



Technical data sheet

IGP-DURA[®] *than* 8109B-A2

High gloss polyurethane powder coating with an especially elegant, smooth finish for interior and exterior applications.



Characteristics

- Gloss
- Smooth finish
- Transparent
- Industrial outdoor quality



Powder properties

Particle size:	< 3.94 mil
Solids:	> 99 %
Density:	10.01 lb/gal-10.85 lb/gal
Suitability for storage:	min. 24 months at ≤ 77 °F in an unopened original container
Color tones:	Transparent, individual colours 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:

Aluminum

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

Steel

- Zinc phosphating

Galvanized steel

- Zinc phosphating
- Chrome (III) passivation
- Chromating according to DIN EN 12487

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).

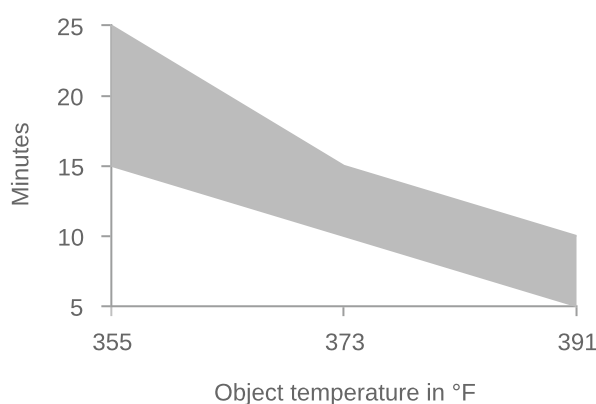
Coating devices

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

2.36 mil - 3.15 mil

Curing conditions



T_{Object}	t_{min}	t_{max}
356 °F	15 minutes	25 minutes
374 °F	10 minutes	15 minutes
392 °F	5 minutes	10 minutes

In order to determine ideal curing conditions, we recommend practical trials with the object in question and curing oven.

Application

Coloured transparent coating powders are mainly suitable for small parts or pipe constructions and not for large, flat surfaces. Furthermore, the visual impression is very much influenced by film thickness and homogeneity: Different film thicknesses result in different colour shades! For this reason, it is not advisable to recoat coloured-transparent powder coatings for repair purposes.

Devices and coating systems must be thoroughly cleaned before using the powder.

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: Aluminum (AlMg1), 0.8 mm, chromated
 Film thickness: 2.36 mil - 3.15 mil
 Object temperature: 374 °F, 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
Mandrel bending test	≤ 5 mm	DIN EN ISO 1519 2011
Impact test	≥ 20 inchp.	ASTM D 2794 1993
Erichsen cupping	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10

Weathering tests

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



More information

Packaging

15 kg cardboard box with inserted antistatic PE liner
400 kg cardboard container with antistatic PE-liner

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