



Technical data sheet

IGP-RAPID® primer 854SA-E2

Highly reactive primer to optimally prepare MDF substrates for overcoating with powder coatings.



Characteristics

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



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 ca. NCS S 5000-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

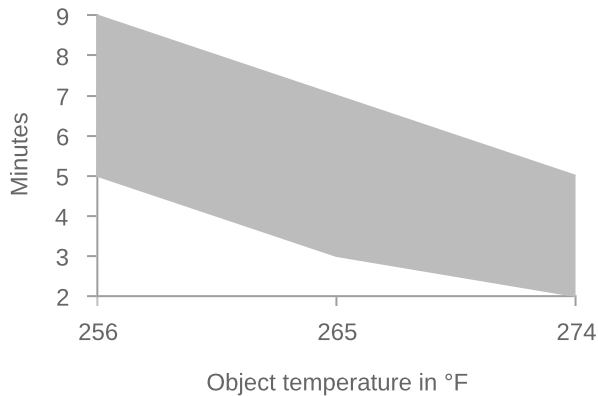
All conventional electrostatic systems with corona charging. For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

Recommended film thickness

3.15 mil - 3.94 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
275 °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

Tested setting:

Getestet mit 381M mit einer Gesamtschichtdicke > 160µm

Object temperature:

266 °F, 3 min.

Mechanical tests

Hinge Hole Test

≤ 1.1

IGP AA341.54



More information

Packaging

20 kg cardboard box with inserted antistatic PE liner

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**