



IGP-DURA®*mix* 33

Indoor quality

IGP-DURA®*mix* 33 is a matt, resp. silk matt coating powder on polyester and epoxy resin base, plus the corresponding light and heat resistant pigments.

Technical Data Sheet

Characteristics

- impact resistant, matt surface with excellent flow
- good general resistance properties
- excellent mechanical properties
- high yellowing resistance during stoving

Applications

- Cable ducts
- Ceiling boards
- Domestic appliances
- Office furniture
- Operational equipment
- Radiators
- Railing panels
- Shelving components
- Toilet equipment

Product range

Surface appearance

- **3302A**, smooth flowing, matt
Gloss class DIN EN ISO 2813: 15-25 R'/60°
- **3303A**, smooth flowing, matt
Gloss class DIN EN ISO 2813: 20-35 R'/60°
- **3305A**, smooth flowing, silk-matt
Gloss class DIN EN ISO 2813: 45-55 R'/60°

Also available: Pearl-mica effects, METALLIC®*pearl* and various textures.

Shades

Mainly RAL- and NCS shades, special domestic shades on request.

Powder specifications

- Particle size: < 100 µm
- Solids: approx. 99%
- Density, acc. to shade 1.3-1.6kg/l
- Storage stability: min. 24 months
- Storage temperature: < 25°C

Packaging

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



IGP-DURA[®]mix 33

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 commercial electrostatic systems, both with "corona"- and „tribo charge“.

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 33, RAL 9010 white, was coated as follows:

- Galvanised sheet metal 0.8 mm
- Coating thickness 60-80 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	> 10 kg x cm
Erichsen cupping, DIN EN ISO 1520	>8 mm
Buchholz hardness, DIN EN ISO 2815	> 80

1000 h Condensation water test, DIN EN ISO 6270-2:
No infiltration, no blisters

1000 h Salt spray test, DIN EN ISO 9227:
No infiltration, no blisters

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

Resistance to chemicals

IGP-DURA[®]mix 33 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.

