



IGP-DURA®*pox* 08

Low temperature, indoor quality, high gloss



IGP-DURA®*pox* 08 consists largely of epoxy resins and the corresponding hardeners. This highly-reactive epoxy system enables curing temperatures starting at 140°C.

Technical data sheet

Characteristics

- good mechanical properties
- very good resistance to solvents and chemicals
- light shades may tend to yellow under improper curing conditions

Applications

- decorative and functional indoor use
- laboratory devices and equipment
- machine components
- tools
- glass
- plastic
- MDF wood fibre board
- heat-sensitive substrates

Product range

Surface appearance

- **0809A, smooth flowing, gloss**
Gloss class, DIN EN ISO 2813: >85 R'/60°
There are no matte settings available.

Shades

In this quality are only limited colours available.

Powder specification

- Particle size: < 100µm
- Solids: > 99%
- Density based on shade: 1.3 – 1.6 kg/l
- Storage stability: at least 6 months
- Storage temperature: < 25° Celsius

The durability can be extended by continuously lowering the storage temperature.

Packaging

- Carton with antistatic PE bag liner, capacity 20 kg.

Ask about additional packaging materials that are thermally resistant for transport.



IGP-DURA®*pox* 08

Processing instructions

Pre-treatment

The substrate to be covered must be free of oxidation products, scale, oil, fat or release agent residue.

- Aluminium, either de-greasing or chromatising in accordance with DIN EN ISO 12487, depending on intended use.
- Steel or zincor sheet metal, either de-greasing or iron phosphating, depending on intended use

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

Coating equipment

All conventional electrostatic systems, both «corona» and «tribo charging». Regulations to be observed: VDE provisions and VDM information sheet 23471.

Recyclability

Recycled powder should be added in small portions, (automatically, if possible), and mixed with fresh powder. Important: Overspraying should absolutely be kept to a minimum. The temperature should not exceed 25° C.

Compatibility

Problems such as loss of gloss, orange skin, craters, specks, or loss of mechanical properties may be the result of an incompatibility with other coating powders. For this reason, the coating system must be thoroughly cleaned at product changeover.

Stoving conditions

Temperature and time combinations resulting in the optimal cross-linking of the coating.

| <i>Object- Temperature</i> | <i>Retention time at Object temperature</i> |
|--------------------------------|---|
| 140°C | 10 Min. |

For temperatures above 140° C or longer curing times, light shades are likely to yellow. In each case, practical experiments adapted to the particular object and curing oven are recommended in order to determine the best possible curing conditions. Our technical customer service would be happy to advise you.

Technological values

To obtain the following data IGP-DURA®*pox* 08 was coated as follows:

- Fe sheet, 0,8mm
- Coating thickness 60-80 µm
- Object temperatures 140°C, 10 min.

| | |
|-----------------------------------|--------|
| Cross-cut adhesion test, ISO 2409 | GT 0 |
| mandrel bending test | < 5 mm |
| Impact penetration, ASTM D2794 | 2,5 Nm |
| Erichsen cupping, ISO 1520 | > 1 mm |
| Buchholz hardness, ISO 2815 | > 80 |

500 - 1000h* water condensate test, EN ISO 6270 : no infiltration, no blisters. (*based on pre-treatment)

500-1000h* salt spray test, DIN 50021: no infiltration, no blisters. (*based on pre-treatment)

Resistance to chemicals:

IGP-DURA®*pox* 08 shows good resistance to many diluted acids and alkaline solutions, machine and drilling oils, as well as many solvents.

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.

