



IGP-DURA®*pol* 64

Industrial quality

Weather resistant coating system on a saturated polyester resin base, declaration-free hardener plus special light, heat and chalk resistant pigments.

Technical Data Sheet

Characteristics

- good light and weather resistance
- impact resistant surface with excellent flow
- good elasticity etc.
- No yellowing with directly heated gas ovens.

Applications

- Bicycle frames
- Agricultural machines
- Garden and camping furniture
- Housings for automatic devices, switch cabinets
- Lights
- Boilers, radiators
- Ceiling panels
- Household appliances
- Office furniture

Product range

Surface appearances

- **6409A**, smooth flowing, gloss
Gloss class, DIN EN ISO 2813: > 85 R'/60°
- **6409D**, smooth flowing, gloss, metallic
Gloss class, DIN EN ISO 2813: > 85 R'/60°
- **6407A**, smooth flowing, silk gloss
Gloss class, DIN EN ISO 2813: 65-85 R'/60°
- **6407D**, smooth flowing, silk gloss, metallic
Gloss class, DIN EN ISO 2813: 65-85 R'/60°
- **6407E**, smooth flowing, silk gloss, pearl mica
Gloss class, DIN EN ISO 2813: 65-85 R'/60°
- **6405A**, smooth flowing, silk-matt
Gloss class, DIN EN ISO 2813: 45-55 R'/60°

- **6403A**, smooth flowing, matt
Gloss class, DIN EN ISO 2813: 25-35 R'/60°
- **6403D**, smooth flowing, matt, metallic
Gloss class, DIN EN ISO 2813: 25-35 R'/60°
- **6403E**, smooth flowing, matt, pearl mica
Gloss class, DIN EN ISO 2813: 25-35 R'/60°
- **6402A**, smooth flowing, matt
Gloss class, DIN EN ISO 2813: 15-25 R'/60°
- **644MA**, fine structure, matt

Shades

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

Powder specification

- Particle size: < 100µm
- Solids: > 98%
- Density acc. to shade: 1.3 – 1.6 kg/l
- Storage stability: min. 12 months
- Storage temperature: < 25° Celsius

Packing

- Carton with antistatic PE liner, capacity 20 kg.
- Carton container with 20 antistatic PE liners for 20 kg each, capacity 500 kg



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Safety Data Sheet: SD 010
Safety Data Sheet SD 120 is applicable for
IGP-DURA®*pol* products 6402 and 644MA.

IGP-DURA[®]pol 64

Processing instructions

Pre-treatment

The substrate to be coated must be free of oxidants, cinder, oil, grease, stripping agents and other residues. For exterior use, pre-treatment matching the substrate is absolutely necessary:

- Aluminium and zinc-plated steel sheeting: Chromatising DIN EN ISO 12487.
- Steel: zinc or Fe-phosphating, additionally coated with **IGP Korroprimer 10**.

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

Coating equipment

All commercially available electrostatic systems, Both Corona and Tribo charge systems. Exceptions are pearl-mica-, metallic effects and 6403 + 644MA which must 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 to the fresh powder, where possibly automatically. Important:

Overspray should in all cases be kept as low as possible.

Stoving conditions

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

IGP-DURA[®]pol 6409A and D / 6407A, D and E / 6405A / 6403A, D and E

Object-temperature	Retention time at object temperature	
	minimum	maximum
170°C	15 min.	30 min.
180°C	10 min.	20 min.
190°C	8 min.	15 min.

IGP-DURA[®]pol 6402A / IGP-DURA[®]pol 644MA

Object-temperature	Retention time at object temperature	
	minimum	maximum
180°C	30 min.	40 min.
190°C	15 min.	30 min.
200°C	10 min.	20 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[®]pol 64 was applied as follows:

- Aluminium sheet (AlMg1) 0.8 mm, chromatised
- Coating thickness 60-80 µm
- Object temperature 10 min., 180°C, rep. 15 min., 190°C

Gloss glass, DIN EN ISO 2813	
IGP-DURA [®] pol 6409A and D	> 85 R`/60°
IGP-DURA [®] pol 6407A, D and E	65-85 R`/60°
IGP-DURA [®] pol 6405A	45-55 R`/60°
IGP-DURA [®] pol 6403A, D and E	25-35 R`/60°
IGP-DURA [®] pol 6402A	15-25 R`/60°
IGP-DURA [®] pol 644MA	matt

Cross-cut adhesion test, DIN EN ISO 2409	Gt 0
Mandrel bending test, DIN EN ISO 1519	< 5 mm
Impact penetr. ASTM D2794	> 20 inchp.
Erichsen cupping, DIN EN ISO 1520	> 5 mm
Buchholz hardness, DIN EN ISO 2815	> 80

Accelerated weathering-test

QUV/SE-B-313, DIN EN ISO 11507/ASTM G-53-88: after 200h > 50% residual gloss

1000h condensation water test, DIN EN ISO 6270-2: No infiltration, no blisters.

1000h salt spray test, DIN EN ISO 9227: No infiltration, no blisters.

Cleaning

The coated parts are to be cleaned according to the specifications RAL-GZ 632 or SZFF 6101. For pearl-mica effects, additionally note Technical Information IGP-TI 106.

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.

