



Scheda tecnica

## IGP-DURA®*pol* 644MA-A1

Polyester-based matt powder coating with extremely fine haptics, for interior and exterior applications.



### Proprietà

- opaco
- raggrinzato var.
- Tinte unite
- Industrial outdoor quality



### Proprietà delle polveri

|                |   |
|----------------|---|
| Granulometria: | < 100 µm  |
| Corpi solidi:  | > 99 %  |
| Densità:       | 1.3 kg/l-1.6 kg/l   |
| Stoccaggio:    | min. 24 months a ≤ 25 °C<br>in an unopened original container |
| Color tones:   | RAL and NCS-S shades, individual colors on request            |



### 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

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

#### Acciaio

- Zinc phosphating

#### Acciaio zincato

- 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).

### Impianti di verniciatura

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.

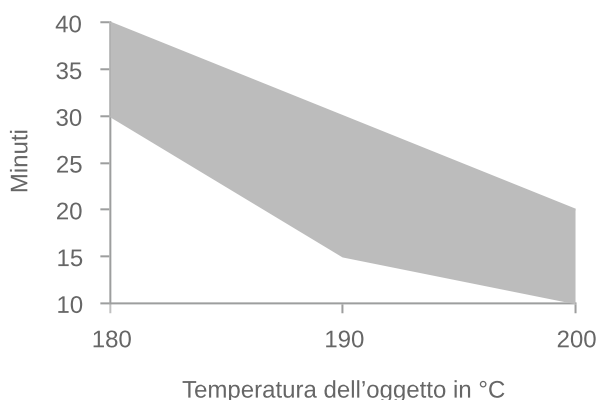
### Spessore del film consigliato

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.

### Condizioni di cottura



| <b>T<sub>oggetto</sub></b> | <b>t<sub>min</sub></b> | <b>t<sub>max</sub></b> |
|----------------------------|------------------------|------------------------|
| 180 °C                     | 30 minutes             | 40 minutes             |
| 190 °C                     | 15 minutes             | 30 minutes             |
| <b>200 °C</b>              | <b>10 minutes</b>      | <b>20 minutes</b>      |

Per accertare le condizioni di cottura migliori si consiglia, in ogni caso, di effettuare prove pratiche con il rispettivo oggetto e forno di polimerizzazione.

### Recupero

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.



## Caratteristiche del film

### Testato per

Substrati: Aluminum (AlMg1), 0.8mm, chromated  
Spessore: 60 µm - 80 µm  
Temperatura dell'oggetto: 200 °C, 10 min.

### Prove meccaniche

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 |

#### Test di resistenza agli agenti atmosferici

|                    |                             |                            |
|--------------------|-----------------------------|----------------------------|
| QUV-SE-B-313, 200h | > 50 % Brillantezza residua | DIN EN ISO 16474-3 2014-03 |
|--------------------|-----------------------------|----------------------------|

#### Verifiche della resistenza a corrosione

|                                |                              |                           |
|--------------------------------|------------------------------|---------------------------|
| 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   |



## Altre informazioni

### Imballaggio

20 kg cardboard box with inserted antistatic PE liner

500 kg cardboard container with 25 antistatic PE-liners each 20kg

### Pulizia

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

### 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)