



IGP-DURA[®]face 521ME

Fine structure, matt with pearl-mica effect
Facade quality

Matt, weather-resistant fine structure powder with pearl-mica effect on saturated polyester resin base, incl. the appropriate hardener, and special heat, light and chalk resistant pigments.

Technical Data Sheet

Properties

- excellent light and weather resistance
- impact-proof surface with decorative pearl-mica fine structure effect
- good elasticity

Non-yellowing in direct-heat gas ovens.

Application

- Facade elements, window profile sections
- Garden and camping furniture
- Machine casings, switchgear cabinets
- Domestic appliances
- Lights
- Agricultural machinery
- Railing sections

Product range

Surface appearance

- **521ME** fine structure, matt, with pearl-mica effect.

Colour shades

Mainly colour shades as shown in the IGP colour chart "Eisenglimmer-Effekt", as well as special house shades.

Powder specifications

- Particle size: < 100 µm
- Solids: approx. 99%
- Density acc. to shade: 1.3 - 1.6 kg/l
- Storage stability: 12 months
- Storage temperature: < 25° C

Packing

- Carton with antistatic PE bag liner, capacity 20 kg,
- Carton container with 25 antistatic PE bags, 20 kg each; capacity 500 kg

Material approvals:
Qualicoat No. P-0400, Class1

Product declarations:
Safety data sheet: SD 110



IGP Pulvertechnik AG
Industrie Stelz, Kirchberg
CH-9500 Wil
Telefon +41 (0)71 929 81 11
Telefax +41 (0)71 929 81 81
www.igp.ch
info@igp.ch

www.doldgroup.com

IGP-DURA[®]face 521ME

Processing instructions

Pre-treatment

The substrate to be coated must be free of oxidants, cinder, oil, grease, stripping agents and other residues. For exterior use, pre-treatment matching the substrate is absolutely necessary:

- Aluminium and zinc-plated steel sheeting: Chromatising DIN EN ISO 12487.
- Steel: zinc or Fe-phosphating, additionally coated with **IGP Korroprimer 10**.

For further information: see also our special leaflet on pre-treatment (IGP-TI 100).

Coating equipment

All commercially available electrostatic corona systems. Relevant regulations: VDE requirements and VDM data sheet 24371.

Recycling

Small portions of recycled powder should be added, automatically if possible, to the fresh powder.

Important:

Keep overspray to an absolute minimum.

Processing instruction VR 201 must be observed.

Stoving conditions

The temperature and time combinations resulting in optimum cross-linking of the coating are shown.

<i>Object temperature</i>	<i>Retention time at object</i>	
	<i>minimal</i>	<i>maximum</i>
180°C	10 min.	30 min.
190°C	8 min.	20 min.
200°C	5 min.	10 min.

You are advised to carry out practical trials adapted to the object in question and the stoving oven in order to determine the optimum stoving conditions. Our Technical Department will be glad to help.

Technological values

To determine the following data, IGP-DURA[®]face 521ME was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Coating thickness 80 µm
- Object temperature 180°C, 10 min.

Gloss class after limit samples

Cross-cut adhesion test, DIN EN ISO 2813 Gt 0

Mandrel bending test, DIN EN ISO 1519 < 6 mm

Impact penetr., ASTM D2794 > 20 inchp.

Erichsen cupping, DIN EN ISO 1520 > 5 mm

Buchholz hardness, DIN EN ISO 2815 > 80

Accelerated weathering-test

DIN EN ISO 11341: > 50% residual gloss after 1000h.

Weathering

1 year Florida, 5° south: > 50% residual gloss. DIN EN ISO 2810

1000h condensation water test, EN ISO 6270-2: no infiltration, no blisters.

1000h salt spray test, DIN EN ISO 9227: no infiltration, no blisters.

Mortar resistance, ASTM D 3260:

Easily removable after 24h with no residues.

Cleaning

Coated parts to be cleaned in compliance with the regulations RAL-GZ 632 or SZFF 61.01.

For pearl-mica effect, the Technical Information IGP-TI 106 must also be observed.

Note

Our technical advice on application, given verbally, in writing or through trials is provided to the best of our knowledge but is to be regarded solely as non-binding information and does not release you from the need to carry out your own tests and trials.

Application, use and processing of the products take place outside our control and are therefore exclusively within your own responsibility.



Powderful Solutions.