IGP POWDER COATINGS

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Scheda tecnica

IGP-HWFclassic 5907M-S3 Melted Metal

Superdurable powder coating for silk-gloss and smooth surfaces, based on highly brilliant metal interference pigments.

Proprietà

- Semi lucido
- Superficie liscia
- Melted Metal
- Premium
- Super durable facade quality, 3 years Florida > 50% residual gloss
- Erhöhte resistenza ai graffi
- Effetto clean

Omologazioni

- Qualicoat Nr. P-1535, class 2
- Qualicoat Nr. P-1136, class 2

QUALICOAT
Inspired by architecture, trusted by professionals

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.

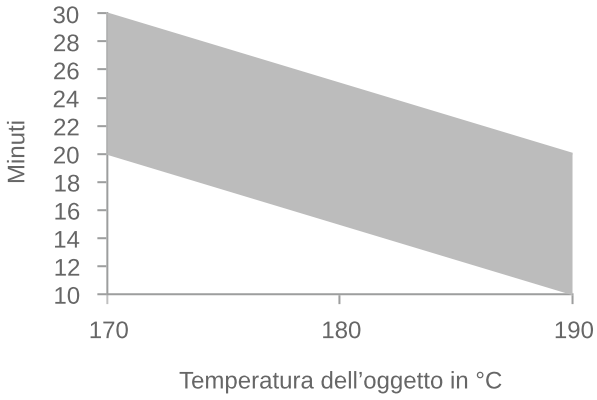
The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. The minimum requirement for aluminium substrates / galvanised steel components is to carry out a boiling water test with a subsequent cross-cut adhesion and tape test. We 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	71-100 R'/60°	DIN EN ISO 2813 2015-02

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 Martindale, residual gloss_50%	≥ 50 %	IGP AA341.62

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

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

Prove chimiche

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

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.