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IGP Powder Coatings

TDS IGP-DURA®pol 6809A-A0|240424|v1.3

This application-related advice is given to the best of our knowledge. However, this information is non-obligatory and does not exempt you from carrying out your own tests. Application, use and processing of these products are beyond our control and are therefore on your responsibility.

Consult the Safety Data Sheet prior to use. Article-specific safety data sheet and comprehensive risk management measures available at: **igp-powder.com**

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Technical data sheet

IGP-DURA®*pol* 6809A-A0

High gloss, low-temperature powder coating with a smooth finish, ideal for interior and exterior applications.



Characteristics

- Gloss
- Smooth finish
- Uni colors
- Industrial outdoor quality



Powder properties

Particle size:

Solids:

Density:

Suitability for storage:

< 3.94 mil
> 99 %
10.85 lb/gal-13.35 lb/gal
min. 18 months at ≤ 77 °F
in an unopened original container
Color tones:
RAL and NCS-S shades, individual colors on request



Processing

Pre-treatment

The substrate must be free from oil, grease and oxidation products. The pretreatment depends on the type of substrate and the corrosion protection to be achieved. We recommend the following pretreatments:

Aluminum

- Chromating according to DIN EN 12487
- Pre-anodization
- Chrome-free pretreatment according to GSB International and QUALICOAT specifications

Steel

- Zinc phosphating

Galvanized steel

- Zinc phosphating
- Chrome (III) passivation
- Chromating according to DIN EN 12487

For improved corrosion protection for applications on steel / galvanized steel, the use of corrosion protection primer IGP-KORROPRIMER 18 is recommended. The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. The minimum requirement for aluminum substrates / galvanized steel components is to carry out a boiling water test with a subsequent cross-cut adhesion and tape test. We refer to the guidelines of the GSB International, Qualicoat and Qualisteelcoat certifications. For further information: see also our special leaflet on pre-treatment (IGP-TI 100).

Coating devices

All commercially available electrostatic systems, both corona and tribo charge systems. For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

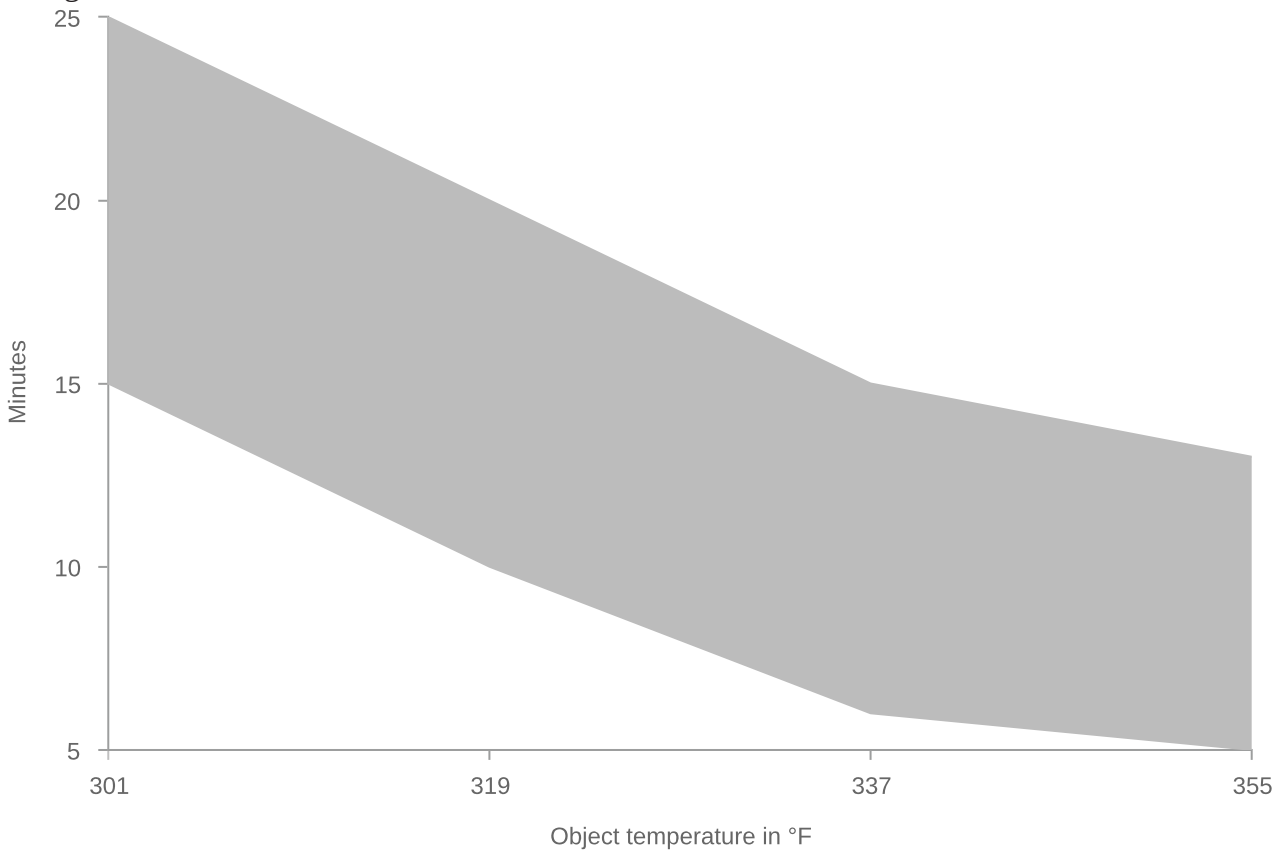
Recommended film thickness

2.36 mil - 3.15 mil

A homogeneous coating result with textured coatings or article- and color-specific differences in hiding power may require higher coating thicknesses. The corresponding processing guidelines

must be observed. For a pre-calculation of the required powder coating quantity, the necessary coating thickness must be determined for each article.

Curing conditions



T Object	t min	t max
302 °F	15 minutes	25 minutes
320 °F	10 minutes	20 minutes
338 °F	6 minutes	15 minutes
356 °F	5 minutes	13 minutes

In order to determine ideal curing conditions, we recommend practical trials with the object in question and curing oven.

Reclaimability

Small portions of recycled powder can be added, automatically if possible, to the fresh powder.

Important: Keep overspray to an absolute minimum.



Film properties

Tested on

Substrate:

Aluminum (AlMg1), 0.8 mm, chromated

Film thickness:

2.36 mil - 3.15 mil

Object temperature:

320 °F, 10 min.
Appearance
Gloss level
85-100 R'/60°
DIN EN ISO 2813 2015-02
Mechanical tests
Cross-cut adhesion test
Gt 0
DIN EN ISO 2409 2020-12
Mandrel bending test
≤ 5 mm
DIN EN ISO 1519 2011
Impact test
≥ 20 inchp.
ASTM D 2794 1993
Erichsen cupping
≥ 5 mm
DIN EN ISO 1520 2007-11
Buchholz hardness
≥ 80
DIN EN ISO 2815 2003-10
Weathering tests
QUV-SE-B-313, 200h
> 50 % residual gloss
DIN EN ISO 16474-3 2014-03
Corrosion tests
Condensation water test, 1000h
No infiltration, no blisters
DIN EN ISO 6270-2 2018-04
Natural salt spray test, 1000h
No infiltration, no blisters
DIN EN ISO 9227 2017-07



More information

Cleaning

The coated parts must be cleaned according to the directives RAL-GZ 632 or SZFF 61.01.

Paint removal and disposal

After use, coated goods should be supplied to the normal recycling process. The disposal methods for sludges or residual powders must be observed in accordance with the local official provisions whilst taking Waste Code “080201 Coating Powder Wastes” in accordance with the European Waste Catalogue into consideration.