



IGP-DURA[®]face 5803

Mat facade quality

IGP-DURA[®]face 5803 is a weather resistant, **mat coating system** on saturated polyester resin base, the corresponding hardener plus special heat, light and chalk resistant pigments.

Technical Data Sheet

Characteristics

- excellent weather and light resistance
- impact-resistant surface with excellent flow
- good elasticity
- no yellowing in direct-heat gas furnaces.

Applications

- Facade elements, window profiles,
- Bicycle frames
- Agricultural machines
- Garden and Camping furniture
- Housings for automatic devices, switch cabinets
- Lights
- Balcony parts

Product range

Surface appearance

- 5803A, smooth flowing, mat
- 5803E, smooth flowing, mat, Pearl Mica effect
- 5803H, smooth flowing, mat, Crystal color effect

Gloss class, DIN EN ISO 2813: 25-35 R/60°

The products IGP-DURA[®]face 5803A and 5803E are also optionally available with IGP-DURA[®]clean. Thereby they receive an easy cleanable surface.

Shades

Mainly RAL and NCS shades; special house shades on request.

Powder specifications

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

Packing

- Carton with antistatic PE liner capacity 20 kg.
- Carton container with 25 antistatic PE liners for 20 / 15 kg; capacity 500kg.

Material approvals:
Qualicoat No. P-0540, class 1
GSB No.: 109 m, class "standard"

Product declarations:
Safety data sheet: SD 010



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IGP-DURA[®]face 5803

Processing instructions

Pre-treatment

The substrate to be coated must be free of oxidation products, scale, oil, grease, stripping agents and other residues.

For outdoor use, pre-treatment matching the substrate/surface is absolutely necessary:

- Aluminium: chromatising DIN EN ISO 12487
- Galvanised sheet: likewise DIN EN ISO 12487,
- Steel: Zinc or Fe phosphating, also 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 systems, both corona and Tribo charge systems. Exceptions are Pearl Mica and Crystal Color effects which must be processed only with corona charging.

Relevant regulations: VDE requirements and VDM data sheet 24371.

Recycling

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

For Pearl Mica effects, refer also to processing instruction VR 201.

Stoving conditions

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

| <i>Object temperature</i> | <i>Retention time at object</i> | |
|---------------------------|---------------------------------|----------------|
| | <i>minimal</i> | <i>maximal</i> |
| 170°C | 15 min. | 30 min. |
| 180°C | 10 min. | 20 min. |
| 190°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 5803 was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Shades RAL 9010, 5010, 3005
- Coating thickness 60-80 µm
- Object temperature 180°C, 10 min.

| | |
|--|----------------|
| Gloss class, DIN EN ISO 2813 | 25-35 R' / 60° |
| Cross-cut adhesion test, DIN EN ISO 2409 | Gt 0 |
| Mandrel bending test, DIN EN ISO 1519 | < 5 mm |
| Impact-Test, ASTM D2794 | > 20 inchp. |
| Erichsen cupping, DIN EN ISO 1520 | > 5 mm |
| Buchholz hardness, DIN EN ISO 2815 | > 80 |

Accelerated weathering-test

QUV/SE-B-313, DIN EN ISO 11507/ASTM G-53-88:
after 300h >50% residual gloss
DIN EN ISO 11341: >50% residual gloss after 1000h.

Weathering

1 year Florida, 5° south: > 50% residual gloss.

1000h condensation water test, DIN 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

The coated parts are to be cleaned according to the specifications RAL-GZ 632 or SZFF 61.01.

For Pearl Mica effects, the Technical Information IGP-TI 106 must be observed in addition.

Notes

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 ability to supervise and are therefore exclusively your own responsibility.

