



IGP-DURA®*mix* 31

Indoor quality, silk gloss, gloss



IGP-DURA®*mix* 31 comprises essentially polyester and epoxy resins, plus the corresponding light and heat resistant pigments. They are used in the decorative indoor domain. This reactive polyester-epoxid system allows stoving temperatures from 160°C.

Technical Data Sheet

Characteristics

- impact resistant surface with excellent flow
- good elasticity
- good general resistance values

Applications

- Factory equipment
- Parapet or balustrade cladding
- Office furniture
- Ceiling panels
- Household appliances
- Radiators
- Cable ducts
- Shelving components
- Toilet fixtures and fittings

Product range

Surface appearance:

- **3109A**, smooth flowing, glossy
gloss class, DIN EN ISO 2813 :
> 85 R' / 60°
- **3107A**, smooth flowing, silk gloss
gloss class, DIN EN ISO 2813:
75 R' +/- 10EH / 60°

Also available are different surface appearances such as: textured, metallic and pearl mica effects, also transparent qualities.

Shades:

Mainly RAL and NCS shades; also special domestic shades by arrangement.

Powder specification

- Particle size: < 100 µm
- Solids: ca. 99%
- Density according to shade: 1.3 – 1.6 kg/l
- Storage stability: 24 months
- Storage temperature: < 25° C

Packing

- Carton with antistatic PE liner, capacity 20 kg, excluding transparent and certain metallic shades: 15 kg.
- Carton container 25 antistatic PE liners, capacity 500 kg or 400 kg.

Safety Datasheet: SD 010



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IGP-DURA[®]mix 31

Processing instructions

Pre-treatment

The substrate must be free of oxidation products, scale, oil, grease or mould-release residues.

- Aluminium, according to intended purpose, degreasing or chromatising according to DIN EN ISO 12487
- Steel or galvanised sheet, according to intended purpose, degreasing or Fe-phosphating

For further information: see also our special leaflet on pre-treatments (IGP-TI 100).

Coating equipment

All commercially available electrostatic systems (both corona and tribo-charge) can be used for processing. Exceptions are pearl mica and metallic effects which can only be processed with "corona charge".

Relevant regulations: VDE requirements and the VDM data sheet 24371.

Recycling capacity

Small proportions of recycled powder should be added (automatically if possible) to the fresh powder and then processed.

For pearl mica- and metallic effects, refer also to processing instruction PG-201.

Stoving conditions

Given are the temperature and time combinations which result in optimal cross-linking of the coating.

<i>Object temperature</i>	<i>Retention time at object temperature</i>
190°C	5 min.
180°C	7 min.
160°C	10 min.

To obtain optimal stoving conditions you are recommended to carry out practical trials each time, adapted to the object in question and the stoving oven. Our technical service department will be glad to advise you.

Technological values

To obtain the following data IGP-DURA[®]mix 31 was applied as follows:

- Steel sheet 0,8 mm
- Coating thickness 60-80 µm
- Object temperatures 160°C, 10 min.

Cross-cut adhesion test, DIN EN ISO 2409	Gt 0
Mandrel bending test, DIN EN ISO 1519	< 5 mm
Impact penetr., ASTM D2794	> 10 kg x cm
Erichsen cupping, DIN EN ISO 1520	> 5 mm
Buchholz hardness, DIN EN ISO 2815	> 80

500-1000 h* Condensation water test, DIN EN ISO 6270-2: no infiltration, no blisters
(*depending on preliminary treatment)

500-1000 h* Salt spray test, DIN EN ISO 9227: no infiltration, no blisters
(*depending on preliminary treatment)

Long-Term heat resistance:
gradual yellowing after 120°C.

Resistance to chemicals:
IGP-DURA[®]mix 31 displayed good resistance to many diluted acids and alkalis.

Loads from organic solvents are only possible conditionally and for the short term.

Resistance should be investigated for the case in question.

Note

Our technical advice on application, given verbally, in writing and through trials is provided to the best of our knowledge but is to be regarded solely as non-binding information and does not release you from the need to carry out your own tests and trials.

Application, use and processing of the products take place outside our ability to supervise and are therefore exclusively your own responsibility.

