

Scheda tecnica

IGP-HWFclassic 5903M-S3 MeltedMetal

Superdurable effect powder coating for matte and smooth surfaces, formulated with brilliant metal interference pigments.



Proprietà

- Opaco
- Liscio
- Melted Metal, Premium
- Super durable facade quality, 3 years Florida > 50% residual gloss
- Erhöhte resistenza ai graffi
- Effetto clean



Omologazioni

- Qualicoat Nr. P-1137, class 2
- Part of QSC-System
- AAMA 2604-13, independent test report
- EPD IGP-HWFclassic 59



Proprietà delle polveri

Granulometria:	< 100 µm
Corpi solidi:	> 99 %
Densità:	1.3 kg/l-1.6 kg/l
Stoccaggio:	min. 24 months a ≤ 25 °C in an unopened original container
Color tones:	8 shades with metal interference pigments



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 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).

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.

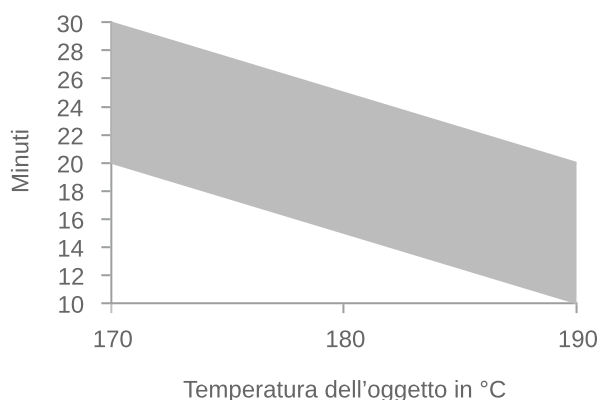
Spessore del film consigliato

80 µm - 100 µm

Whenever melted metal products are coated, the application parameter settings must be made in accordance with VR 216.

In particular, the note on purging air and gun distance in the Processing section of VR 216 must be observed.

Condizioni di cottura



T _{oggetto}	t _{min}	t _{max}
170 °C	20 minutes	30 minutes
180 °C	15 minutes	25 minutes
190 °C	10 minutes	20 minutes

Application

For safe and stable processing of the products, a slightly increased total air / metering air should be used, especially when conveying by means of pump technology.

For detailed information, please refer to the information in the section "processing" in the processing guideline VR216.

Recupero

Small amounts of recovered powder can be added to the fresh powder, automatically if possible. Important: Keep overspray to an absolute minimum. Processing instruction VR216 must be observed.



Caratteristiche del film

Testato per

Substrati:	Aluminum (AlMg1), 0.8 mm chrom-free
Spessore:	60 µm - 80 µm
Temperatura dell'oggetto:	180 °C, 15 min.

Struttura superficiale

Brillantezza	24-38 R'/60°	DIN EN ISO 2813 2015-02
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Prove meccaniche

Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Mandrel bending test / Tape test	≤ 5 mm	DIN EN ISO 1519 2011
Impact test / Tape test	≥ 2.5 Nm	ASTM D 2794 1993
Erichsen cupping / Tape test	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10 (Anhang A)
Robustness according to	≥ 50 %	IGP AA341.62
Martindale, residual gloss_50%		

Test di resistenza agli agenti atmosferici

3 years Florida, 5° south	> 50 % Brillantezza residua	DIN EN ISO 2810 2021-01
Xenon-arc lamps, 1000h, 90%	> 90 % Brillantezza residua	DIN EN ISO 16474-2 2014-03

Verifiche della resistenza a corrosione

Test con acqua di condensa, 1000h	Nessuna infiltrazione, nessuna vescica	DIN EN ISO 6270-2 2018-04
Test di nebbia salina all'acido acetico, 1000h	Nessuna infiltrazione, nessuna vescica	DIN EN ISO 9227 2017-07

Prove chimiche

Mortar resistance	Easily removable after 24h with no residues.	ASTM D 3260 2001
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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 for printing and glueing of painted surfaces.

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 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**