



IGP-DURA[®]face 581M

Fine structure, matt

Facade quality

Matt, weather-resistant fine structure powder 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 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
- Lights
- Bicycle frames
- Agricultural machinery
- Railing sections

Product range

Surface appearance

- **581MA**, fine structure, matt
- **581ME**, fine structure, matt, with pearl-mica effect

Colour shades

Mainly RAL and NCS shades, 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: min. 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:
GSB No. 109n, class «standard»
Qualicoat No. P-0561, class 1

Product declarations:
Safety data sheet: SD 010



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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 systems, both corona and Tribo charge systems. Exceptions are Pearl Mica effects, IGP-DURA[®]face 581ME which must be processed only with corona charging. 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>Objecttemperature</i>	<i>Retention time at object</i>	
	<i>minimal</i>	<i>maximum</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 581MA/E 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	< 5 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.
QUV/SE-B-313, DIN EN ISO 11507/ASTM G-53-88:
after 300 h > 50% residual glosses

Weathering

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

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

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 too 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.



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