



Technical data sheet

## IGP-DURA®pol 644MA-A1

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



### Characteristics

- Matte
- Var. fine texture
- Uni, without effect
- Industrial outdoor 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:

#### 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.

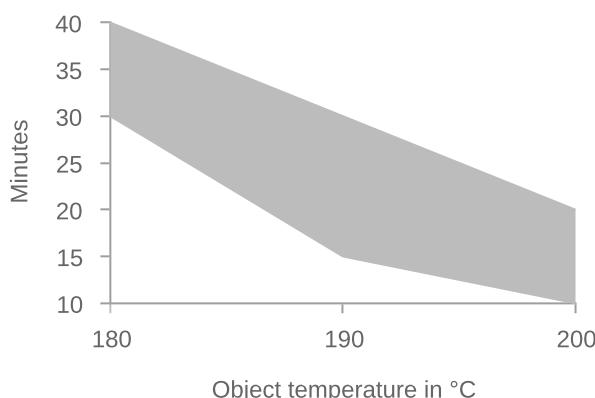
### **Recommended film thickness**

60 µm - 80 µm

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
180 °C	30 minutes	40 minutes
190 °C	15 minutes	30 minutes
<b>200 °C</b>	<b>10 minutes</b>	<b>20 minutes</b>

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. Processing instruction VR214 must be observed.



## **Film properties**

### **Tested on**

Substrate: Aluminum (AlMg1), 0.8mm, chromated  
Film thickness: 60 µm - 80 µm  
Object temperature: 200 °C, 10 min.

### **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 (Anhang A)

#### Weathering tests

QUV-SE-B-313, 200h	> 50 % residual gloss	DIN EN ISO 16474-3 2014-03
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#### 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



## Further information

#### Packaging

20 kg cardboard box with inserted antistatic PE liner

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

#### 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](http://igp-powder.com)