



app.print.technical_data_sheet.title

IGP-KORROPRIMER 3002A-A0

Powder coating primer based on polyester and epoxy resins especially for priming aluminum substrates.



app.print.technical_data_sheet.characteristics.title

- Matte
- Smooth finish
- Uni, without effect
- Indoor quality



- Qualicoat No. P-1165, two-coat approval



app.print.technical_data_sheet.powder_properties.title

app.print.technical_data_sheet.powder_properties.particle_size:
ca. 90 µm
app.print.technical_data_sheet.powder_properties.solid:
ca. 99 %
app.print.technical_data_sheet.powder_properties.density:
ca. 1,5 kg/l
app.print.technical_data_sheet.powder_properties.storage_suitability.prefix
24 months
app.print.technical_data_sheet.powder_properties.storage_suitability.at
25 °C
in an unopened original container
app.print.technical_data_sheet.powder_properties.color_tones:
ca. RAL 7012
ca. RAL 7042



app.print.technical_data_sheet.processing.title

app.print.technical_data_sheet.processing.substrates

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
- Chrome-free pretreatment according to GSB International and QUALICOAT specifications
 - Chromating according to DIN EN 12487
 - Pre-anodization

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).

app.print.technical_data_sheet.processing.coating_devices

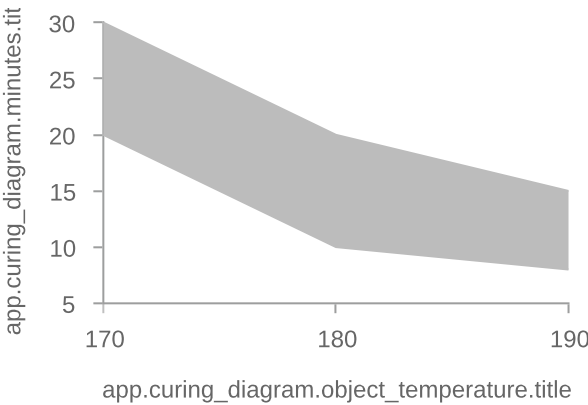
All commercially available electrostatic systems, both corona and tribo charge systems.
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

app.print.technical_data_sheet.processing.recommended_film_thickness

60 µm - 80 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.

app.print.technical_data_sheet.processing.curing_condition_recommendation



app.print.technical_data_sheet.processing.curing_conditi

170 °C
180 °C
190 °C

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



app.print.technical_data_sheet.film_properties.title

app.print.technical_data_sheet.film_properties.tested_on.title

app.print.technical_data_sheet.film_properties.tested_on.title
Apparient (Al-Mg-1) 3.8 mm chrom-free
app.print.technical_data_sheet.film_properties.tested_on.title
2-layer system GB-DuBa® face 5807
app.print.technical_data_sheet.film_properties.tested_on.title
140 µm film thickness:
app.print.technical_data_sheet.film_properties.tested_on.title
180 °C 10 min object temperature:

app.print.technical_data_sheet.film_properties.mechanical_tests

Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Mandrel bending test	≤ 6 mm	DIN EN ISO 1519 2011
Impact test	≥ 20 inchn.	ASTM D 2794 1993
Erichsen cupping	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10 (Anhang A)

app.print.technical_data_sheet.film_properties.corrosion_tests

Condensation water test, 2000h	Infiltration < 1 mm , no blisters	DIN EN ISO 6270-2 2018-04
Acetic acid salt spray test, 2000h	Infiltration <1mm, no blisters	DIN EN ISO 9227 2017-07



app.print.technical_data_sheet.more_information.title

app.print.technical_data_sheet.infobox