IGP Powder Coatings
TDS IGP-DURA®pox 0201A-A0|240424|v1.3

Technical data sheet

IGP-DURA®*pox* 0201A-A0

Deep-matt epoxy powder coating with a very smooth finish and high resistance to chemicals for interior applications.

Characteristics

- Deep matte
- Smooth finish
- Uni colors
- Indoor quality
- Chemical resistant

Powder properties

Particle size:
Solids:
Density:

Suitability for storage:
< 3.94 mil
> 99 %
10.85 lb/gal-13.35 lb/gal
min. 12 months at ≤ 77 °F
in an unopened original container
Color tones:
RAL and NCS-S shades, individual colors on request; due to yellowing pale colors are not possible

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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

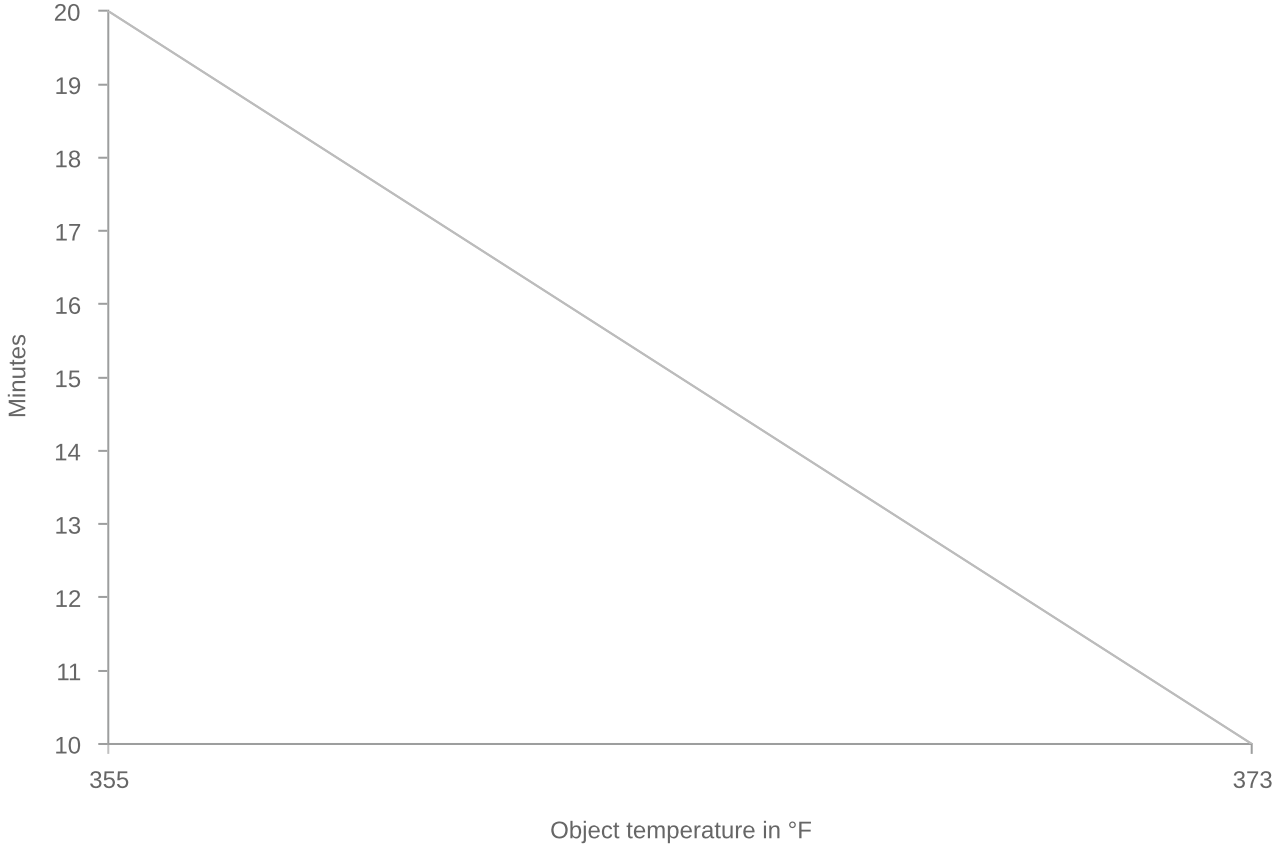
- Zinc phosphating
- Iron phospating

Galvanized steel

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

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}
356 °F	20 minutes	20 minutes
374 °F	10 minutes	10 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:
Steel, 0.5 mm
Film thickness:
2.36 mil - 3.15 mil
Object temperature:
374 °F, 10 min.
Appearance

Gloss level
0-15 R’/60°
DIN EN ISO 2813 2015-02
Mechanical tests
Cross-cut adhesion test
Gt 0
DIN EN ISO 2409 2020-12
Impact test
≤ 10 inchp.
ASTM D 2794 1993
Erichsen cupping
≥ 1 mm
DIN EN ISO 1520 2007-11
Buchholz hardness
≥ 80
DIN EN ISO 2815 2003-10
Corrosion tests
Condensation water test, 500-1000h*
No infiltration, no blisters. *depending on pretreatment
DIN EN ISO 6270-2 2018-04
Natural salt spray test, 500-1000h
No infiltration, no blisters. *depending on pretreatment.
DIN EN ISO 9227 2017-07
Chemical tests
Acids and alkalis
Very good resistance to many dilute acids and alkalis.
Organic solvents
Outstanding resistance to organic solvents
Additional properties
Continuous heat resistance
> 120°C allmähliche Vergilbung

More information

Packaging
20 kg cardboard box with inserted antistatic PE liner
500 kg cardboard container with 25 antistatic PE-liners each 20kg
Protection of coated parts
Coated parts should be packed after cooling with suitable materials without plasticizers. They should be stored protected from the weather to avoid the formation of condensation and thus water spots on the coating.
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.