



IGP-DURA[®]face 80B

Facade quality

Transparent

Weather resistant, crack-free Polyurethane-coating system on a saturated polyester resin base and with declaration-free hardener.

Technical Data Sheet

Characteristics

- good light and weather resistance
- impact resistant surface with excellent flow
- very good mechanical properties
- excellent transparency and brilliance
- No yellowing with directly heated gas ovens.

Applications

- as a "top coat" for the finishing of
- metallic coatings for:
 - bicycle frames
 - engine casings
 - facade components
 - wheel rims
 - drain fittings
- decorative interior fittings of:
 - Brass
 - Chrome
 - Nickel

Product range

Surface appearances

- **8009B**, smooth flowing, glossy
Gloss class, DIN EN ISO 2813: > 85 R' / 60°
- **8005B**, smooth flowing, silk matt
Gloss class, DIN EN ISO 2813: 45-55 R' / 60°

Shades

- colourless, transparent

Powder specification

- Particle size: < 100µm
- Solids: > 99%
- Density according to shade: 1.2 kg/l
- Storage stability: min. 12 months
- Storage temperature: < 25° Celsius

Packing

- Carton with antistatic PE liner, capacity 20 kg
- Carton container with 25 antistatic PE liners for 20kg, Capacity 400 kg

Safety data sheet: SD 010



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IGP-DURA[®]face 80B

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.

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

Coating equipment

8009B: all commercially available electrostatic systems, both Corona and Tribo charge systems.

8005B: must be processed with Corona charge.

VDE requirements and the VDM data sheet 24371.

Coating / Recycling

Naturally special attention must be paid to the cleanliness of equipment and the environment with transparent coatings.

Small proportions of recycled powder should be added to the fresh powder, where possibly automatically.

Important:

Overspray should in all cases be kept as low as possible

Stoving conditions

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

<i>Object temperature</i>	<i>Retention time at object</i>	
	<i>minimal</i>	<i>maximum</i>
180°C	20 min.	25 min.
190°C	10 min.	20 min.
200°C	7 min.	15 min.

These specified stoving conditions must be observed in order to avoid cracking if the object temperature is too low or yellowing if it is too high (>210°C).

You are recommended to carry out practical trials adapted to the object in question and the stoving oven, in order to achieve optimal stoving conditions. Our Technical Service department will be glad to advise you.

Technological values

To determine the following data, IGP-DURA[®]face 80B was applied as follows:

- Aluminium sheet (AlMg1) 0.6mm, chromatised
- Coating thickness 60-80 µm
- Object temperature 190°C for 10 min.

IGP-DURA[®]face 8009B

Gloss class, DIN EN ISO 2813 > 85 R' / 60°

IGP-DURA[®]face 8005B

Gloss class, DIN EN ISO 2813 > 45-55 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 inchnp.

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:

> 50 residual gloss after 300 h.

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

Weathering

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

Cleaning

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

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.

