





Technical data sheet

# **IGP-HWFsuperior 571TA-R1**

Deep-matt powder coating with a fine texture and outstanding weathering stability, based on saturated polyester and a declaration-free hardener.



## **Characteristics**

- Deep matte
- Fine texture
- Uni colours
- Super durable facade quality,
   5 years Florida > 50% residual gloss
- More robust and pliable
- Clean effect



## Material approvals

- Qualicoat Nr. P-1856, class 2
- GSB 173 f Florida 5
- 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.

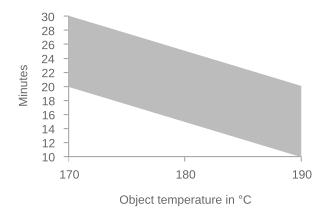
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

## 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 <sub>min</sub>	t <sub>max</sub>
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 (AIMg1), 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 2-12 R'/60° DIN EN ISO 2813 2015-02

#### Mechanical tests

Cross-cut adhesion testGt 0DIN EN ISO 2409 2020-12Mandrel bending test / Tapetest≤ 5 mmDIN EN ISO 1519 2011Impact test / Tape test≥ 20 inchp.ASTM D 2794 1993Erichsen cupping / Tape Test≥ 5 mmDIN EN ISO 1520 2007-11Buchholz hardness≥ 80DIN EN ISO 2815 2003-10

## Weathering

 5 years Florida, 5° south
 > 50 % residual gloss

 Xenon-arc lamps, 1000h, 90%
 > 90 % residual gloss

 QUV-SE-B-313, 1000h
 > 50 % residual gloss

 DIN EN ISO 16474-2 2014-03

 DIN EN ISO 16474-3 2014-03

#### **Corrosion tests**

Acetic acid salt spray test, 1000h

No infiltration, no blisters

DIN EN ISO 9227 2017-07

Condensation water test, 1000h

No infiltration, no blisters

DIN EN ISO 6270-2 2018-04

## **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 nonobligatory 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