



Technical data sheet

## IGP-HWFclassic 5903U-S1

Superdurable, effect containing and more scratch-resistant coating powder for matte surfaces, produced with IGP-Effectives® technology.



### Characteristics

- Matte
- Smooth finish
- IGP-Effectives®
- Super durable facade quality, 3 years Florida > 50% residual gloss
- Clean Effect
- Increased scratch resistance



### Material approvals

- [GSB 173 q - Florida 3](#)
- [Qualicoat Nr. P-1531, class 2](#)
- Part of QSC-System
- [AAMA 2604-13, independent test report](#)
- [EPD IGP-HWFclassic 59](#)



### Powder properties

Particle size:	< 100 µm
Solids:	> 99 %
Density:	1.2 kg/l-1.6 kg/l
Suitability for storage:	min. 24 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 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 Qualisteelecoat 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.

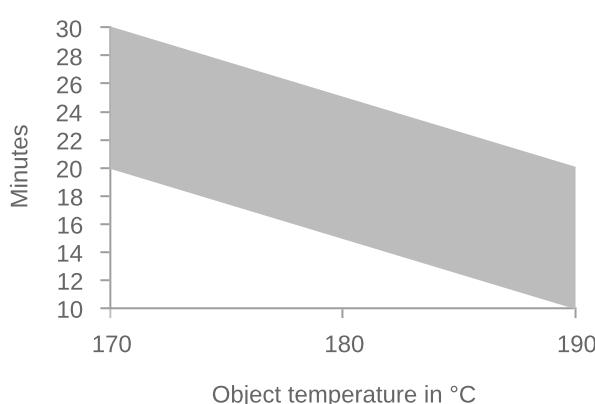
## Recommended film thickness

60 µm - 80 µm

A homogeneous coating result with textured paints or colour or article-specific differences in hiding power may require higher Film thicknesses. The corresponding processing guidelines must be observed.

For a preliminary calculation of the required powder coating quantity, the required Film thickness must be determined for each specific article.

## Curing conditions



T Object	t min	t max
170 °C	20 minutes	30 minutes
<b>180 °C</b>	<b>15 minutes</b>	<b>25 minutes</b>
190 °C	10 minutes	20 minutes

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

## Reclaimability

Due to the high bonding rate of powder grain and effect agent, the powder can be charged much more uniformly compared to other effect finishing processes. As a result, the powder can be processed with a significantly increased recovery rate. Please also refer to the IGP processing guideline for IGP-Effectives® powder coatings: VR201.2



# Film properties

## Tested on

Substrate: Aluminum (AlMg1), 0.8 mm chrom-free  
Film thickness: 60 µm - 80 µm  
Object temperature: 180 °C, 15 min.

## Appearance

Gloss level	20-30 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 / Tape test	≤ 5 mm	DIN EN ISO 1519 2011
Impact test / Tape test	≥ 20 inchp.	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 Martindale, residual gloss_50%	≥ 50 %	IGP AA341.62

## Weathering tests

3 years Florida, 5° south	> 50 % residual gloss	DIN EN ISO 2810 2021-01
Xenon-arc lamps, 1000h, 90%	> 90 % residual gloss	DIN EN ISO 16474-2 2014-03
QUV-SE-B-313, 600h	> 50 % residual gloss	DIN EN ISO 16474-3 2014-03

## Corrosion tests

Condensation water test, 1000h	No infiltration, no blisters	DIN EN ISO 6270-2 2018-04
Acetic acid salt spray test, 1000h	No infiltration, no blisters	DIN EN ISO 9227 2017-07

## Chemical tests

Mortar resistance	Easily removable after 24h with no residues.	ASTM D 3260 2001
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## Further information

### Packaging

20 kg cardboard box with inserted antistatic PE liner  
500 kg cardboard container with 25 antistatic PE-liners each 20kg

### Overcoating suitability

Preliminary tests are mandatory for overcoating painted surfaces.

### Printing and glueing

Preliminary tests are mandatory for printing and glueing of painted surfaces.

### **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.

### **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)