



IGP-DURA®*mix* 3302

Indoor quality

Thin-film coating powder

IGP-DURA®*mix* 3302 T00 and U00 is a matt coating powder on polyester and epoxy resin base, plus the corresponding light and heat resistant pigments, a product with modified particle size distribution.

Technical Data Sheet

Characteristics

- optimised coverage
- reduced layer thickness down to 30% possible
- impact resistant, matt surface with excellent flow
- good general resistance properties
- high yellowing resistance during stoving
- foldable

Applications

- For non-complex parts geometries
- Ceiling boards
- Domestic appliances
- Cable ducts
- Shelving components

Product range

Surface appearance:

- **3302A T00**, smooth flowing, matt
 - **3302A U00**, smooth flowing, matt
- Gloss class, DIN EN ISO 2813: 17-23 R'/60°, (Special gloss, not complying with IGP nomenclature).

Shades:

- mainly **white shades**, such as RAL 9001, 9003, 9010 and 9016
- special domestic shades

Powder specification

- Particle size: < 80 µm
- Solids: approx. 99%
- Density, RAL 9010: 1.61 kg/l
- Storage stability: at least 24 months
- Storage temperature: < 25° C

Packing

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



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Processing instructions

Pre-treatment

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

- Aluminium, depending on intended purpose, degreasing or chromatising according to DIN EN ISO 12487
- Steel or galvanised sheet metal, depending on intended purpose, degreasing or Fe-phosphating.

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) can be used for processing. Relevant regulations: VDE requirements and VDM data sheet 24371.

Recycling capacity

Recycled powder should be added in small proportions (automatically, if possible) to the fresh powder and then processed.

Stoving conditions

Temperature and time combination resulting in optimum cross-linking of the coating.

<i>Object temperature</i>	<i>Retention time at object temperature</i>
200°C	8 min.
190°C	10 min.
180°C	15 min.

To obtain optimum stoving conditions, we recommend practical trials each time, adapted to the object in question and the stoving furnace. Our technical service department will be glad to advise you.

Technological values

To obtain the following data, IGP-DURA[®]mix 3302 T00, RAL 9010 white, was coated as follows:

- Galvanised sheet metal 0.8 mm
- Coating thickness 50-60 µm
- Object temperature 190°C, 10 min.

Cross-cut adhesion test, DIN EN ISO 2409	Gt 0
Mandrel bending test, DIN EN ISO 1519	< 5 mm
Impact penetr., ASTM D2794	> 100 kg x cm
Erichsen cupping, DIN EN ISO 1520	> 8 mm
Buchholz hardness, DIN EN ISO 2815	> 80

Bending with sheet metal thickness below 1.5 mm, under an angle of 90° and an inner metal sheet radius of 2.5 mm.

500-1000 h* Condensation water test, DIN EN ISO 6270: no infiltration, no blisters (*depending on preliminary treatment)

500-1000 h* Salt spray test, DIN EN ISO 9227: no infiltration, no blisters (*depending on preliminary treatment)

Long-Term heat resistance: gradual yellowing after 100°C.

Overbaking resistance: 10 min. 180-210°C max. DE 0.3, CIELAB.

Resistance to chemicals
IGP-DURA[®]mix 3302 T00 displays good resistance to many diluted acids and alkaline. Loads from organic solvents are only possible conditionally and for the short term. Resistance should be tested from case to case.

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.



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