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IGP Powder Coatings

TDS IGP-RAPID®primer 134SA-A1|240424|v1.4

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-RAPID®*primer* 134SA-A1

Highly reactive primer that optimally prepares MDF substrates for finishing with IGP-RAPID®top.



Characteristics

- Silk gloss
- Var. fine texture
- Uni colours
- Indoor quality



Powder properties

Particle size:

Solids:

Density:

Suitability for storage:

< 100 µm

> 99 %
1.2 kg/l-1.6 kg/l
min. 6 months at $\leq 15\text{ }^{\circ}\text{C}$
min. 6 months at $\leq 15\text{ }^{\circ}\text{C}$
in an unopened original container
Color tones:
ca. RAL 7035



Processing

Pre-treatment

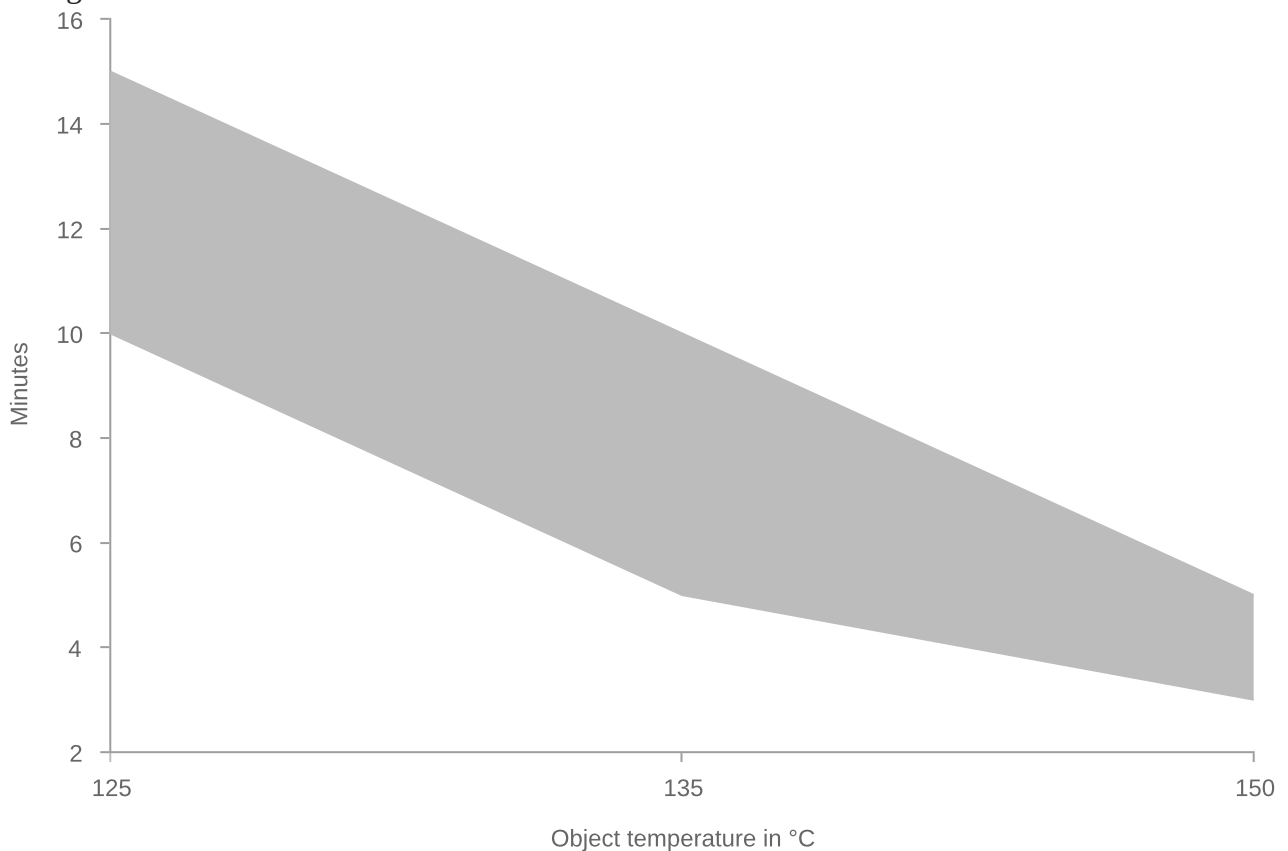
If the surface finish of the MDF ex-works does not meet the quality requirements of the end product, the surface has to be sanded. This will ensure that the material has an evenly smooth surface and is free of any contaminants, minor scratches, dust, grease, etc. For more information, see IGP-TI 111.

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.

Curing conditions



T Object	t min	t max
125 $^{\circ}\text{C}$	10 minutes	15 minutes
135 $^{\circ}\text{C}$	5 minutes	10 minutes

T Object **t** min **t** max
150 °C 3 minutes 5 minutes

Due to the limited thermal conductivity, the use of infrared- (electric / gas catalytic) or convectional - infrared combined ovens is recommended.

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

The curing conditions must be carefully controlled. Powder coatings cured outside the curing window may show deficiencies in the film flexibility. Our technical customer service will advise you.

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:

EGGER MBP-L 25mm

Tested setting:

Tested with 381M with a total film thickness > 160µm

Object temperature:

135 °C, 5 min.

Mechanical tests

Hinge Hole Test

≤ 1.1

IGP AA341.54

Chemical tests

Acetone test

2N Level 2

IGP AA341.58



Further information

Packaging

20 kg cardboard box with inserted antistatic PE liner

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.