



## Technical data sheet

# IGP-RAPID®*top* 381TE-A2

Deep matte powder topcoat with a fine texture for two-coat application on temperature-sensitive wood-based materials in interiors.



## Characteristics

- Deep matte
- Fine texture
- Pearl mica
- Indoor quality



## Powder properties

|                          |                                                                                           |
|--------------------------|-------------------------------------------------------------------------------------------|
| Particle size:           | < 100 µm                                                                                  |
| Solids:                  | > 99 %                                                                                    |
| Density:                 | 1.3 kg/l-1.6 kg/l                                                                         |
| Suitability for storage: | min. 9 months at ≤ 15 °C<br>min. 6 months at ≤ 25 °C<br>in an unopened original container |
| Color tones:             | RAL Metallic and individual metallic colors on request                                    |



## 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.

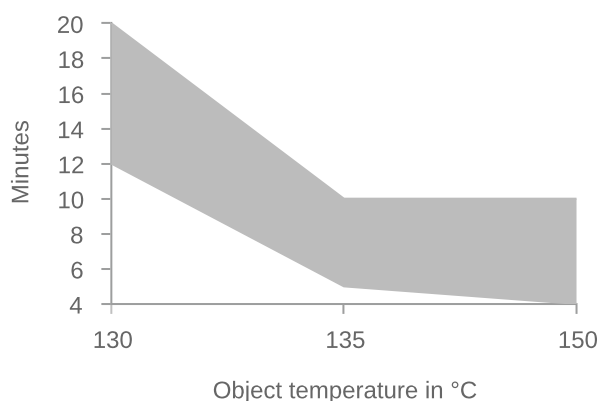
### Recommended film thickness

80 µm - 100 µm

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

For a preliminary calculation of the required powder coating quantity, the required Film thickness must be determined for each specific article.

## Curing conditions



| T <sub>Object</sub> | t <sub>min</sub> | t <sub>max</sub>  |
|---------------------|------------------|-------------------|
| 130 °C              | 12 minutes       | 20 minutes        |
| <b>135 °C</b>       | <b>5 minutes</b> | <b>10 minutes</b> |
| 150 °C              | 4 minutes        | 10 minutes        |

Due to the limited thermal conductivity, the use of infrared- (electric / gas catalytic) or convectional - infrared combined ovens is recommended.

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

## Application

For optimal coating and surface quality, please follow the recommendations in technical information TI111

## Reclaimability

To prevent colour variations caused by loss of effect during coating, pearlescent mica products should be processed without reclaiming. In the case of automated coating with an appropriate batch size, a certain quantity of reclaimed powder may be added, depending on the shade's categorisation. Please refer to the effect category on the container label and processing guideline VR201.1.



## Film properties

### Tested on

Substrate: EGGER MBP-L 25mm  
Tested setting: Tested on Primer 13 with a total film thickness > 160µm  
Object temperature: 135 °C, 5 min.

### Mechanical tests

|                 |       |              |
|-----------------|-------|--------------|
| Hinge Hole Test | ≤ 1.1 | IGP AA341.42 |
|-----------------|-------|--------------|

### Chemical tests

|              |            |              |
|--------------|------------|--------------|
| Acetone test | 1N Level 2 | IGP AA341.44 |
|--------------|------------|--------------|

### Additional properties

|                                  |   |                       |
|----------------------------------|---|-----------------------|
| Behavior at chemical influence   | B | DIN 68861 - 1 2011-01 |
| Behavior at abrasion             | C | DIN 68861 - 2 2020-07 |
| Behaviour at scratches           | D | DIN 68861 - 4 2013-02 |
| Behaviour subjection to dry heat | C | DIN 68861-7 1985-04   |

|                                                                                  |      |                           |
|----------------------------------------------------------------------------------|------|---------------------------|
| Behaviour on subjection to wet heat                                              | B    | DIN 68861 - 8 2001-04     |
| Lightfastness                                                                    | > 6  | DIN EN 15187 2006-12      |
| Water vapor admission<br>3 cycles: no visible changes                            | i.O. | DIN 68930 2009-11         |
| Resistance to alternating climates<br>1 cycle: no visible changes                | i.O. | DIN 68930 2009-11         |
| Resistance to alternating climates<br>Module 3, 10 cycles:<br>no visible changes | i.O. | AMK-Merkblatt 005 2015-04 |
| Humidity resistance<br>Module 2, 14 days:<br>no visible changes                  | i.O. | AMK-Merkblatt 005 2015-04 |



## Further information

### Packaging

20 kg cardboard box with inserted antistatic PE liner

### Protection of coated parts

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.

### Cleaning

The coated parts must be cleaned according to the directives RAL-GZ 632 or SZFF 61.01. Technical Information IGP-TI 106 must also be observed when dealing with pearl mica effects.

### 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\*\*](https://www.igp-powder.com)