



Technical data sheet

IGP-DURA®*than* 8909B-A2

High gloss polyurethane powder coating with very high chemical resistance and an elegant finish, above all in transparent shades.



Characteristics

- Gloss
- Smooth finish
- Transparent
- Industrial outdoor quality
- Antigraffiti



Powder properties

Particle size:	< 3.94 mil
Solids:	> 99 %
Density:	10.01 lb/gal-10.85 lb/gal
Suitability for storage:	min. 12 months at ≤ 77 °F in an unopened original container
Color tones:	transparent



Processing

Pre-treatment

Suitable for overcoating already painted surfaces, especially for the protection of metallic coatings.

The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. 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-TI100).

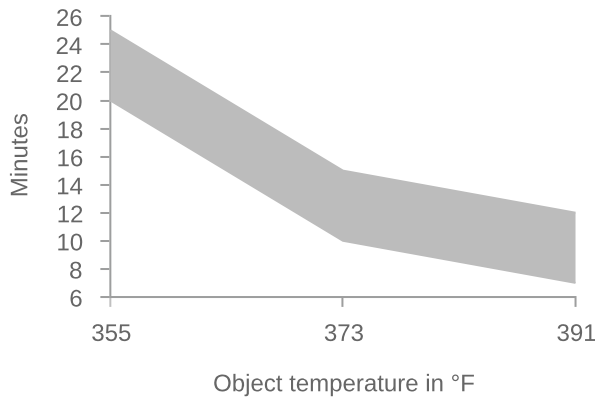
Coating devices

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

1.97 mil - 2.36 mil

Curing conditions



T Object	t min	t max
356 °F	20 minutes	25 minutes
374 °F	10 minutes	15 minutes
392 °F	7 minutes	12 minutes

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

Application

Devices and coating systems must be thoroughly cleaned before using the powder. For IGP-DURA® than 8909B, the IGP processing guideline VR 208 must also be observed.

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 chromium-free
 Film thickness: 1.97 mil - 2.36 mil
 Object temperature: 374 °F, 10 min.

Appearance

Gloss level	80-100 R'/60°	DIN EN ISO 2813 2015-02
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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 inchnp.	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
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Chemical tests

Organic solvents	Outstanding resistance to organic solvents
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More information

Packaging

15 kg cardboard box with inserted antistatic PE liner

Overcoating suitability

For overcoating anti-graffiti powder coatings, sanding and preliminary tests are mandatory.

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.

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 - Socostript 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