



## Technical data sheet

# IGP-HWFclassic 591TA-R1

Deep matte, fine-textured, superdurable powder coating based on saturated polyester and a declaration-free hardener, which offers good weathering and robustness.



## Characteristics

- Deep matte
- Fine texture
- Uni, without effect
- Super durable facade quality, 3 years Florida > 50% residual gloss
- More robust & pliable



## Material approvals

- [Qualicoat Nr. P-1173, class 2](#)
- Part of QSC-System
- [Qualicoat Nr. P-1921, class 2](#)
- [Qualicoat Nr. P-1924, class 2](#)
- [AAMA 2604-13, independent test report](#)
- [EPD IGP-HWFclassic 59](#)



## Powder properties

|                          |                                                                                                                                                                                    |
|--------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Particle size:           | < 100 µm                                                                                                                                                                           |
| Solids:                  | > 99 %                                                                                                                                                                             |
| Density:                 | 1.3 kg/l-1.6 kg/l                                                                                                                                                                  |
| Suitability for storage: | min. 24 months at ≤ 25 °C<br>in an unopened original container                                                                                                                     |
| Color tones:             | Due to the limited volume of highly weather-resistant pigments, the product portfolio only has a small amount of different shades in accordance with the special IGP colour range. |



## 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 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.

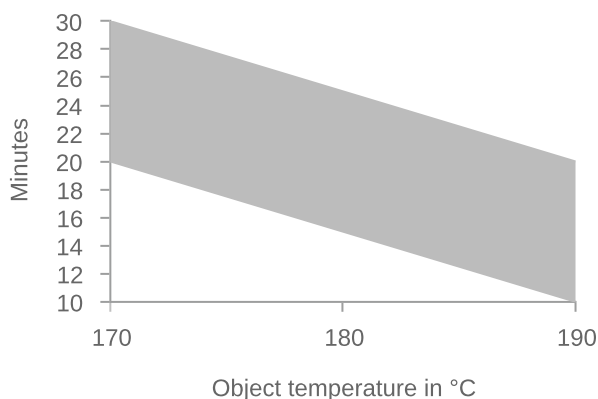
## Recommended film thickness

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

Small portions of recycled powder can be added, automatically if possible, to the fresh powder. Important: Keep overspray to an absolute minimum. Processing instruction VR214 must be observed.



## Film properties

### Tested on

|                     |                                     |
|---------------------|-------------------------------------|
| Substrate:          | Aluminum (AlMg1), 0.8 mm chrom-free |
| Tested colours:     | RAL 9010, 5010, 3005                |
| Film thickness:     | 60 µm - 80 µm                       |
| Object temperature: | 180 °C, 15 min.                     |

### Appearance

|             |             |                         |
|-------------|-------------|-------------------------|
| Gloss level | 2-12 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 / 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) |

### 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 |

### 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 |
|-------------------|----------------------------------------------|------------------|



## Further information

### Packaging

20 kg cardboard box with inserted antistatic PE liner

### 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.

### **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](https://www.igp-powder.com)**