



IGP-KORROPRIMER 30

Priming powder for chromatised aluminium



Basically speaking, IGP-Korroprimer 30 consists of polyester and epoxy resins, the corresponding hardener, as well as the corresponding light, heat, and chemical-resistant and anti-corrosive pigments. IGP anti-corrosive primers are free of toxic substances.

Technical Data Sheet

Properties

IGP-Korroprimer 30 is corrosion-retarding with excellent mechanical properties. IGP powder coatings as well as water and solvent-based coating lacquers are ideal for top coats.

Application

Priming of chromatised aluminium
(DIN 50939).

In the event of chrome-free pre-treatment, additional tests may be necessary.

Range

Surface aspects/colours

- **3002A**, smooth finish, mat
Traffic grey, RAL 7042.

Powder specification

- Particle size: < 100 µm
- Solids: approx. 99 %
- Density: approx. 1.5–1.6 kg/l
- Storage stability: at least 12 months
- Storage temperature: < 25°C

Packing

- Carton with inserted antistatic PE liner, capacity 25 kg.
- Carton container with 20 antistatic PE liners, each of 25kg; capacity 500 kg.



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IGP-KORROPRIMER 30

Processing instructions

Pre-treatment

The substrate must be free of oxidation products, oil, grease or mould release residues. Multistage chromatising in accordance with DIN 50939 has proved successful for aluminium. For further information: see also our special fact sheet on pre-treatments (IGP-TI 100).

«Coating equipment

IGP-Korroprimer 30 can be processed with all commercially available electrostatic systems (both corona and tribo-charge). Relevant regulations: VDE requirements and the VDM data sheet 24371.

Recycling capability

Recycled powder should be added in small amounts (if possible automatically) to the fresh powder and mixed in thoroughly.

Stoving conditions

Here below are the temperature and time combinations that provide sufficient cross-linking for successful overcoating.

A complete cross-linking of the primer occurs after overcoating.

Object temperature	Retention time at object temperature	
	minimal	maximal
190°C	8 min.	15 min.
180°C	10 min.	20 min.
170°C	20 min.	30 min.

Processing information

The above-mentioned curing conditions must be followed/complied with in order to avoid intercoat adhesion problems between primer and top-coat resulting from too high curing temperatures (max. oven setting of 210°C). When curing in directly heated gas ovens, a preliminary trial is necessary as a matter of priority on account of the intermediate bonding of the top coat; please contact our technical serve department. 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-Korroprimer 30 was applied as follows:

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

Buchholz hardness, ISO 2815:	> 80
Mandrel bending test, ISO 1519:	≤ 6 mm
Erichsen cupping, ISO 1520:	≤ 5 mm
Cross-cut adhesion test, ISO 2409:	GT 0
Impact penetration, ASTM 2794:	> 2.5 Nm

The results of the corrosion protection tests on the powder coating system **IGP-Korroprimer 30** as a primer powder and with **IGP-DURA[®]face 5807** as a top coat, coated on aluminium sheets (AlMg1) 0.8 mm, chromatised and with a total layer thickness of approx. 140 µm. Stoving conditions acc. to technical data sheets.

Buchholz hardness, DIN EN ISO 2815:	> 80
Mandrel bending test, DIN EN ISO 1519:	≤ 6 mm
Erichsen cupping, DIN EN ISO 1520:	> 5 mm
Cross-cut adhesion test, DIN EN ISO 2409:	GT 0
Impact penetration, ASTM 2794:	> 2.5 Nm

2000h Water condensate constant climate test, EN ISO 6270-2: infiltration < 1 mm, no blisters.

Water condensate exposure test with SO₂, DIN EN ISO 3231, after 30 cycles: infiltration < 1 mm, no blisters.

2000h salt spray test NSS and ESS, ISO 9227: infiltration < 1 mm, evaluation acc. to DIN EN ISO 4628-8.

2000h filiform corrosion test, DIN EN 3665: F < 0.4. Sawing, milling, and drilling: corresponds to GSB international requirements.

Notes

Our application-related consulting given verbally, in writing and through trials is provided to the best of our knowledge and belief 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 of our ability to supervise and are therefore exclusively your own responsibility.

