



## IGP-DURA<sup>®</sup>face 5809

Facade quality

IGP-DURA<sup>®</sup>face 5809 is a **weather resistant, gloss coating system** on a saturated polyester resin base, the corresponding hardener plus special heat, light and chalk resistant pigments.

# Technical Data Sheet

### Characteristics

- excellent light and weather resistance
- impact resistant surface with excellent flow
- good elasticity
- No yellowing with directly heated gas ovens.

### 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 appearances

- **5809A**, smooth flowing, gloss
  - **5809E**, gloss Pearl Mica effect
- Gloss class, DIN EN ISO 2813: 75-95 R<sup>1</sup>/60°

The products IGP-DURA<sup>®</sup>face 5809A and 5809E are also optionally available with IGP-DURA<sup>®</sup>clean. Thereby they receive an easy cleanable surface.

#### Shades

Mainly RAL and NCS shades; also special domestic shades by arrangement.

### Powder specification

- Particle size: < 100µm
- Solids: > 99%
- Density according to shade: 1.3 – 1.6 kg/l
- Storage stability: min. 24 months
- Storage temperature: < 25° Celsius

### Packing

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

Material approvals:  
Qualicoat No. P-0614, class 1  
GSB No. 109q, class «standard»

Product declarations:  
Safety data sheet: SD 010



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<sup>®</sup>face 5809

## Processing instructions

### Pre treatment

The substrate must be free of oxidation products, scale, oil, grease or mould-release residues.

For outdoor use, a pre-treatment adapted to the substrate is absolutely imperative:

- 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 metallic effects which must be processed with Corona charge.

Relevant regulations: VDE requirements and the VDM data sheet 24371.

### Recycling capacity

Small proportions of recycled powder should be added (automatically if possible) to the fresh powder and then processed.

For Pearl Mica effects, refer also to processing instruction IGP-PG 201.

### Stoving conditions

Given are the temperature and time combinations which result in optimal cross-linking of the coating.

Object- temperature	Retention time at object temperature	
	minimum	maximum
170°C	20 min.	40 min.
<b>180°C</b>	<b>15 min.</b>	30 min.
190°C	10 min.	20 min.

To obtain optimal stoving conditions you are recommended to carry out practical trials each time, adapted to the object in question and the stoving oven. Our technical service department will be glad to advise you.

## Technological values

To obtain the following data IGP-DURA<sup>®</sup>face 5809A 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, 15 min.

Gloss class, DIN EN ISO 2813	75 - 95 R' / 60°
Cross-cut adhesion test, DIN EN ISO 2409	Gt 0
Mandrel bending test, DIN EN ISO 1519	< 5 mm
Impact penetr., ASTM 2794	> 20 inchp.
Erichsen cupping, DIN EN ISO 1520	< 5 mm
Buchholz hardness, DIN EN ISO 2815	> 80

### Weathering:

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

### 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.

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 residue.

### Cleaning

The coated parts are to be cleaned according to the specifications RAL-GZ 632 or SZFF 6101.

For Pearl Mica-effects, additionally note Technical Information IGP-TI 106.

## Note

Our technical advice on application, given verbally, in writing and 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.

At a permanent damp and warmth influence it can come to local pale water spots. This appearance doesn't represent any product defect and can be removed by warming of the places concerned completely.



Powderful Solutions.