



Technical data sheet

IGP-RAPID® primer 854SA-A2

Highly reactive and ultra low cure primer powder coating for optimal sanding properties and various liquid top coating materials to support optimal surface finish.



Characteristics

- Silk gloss
- Var. fine texture
- Uni colors
- Indoor quality



Powder properties

| | |
|--------------------------|--|
| Particle size: | < 3.94 mil |
| Solids: | > 99 % |
| Density: | 10.85 lb/gal-13.35 lb/gal |
| Suitability for storage: | min. 6 months at ≤ 59 °F min. 12 months at ≤ 41 °F in an unopened original container |
| Color tones: | ca. NCS-S-0500-N |



Processing

Pre-treatment

If the surface finish of the MDF ex-works does not meet the quality requirements of the end product, the surface has to be sanded. This will ensure that the material has an evenly smooth surface and is free of any contaminants, minor scratches, dust, grease, etc. For more information, see IGP-TI 111.

Coating devices

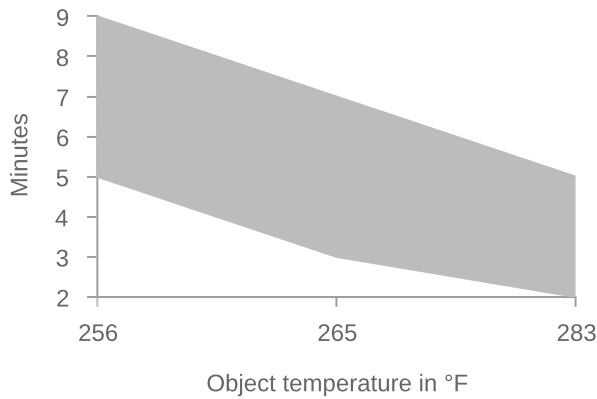
All conventional electrostatic systems with corona charging. For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

Recommended film thickness

3.94 mil - 5.51 mil

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} |
|---------------------------|------------------------|------------------------|
| 257 °F | 5 minutes | 9 minutes |
| 266 °F | 3 minutes | 7 minutes |
| 284 °F | 2 minutes | 5 minutes |

Due to the limited thermal conductivity, the use of infrared (electric / gas catalytic) or combined convectional / infrared ovens is recommended. In order to determine ideal curing conditions, we recommend practical trials with the object in question and curing oven. The curing conditions must be carefully controlled. Powder coatings cured outside the curing window may show deficiencies in the film flexibility. Our technical customer service will advise you.

Reclaimability

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



Film properties

Tested on

Substrate:

EGGER MBP-L 25 mm

Tested setting:

IGP-RAPID®primer 85 was tested in the build-up with wet paints from Dold AG. The primer was sanded before the following wet paints were overcoated:

- Duro Pur
- Durocal topcoat
- DPU 240-90
- DPU 240-10
- AI DO Clear Lacquer

Film thickness:

4.33 mil - 5.12 mil

Object temperature:

266 °F, 3 min.

Mechanical tests

Cross-cut adhesion test

Gt 0

DIN EN ISO 2409 2020-12

Additional properties

Resistance to alternating climates

i.O.

AMK-Merkblatt 005 2015-04

Module 3, 10 cycles:
no visible changes



More information

Packaging

20 kg cardboard box with inserted antistatic PE liner

Overcoating suitability

Preliminary tests are mandatory for overcoating painted surfaces.

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