017-07

## Chemical tests

---

Operating materials	Good resistance to chemicals, especially cleaning agents, operating fluids and fuels.
Acids and alkalis	Good resistance to many dilute acids and alkalis.



## Further information

### Packaging

20 kg cardboard box with inserted antistatic PE liner  
500 kg cardboard container with 25 antistatic PE-liners each 20kg  
500 kg Big Bag

### 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**