



Technical data sheet

IGP-KORROPRIMER 3002A-A0

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



Characteristics

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



Material approvals

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



Powder properties

Particle size:	< 100 µm
Solids:	ca. 99 %
Density:	1.5 kg/l-1.6 kg/l
Suitability for storage:	min. 24 months at ≤ 25 °C in an unopened original container
Color tones:	ca. RAL 7012 ca. RAL 7042



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

- 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).

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.

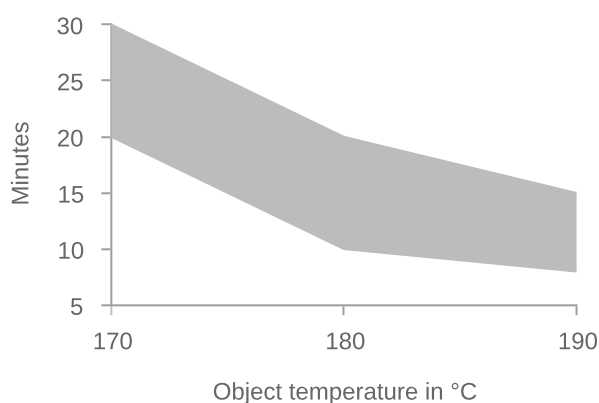
Recommended film thickness

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.

Curing conditions



T _{Object}	t _{min}	t _{max}
170 °C	20 minutes	30 minutes
180 °C	10 minutes	20 minutes
190 °C	8 minutes	15 minutes

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



Film properties

Tested on

Substrate: Aluminum (AlMg1), 0.8 mm chrom-free
 Tested colours: 2-layer with IGP-DURA®face 5807
 Film thickness: 140 µm
 Object temperature: 180 °C, 10 min.

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 inchp.	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)

Corrosion tests

Condensation water test, 2000h
Acetic acid salt spray test, 2000h

Infiltration < 1 mm , no blisters
Infiltration <1mm, no blisters

DIN EN ISO 6270-2 2018-04
DIN EN ISO 9227 2017-07



Further information

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)**