



IGP-DURA[®]face 8003

Facade quality

Weather-resistant, mat Polyurethane-coating system on a saturated polyester resin base and with declaration-free hardener, with special heat, light and chalk resistant pigments.

Technical Data Sheet

Characteristics

- excellent light and weather resistance
- impact resistant surface with excellent flow
- largely degassing free on porous substrates, e.g. zinc-plated steel.
- No yellowing in direct-heat gas furnaces.

Applications

- Zinc-plated Steel components
- Window profile sections
- Agricultural machinery
- Garden and camping furniture
- Aggregate housings, switchgear cabinets
- Lights
- Railing and banister sections

Product range

Surface appearance

- **8003A**, smooth flowing, mat
 - **8003E**, mat Pearl Mica Effect
- Gloss Level, DIN EN ISO 2813: 25-35 R'/60°

Colour shades

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

Powder specification

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



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IGP-DURA®face 8003

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/surface is absolutely necessary:

- Aluminium: Chromatising DIN EN ISO 12487
- Galvanised sheet metal: also 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, with Corona charge.

For coatings with 8003E, refer also to IGP Processing instruction VR 201.

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 and processed.

For pearl mica effects, the additional processing guideline VR 201 must be observed.

Stoving conditions

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

<i>Objecttemperature</i>	<i>Retention time at object</i>	
	<i>minimal</i>	<i>maximum</i>
180°C	20 min.	25 min.
190°C	15 min.	20 min.
200°C	10 min.	15 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 8003A was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Colour shades RAL 9010, 5010, 3005
- Coating thickness 60-80 µm
- Object temperature 190°C, 15 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 penetration, 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, 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 RAL-GZ 632 or SZFF 61.01.

For pearl mica effects, 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 ability to supervise and are therefore exclusively your own responsibility.

