





Technical data sheet

IGP-HWFclassic 5907A-S1

Super durable, smooth and silk gloss powder coating based on saturated polyester and a declaration-free hardener, which offers good robustness.



Characteristics

- Silk gloss
- Smooth flow
- Uni colours
- Super durable facade quality,3 years Florida > 50% residual gloss
- Increased scratch resistance
- Clean effect



Material approvals

- Qualicoat Nr. P-1535, class 2
- GSB 173 z Florida 3
- AAMA 2604-13, independent test report







Powder properties

Particle size: $< 100 \,\mu m$ Solids: $> 99 \,\%$

Density: 1.3 kg/l-1.6 kg/l

Suitability for storage: min. 24 months at \leq 25 °C

in an unopened original container

Color tones: Due to the limited volume of highly weather-resistant pigments, the

product portfolio only has a small amount of different shades in

accordance with the special IGP colour range.



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:

Aluminium

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

Steel

Zinc phosphating

Galvanised steel

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

For improved corrosion protection for applications on steel / galvanised steel, the use of corrosion protection primer IGP-KORROPRIMER 10 or IGP-KORROPRIMER 60 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 aluminium substrates / galvanised 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 conventional electrostatic systems with corona charging.

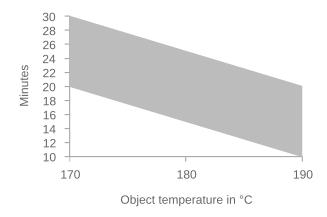
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

Recommended film thickness

60 μm - 80 μm

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}
170 °C	20 minutes	30 minutes
180 °C	15 minutes	25 minutes
190 °C	10 minutes	20 minutes

In order to determine ideal curing conditions, we recommend practical trials with the respective object 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 chrom-free

Tested colours: RAL 9010, 5010, 3005

Film thickness: $60 \, \mu m - 80 \, \mu m$ Object temperature: $180 \, ^{\circ}\text{C}$, 15 min.

Appearance

Gloss level 65-85 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 / Tapetest ≤ 5 mm DIN EN ISO 1519 2011 Impact test / Tape test ≥ 20 inchp. ASTM D 2794 1993 Erichsen cupping / Tape Test ≥ 5 mm DIN EN ISO 1520 2007-11 **Buchholz hardness** ≥ 80 DIN EN ISO 2815 2003-10 Robustness according to ≥ 50 % IGP AA341.62 Martindale, residual gloss_50%

Weathering

 3 years Florida, 5° south
 > 50 % residual gloss
 DIN EN ISO 2810 2021-01

 Xenon-arc lamps, 1000h, 90%
 > 90 % residual gloss
 DIN EN ISO 16474-2 2014-03

 QUV-SE-B-313, 600h
 > 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 Acetic acid salt spray test, 1000h No infiltration, no blisters DIN EN ISO 9227 2017-07

Chemical tests

Mortar resistance Easily removable after 24h with ASTM D 3260 2001 no residues.



Further information

Packaging

20 kg cardboard box with inserted antistatic PE liner

Overcoating

Preliminary tests are mandatory for overcoating painted surfaces.

Printing and glueing

Preliminary tests are mandatory for printing and glueing of painted surfaces.

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.

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**