

Scheda tecnica

IGP-DURA®sky 9503E-A3

Matte effect powder coating with outstanding weather resistance and excellent anti-graffiti properties.



Proprietà

- Opaco
- Superficie liscia
- Perlato
- Premium
- Ultra super durable facade quality, 10 years Florida
- Chemical resistant
- Effetto clean
- Resistente all'abrasione
- Anti-Graffiti
- for use in indirect-fired gas oven



Omologazioni

- 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



Proprietà delle polveri

Granulometria:	< 100 µm
Corpi solidi:	> 99 %
Densità:	1.2 kg/l-1.6 kg/l
Stoccaggio:	min. 18 months a ≤ 25 °C in an unopened original container
Color tones:	RAL Metallic and individual metallic 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 white and light IGP-DURA®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).

Impianti di verniciatura

All conventional electrostatic systems with corona charging.

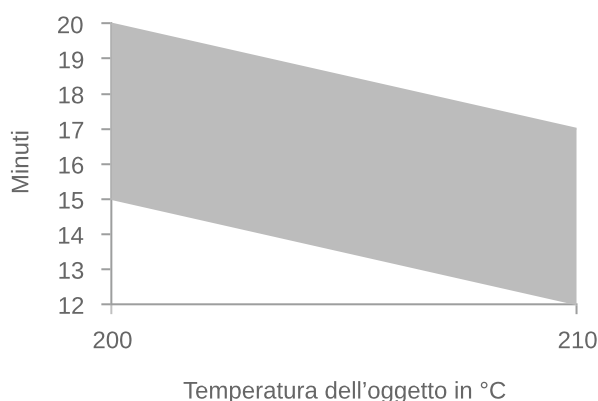
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

Spessore del film consigliato

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.

Condizioni di cottura



T _{oggetto}	t _{min}	t _{max}
200 °C	15 minutes	20 minutes
210 °C	12 minutes	17 minutes

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

Application

VR206 Processing guideline for IGP-DURA®sky 9503.

Recupero

Small portions of recovered powder can be added, automatically if possible, to the fresh powder. Important: Keep overspray to an absolute minimum. Processing instruction VR206 must be observed.



Caratteristiche del film

Testato per

Substrati:	Aluminum (AlMg1), 0.8 mm chrom-free
Spessore:	60 µm - 80 µm
Temperatura dell'oggetto:	200 °C, 15 min.

Struttura superficiale

Brillantezza	25-35 R'/60°	DIN EN ISO 2813 2015-02
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Prove meccaniche

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
taglio incrociato	Gt 0	DIN EN ISO 2409 2020-12
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10 (Anhang A)
Mandrel bending test / Tape test	≤ 5 mm	DIN EN ISO 1519 2011
Erichsen cupping / Tape test	≥ 5 mm	DIN EN ISO 1520 2007-11

Test di resistenza agli agenti atmosferici

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

Verifiche della resistenza a corrosione

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

Prove chimiche

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



Altre informazioni

Imballaggio

20 kg cardboard box with inserted antistatic PE liner

Sovraverniciabilità

Preliminary tests are mandatory for overcoating painted surfaces.

Stampaggio e incollaggio

Preliminary tests are mandatory.

Protezione delle superfici verniciate

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.

Pulizia

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.

Rimozione di graffiti

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

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**