



Scheda tecnica

## IGP-HWFindustry 7906A-A0

Superdurable, low-temperature powder coatings, curable at 160 °C or above, for heavy steel parts and constructions.



### Proprietà

- Semi lucido
- Superficie liscia
- Tinte unite
- Qualità industriale altamente resistente alle inte



### 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:	On request



### 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:

Acciaio

- Blasting (at least SA 2 ½)
- Iron phosphating
- 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 18 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 commercially available electrostatic systems, both corona and tribo charge systems.

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.

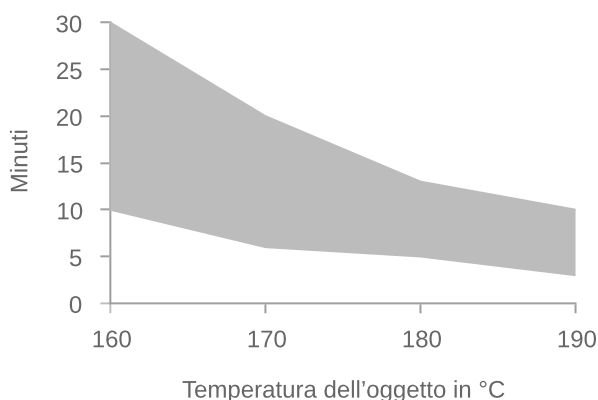
### Spessore del film consigliato

80 µm - 100 µm

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

For a pre-calculation of the required powder coating quantity, the necessary coating thickness must be determined for each article.

### Condizioni di cottura



T <sub>oggetto</sub>	t <sub>min</sub>	t <sub>max</sub>
160 °C	10 minutes	30 minutes
170 °C	6 minutes	20 minutes
180 °C	5 minutes	13 minutes
190 °C	3 minutes	10 minutes

Per accertare le condizioni di cottura migliori si consiglia, in ogni caso, di effettuare prove pratiche con il rispettivo oggetto e forno di polimerizzazione.

### Recupero

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



## Caratteristiche del film

### Testato per

Substrati: Steel, 0.5mm  
Spessore: 80 µm - 100 µm  
Temperatura dell'oggetto: 160 °C, 10 min.

### Struttura superficiale

Brillantezza

50-70 R'/60°

DIN EN ISO 2813 2015-02

## Prove meccaniche

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Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Erichsen cupping / Tape test	≥ 2 mm	DIN EN ISO 1520 2007-11

## Test di resistenza agli agenti atmosferici

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QUV-SE-B-313, 600h	> 50 % Brillantezza residua	DIN EN ISO 16474-3 2014-03
Xenon-arc lamps, 1500h	> 70 % Brillantezza residua	DIN EN ISO 16474-2 2014-03

## Verifiche della resistenza a corrosione

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Condensation water test, 480h	No delamination No bubbles No edge corrosion	DIN EN ISO 6270-2 2018-04
Neutral salt spray test, 480h	Iron phosphating (Gardobond 4976 /6800 OC): < 5mm infiltration Low edge corrosion no blistering  Zinc phosphating (Gardobond 26S / 6800 OC): < 1mm infiltration very low edge corrosion no blistering	DIN EN ISO 9227 2017-07

## Prove chimiche

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Operating materials	Good resistance to chemicals, especially cleaning agents, operating fluids and fuels.
Acids and alkalis	Good resistance to many dilute acids and alkalis.



## Altre informazioni

### Imballaggio

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

### 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.

**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](http://igp-powder.com)