



## IGP-DURA®*pol* 62

Industrial quality

Weather-resistant, coating system on a saturated polyester resin base, the corresponding hardener plus special heat, light and chalk resistant pigments.

# Technical Data Sheet

### Characteristics

- good light and weather resistance
- impact resistant surface with excellent flow
- good elasticity
- No yellowing with directly heated gas ovens.

### Applications

- Bicycle frames
- Agricultural machines
- Garden and camping furniture
- Housings for automatic devices, switch cabinets
- Lights
- Boilers, radiators
- Ceiling panels
- Household appliances
- Office furniture

### Product range

#### Surface appearances

- **6209A**, smooth, flowing, gloss
- **6209E**, gloss, pearl-mica effect  
Gloss class, DIN EN ISO 2813: > 85 R'/60°
- **621SA**, fine structure, silk-gloss
- **621MA**, fine structure, matt
- **621ME**, fine structure matt with pearl-mica effect
- **622SA**, coarse structure, silk-gloss
- **622SE**, coarse structure, silk-gloss with pearl-mica effect
- **622MA**, coarse structure, matt

#### Shades

Mainly RAL and NCS shades; also special domestic shades by arrangement.

### Powder specification

- Particle size: < 100µm
- Solids: > 99%
- Density according to shade: 1.3 – 1.6 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 bags 20 kg each, capacity 500 kg



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# IGP-DURA®*pol* 62

## Processing instructions

### Pre-treatment

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

For outdoor use, a pre-treatment adapted to the substrate is absolutely imperative:

- Aluminium: Chromatising DIN EN ISO 12487
- Galvanised sheet: likewise 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 which must be processed with Corona charge.

Relevant regulations: VDE requirements and the VDM data sheet 24371.

### Recycling capacity

Small proportions of recycled powder should be added (automatically if possible) to the fresh powder and then processed.

For pearl-mica effects, refer also to processing instruction IGP-PG 201.

### Stoving conditions

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

IGP-DURA®*pol* 6209A/E, 621SA/MA, 622SA/SE

Object-temperature	Retention time at object temperature	
	minimum	maximum
180°C	10 min.	30 min.
190°C	8 min.	20 min.
200°C	5 Min.	10 Min.

IGP-DURA®*pol* 622MA

Object-temperature	Retention time at object temperature	
	minimum	maximum
180°C	10 min.	30 min.
190°C	8 min.	20 min.
200°C	5 Min.	10 Min.

To obtain optimal stoving conditions you are recommended to carry out practical trials each time, adapted to the object in question and the stoving oven. Our technical service department will be glad to advise you.

## Technological values

To obtain the following data IGP-DURA®*pol* 62 was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Coating thickness 60-80 µm
- Object temperature for IGP-DURA®*pol* 6209A/E, 621SA/MA, 622SA/SE 180°C, 10 min.
- Object temperature for IGP-DURA®*pol* 622MA 200°C, 10 min.

Cross-cut adhesion test, DIN EN ISO 2409	Gt 0
Mandrel bending test, DIN EN ISO 1519	< 6 mm
Impact penetr., ASTM D2794	< 10 inchp.
Erichsen cupping, DIN EN ISO 1520	< 5 mm
Buchholz hardness, DIN EN ISO 2815	> 80

Weathering:

Excellent in middle European climate

1000h condensation water test, DIN EN ISO 6270:  
no infiltration, no blisters.

1000h salt spray test, DIN EN ISO 9227:  
no infiltration, no blisters.

### Cleaning

The coated parts are to be cleaned according to the specifications RAL-GZ 632 or SZFF 6101.

For pearl-mica effects, additionally note Technical Information IGP-TI 106.

## 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.

