



Technical data sheet

## IGP-DURA®*sky* 9503E-A3

Matte effect powder coating in ultra-high weather-resistant quality with very good anti-graffiti properties.



### Characteristics

- Matte
- Smooth flow
- Pearl mica
- Premium
- Ultra super durable facade quality, 10 years Florida
- Chemical resistant
- Clean Effect
- Abrasion resistant
- Antigraffiti
- for use in indirect-fired gas oven



### Material approvals

- Qualicoat Nr. P-1967, LIGHT, class 3
- Qualicoat Nr. P-1968, MEDIUM, class 3
- Qualicoat Nr. P-1969, DARK, class 3
- AAMA 2605-20, independent test report



### Powder properties

Particle size:	< 100 µm
Solids:	> 99 %
Density:	1.2 kg/l-1.6 kg/l
Suitability for storage:	min. 18 months at ≤ 25 °C in an unopened original container
Color tones:	RAL Metallic and individual metallic 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 white and light IGP-DURA<sup>®</sup>sky qualities, the use of IGP-KORROPRIMER 6007A90164A01 is recommended as a primer.

For improved corrosion protection for applications on steel / galvanised steel, the use of corrosion protection primer 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.

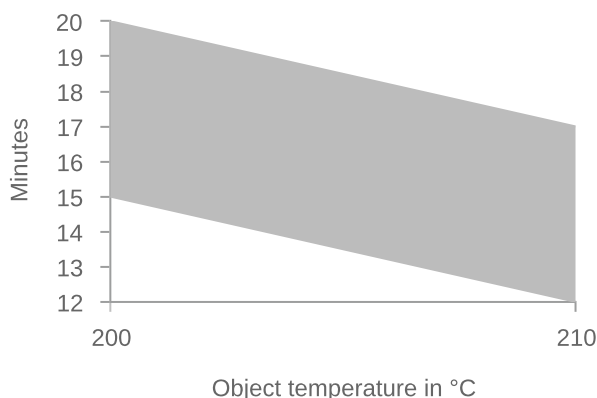
## Recommended film thickness

50 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.

## Curing conditions



T <sub>Object</sub>	t <sub>min</sub>	t <sub>max</sub>
200 °C	15 minutes	20 minutes
210 °C	12 minutes	17 minutes

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

Due to e-caprolactam emissions during the curing process it is necessary to take care for a good ventilation to comply with the permitted occupational exposure limits concentrations.

## Application

VR206 Processing guideline for IGP-DURA<sup>®</sup>sky 9503.

## Reclaimability

Small portions of recovered powder can be added, automatically if possible, to the fresh powder. Important: Keep overspray to an absolute minimum. Processing instruction VR201.1 must be observed.



## Film properties

### Tested on

Substrate:	Aluminum (AlMg1), 0.8 mm chrom-free
Film thickness:	60 µm - 80 µm
Object temperature:	200 °C, 15 min.

### Appearance

Gloss level	25-35 R'/60°	DIN EN ISO 2813 2015-02
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### Mechanical tests

Film Adhesion	passed	AAMA 2605-20; 8.4 2020
Impact test	3 mm	AAMA 2605-20; 8.5 2020
Abrasion Resistance	> 40 mil	AAMA 2605-20; 8.6 2020
Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10
Mandrel bending test / Tapetest	≤ 5 mm	DIN EN ISO 1519 2011
Erichsen cupping / Tape Test	≥ 5 mm	DIN EN ISO 1520 2007-11

### Weathering

10 years Florida, 45° south	> 50 % residual gloss	AAMA 2605-20; 8.9 2020
Xenon-arc lamps, 10000h	> 50 % residual gloss	DIN EN ISO 16474-2 2014-03
QUV-SE-B-313, 5000h	> 50 % residual gloss	DIN EN ISO 16474-3 2014-03

### Corrosion tests

Cyclic Corrosion Testing, 2000h	ASTM G85, creeping < 2mm,	AAMA 2605-20; 8.8.2 2020
Condensation water test, 4000h	Blister Size „Few“	AAMA 2605-20; 8.8.1 2020
	ASTM D2247, Blister Size No. 8	
	Figure No.4	

### Chemical tests

Mortar resistance	Can be easily removed after 24 hours without leaving any residue. No visible changes in gloss or color tone.	ASTM C 207-18 2018
Chemical resistance	Generally good resistance to acids, alkalis and oil.	AAMA 2605-20 8.7.1-8.7.5 2020



## Further information

### Packaging

20 kg cardboard box with inserted antistatic PE liner

### Overcoating

Preliminary tests are mandatory for overcoating painted surfaces.

### Printing and glueing

Preliminary tests are mandatory.

### 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. Technical Information IGP-TI 106 must also be observed when dealing with pearl mica effects.

### Graffiti removal

The following procedure should be observed when removing graffiti:

- The contact time of the graffiti with the surface must be kept as brief as possible
- Preliminary tests to select a suitable graffiti remover
- Thorough rinsing of the cleaned areas with water
- The contact time of the graffiti remover with the surface must be kept as brief as possible

IGP recommendation:

- Elite 007 graffiti remover from Crous Chemicals GmbH
- Socostrip T4210P from Socomore
- Bonderite S-ST 1302 and Bonderite C-MC 400 from Henkel AG
- or a different non-abrasive cleaner

### 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)