



IGP-DURA®*pol* 65

Industrial quality

Weather resistant, economical coating system with aligned product attributes on a saturated polyester resin base, declaration-free hardener plus special light, heat and chalk resistant pigments.

Technical Data Sheet

Characteristics

- good light and weather resistance
- impact resistant surface with excellent flow
- good elasticity

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

- **6509A**, smooth flowing, gloss
 - **6509D**, smooth flowing, gloss, metallic
- Gloss class, DIN EN ISO 2813: >85 R'/60°
- **6507A**, smooth flowing, silk gloss
 - **6507D**, smooth flowing, silk gloss, metallic
 - **6507E**, smooth flowing, silk gloss with pearl mica Effect

Gloss class, DIN EN ISO 2813: 65 - 85 R'/60°

Shades

Shades by arrangement.

Powder specification

- Powder specification: < 100 µm
- Solids: > 99%
- Density acc. to shade: 1.3 – 1.7 kg/l
- Storage stability: min. 12 months
- Storage temperature: < 25° C

Packing

- Carton with antistatic PE liner, capacity 20 kg
- Carton container with 25 antistatic PE bags 20 kg each, capacity 500 kg



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 is absolutely necessary:

- Aluminium and zinc-plated steel sheeting: Chromatising DIN 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“ type, with the exception of pearl mica and metallic effects which must be processed only with „corona“ charging.

Relevant regulations: VDE requirements and VDM data sheet 24371.

IGP processing instructions for „Pearl Mica Effects“: VR 201.

Recycling capacity

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.

Object- temperature	Retention time at object temperature	
	minimum	maximum
170°C	20 min.	40 min.
180°C	10 min.	20 min. *
190°C	5 min.	10 min.

Object- temperature	Retention time at object temperature	
	minimum	maximum
170°C	20 min.	40 min.
180°C	15 min.	30 min. *
190°C	10 min.	20 min.

* Recommended curing conditions

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 65** was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Coating thickness 60-80 µm
- Object temperature 180°C, 10 min.

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:

QUV/SE-B-313, DIN EN ISO 11507/ASTM G-53-88:
After 200 h > 50% residual glosses

500h condensation water test, DIN EN ISO 6270-2:
No infiltration, no blisters.

500h 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.

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.