

# IGP-DURA<sup>®</sup>*xal* – TECHNOLOGICAL SPECIFICATIONS

## Excerpt from tested product features

General material characteristics / application range	
Line	Application
IGP-DURA <sup>®</sup> <i>xal</i> , 42 Material approval: Qualicoat N°, P-1164, class 2	Powder coating for highly weather-resistant architectural applications with extremely high color and weather fastness. Suitable for components in architectural, infrastructure and nautical applications with high demands to appearance and UV resistance.
IGP-DURA <sup>®</sup> <i>xal</i> , 46 Weather-proof standard without special authorisation	Powder coating for weather-proof industrial applications. Homogenous light reflection and high covering power. Suitable for industry products with highly decorative requirements such as light housings, displays, sport equipments, electronic and communication devices.
Visual impression	Both ranges of products provide outstanding flow properties, allowing a perfect coating of edges without disturbing "picture frame effects", thus creating a smooth, deep-matt surface aspect.
Workability	Easy application, 60 kV–80 kV max.; good penetration depth, suitable for vertical systems (not suitable for Tribo application).
Recycling	A fluid reservoir is recommended with fresh powder addition, fresh powder ratio should not be less than 75 %.
Color change	Compatibility with other products, no contamination.
Cleaning	Easy to clean due to the high degree of cross-linking, low porosity and high density. Resistance against neutral cleaning agents.

Material data		
Properties	Norm, testing	Result
Gloss level	DIN EN ISO 2813	< 12R' / 60 °C at object temperature ≥ 200 °C / 10 min.
Coating thickness	DIN EN ISO 2178	Depending on covering power and shade, min. > 60 µm
Density		1.2–1.6 kg / l
Consumption		125 g / m <sup>2</sup> ± 10 g at approx. 80 µm, depending on shade
Cross-cut adhesion test	DIN EN ISO 2409	Gt 0
Impact penetration	DIN EN ISO 6272	> 2.5 Nm, tape test
Erichsen cupping	DIN EN ISO 1520	> 5 mm, tape test
Buchholz hardness	DIN EN ISO 2815	> 80
Water condensate constant	DIN EN ISO 6270-2 CH	1000 h, no infiltration, no blisters
ESS salt spray test	DIN EN ISO 9227 AASS	1000 h, no infiltration, no blisters
Moisture resistance	GSB testing procedure 9.17	L: < 4, valid for the IGP-DURA <sup>®</sup> <i>xal</i> 4201 product quality
Mortar resistance	DIN EN ISO 12206-1 (sect. 5.9)	24 h, residue-free removal

The technological properties were measured at a coating thickness of 60–85 µm on chromatised aluminium 0,8 mm aluminium sheet. Test sheets were stored for 10 min. at 200 °C object temperature. Result deviations due to different curing temperatures cannot be precluded.

For application on extruded, rolled or cast metals and/or non-ferrous metals, and pre-anodised aluminium alloys.

Possible substrates and pre-treatments	
Substrates	Pre-treatment
Aluminium	With chrome content (DIN EN 12487) or chrome-free pre-treatment: a pre-sampling is recommended for chrome-free PT and with pre-anodisation as well as the observance of the certification regulations.
Steel	Suitable zinc phosphating alternatively: blasting at SA 2 ½, priming with IGP-KORROPRIMER 10 (anti-corrosive primer).
Galvanised steel	Chromatising in accordance with GSB regulations or appropriate zinc phosphating, alternatively: sweep and prime with IGP-KORROPRIMER 10.
Casting or other	Pre-treatment should be determined on a case-by-case basis.

## GROUP COMPANIES

**Austria**  
IGP Pulvertechnik GesmbH  
Wienerstrasse 99  
AT-2514 Traiskirchen  
Phone +43 (0)2252 508046  
Fax +43 (0)2252 508046 14  
verkauf@igpulver.at

**Benelux**  
IGP Benelux BV  
Rietveldstraat 18  
NL-8013 RW Zwolle  
Phone +31 38 4600695  
Fax +31 38 4600696  
info@igpbenelux.nl  
www.igpbenelux.nl

**France**  
IGP Pulvertechnik SAS  
Bâtiment Europa 1 – BP 70615  
362 avenue Marie Curie  
Archamps Technopole  
FR-74166 St Julien en Genevois Cedex  
Phone +33 (0)4 50 95 35 10  
Fax +33 (0)4 50 95 30 15  
ig.poudre@wanadoo.fr

**Germany**  
IGP Pulvertechnik Deutschland GmbH  
Dieselstrasse 7, DE-84030 Landshut  
Postfach 1565, DE-84003 Landshut  
Phone +49 (0)871 7609 430  
Fax +49 (0)871 7609 470  
verkauf@ig-pulver.de

**Scandinavia**  
IGP Scandinavia AB  
Drottensgatan 2  
SE-222 23 Lund  
Phone +46 46 120 220  
info.se@igp-powder.com

**Italy**  
IGP Market Manager  
Massimiliano Stanganelli  
Mobile +39 327 38 70 168  
massimiliano.stanganelli@igp.ch



## POWDER COATINGS.

IGP Pulvertechnik AG  
Ringstrasse 30  
9500 Wil  
Switzerland  
Phone +41 (0)71 929 81 11  
Fax +41 (0)71 929 81 81  
www.igp.ch, info@igp.ch

A member of the DOLD GROUP

**Great Britain**  
IGP UK  
Fromeforde House  
Church Road, Yate  
GB-Bristol, BS37 5JB  
Phone +44 (0)1454 800 0075  
Fax +44 (0)1454 318 072  
enquiries@igpuk.com

**Hungary**  
IGP Hungary Kft.  
Bercsényi M. u. 14.  
HU-6000 Kecskemét  
Phone +36 76 507 974  
Fax +36 76 507 975  
info@igphungary.hu  
www.igphungary.hu

**North America**  
IGP North America LLC  
Mobile +01 502 939 5606  
info.us@igp-powder.com

**Poland**  
IGP Pulvertechnik Polska Sp. z o.o.  
ul. Ł. kowa 3  
PL-05-822 Milanówek  
Phone +48 22 724 94 49  
Phone/Fax +48 22 758 31 83  
Fax +48 22 758 37 98  
igp@igp.pl  
www.igp.pl

**Turkey**  
Altinboy Ltd.  
Perpa Is Merkezi A blok Kat: 6 No: 526  
TR-34384 Okmeydanı-Sisli, Istanbul  
Phone +90 212 222 87 01  
Fax +90 212 222 67 92  
omer@altinboy.com.tr  
www.altinboy.com.tr

## DISTRIBUTION PARTNERS

**Bulgaria**  
Ultracoating Ltd  
Galileo Galilei Bl. 251 Vh. G  
BG-1113 Sofia  
Phone +359 2 490 0075  
Fax +359 2 870 6349  
ultracoating@abv.bg

**Czech Republic/Slovakia**  
OK Color spol. s.r.o.  
F.V. Veselého 2760  
CZ-193 00 Praha 9  
Phone +420 283 881 252  
Fax +420 286 891 097  
praha@okcolor.cz

**Romania**  
S.C. Paint Art S.R.L.  
Str. Gorjului nr. 5, sc. C, ap. 26  
RO-550063 Sibiu  
Phone +40 (0)269 21 49 15  
Fax +40 (0)269 21 49 15  
office@paintart.ro  
www.paintart.ro

**Russia**  
Industrial coating systems «KSK»  
Lubertsy, ul. Krasnaya, 4  
140000 Moscow Region  
Phone/Fax +7 (495) 232 64 42  
www.ksk-systems.ru

**Turkey**  
Altinboy Ltd.  
Perpa Is Merkezi A blok Kat: 6 No: 526  
TR-34384 Okmeydanı-Sisli, Istanbul  
Phone +90 212 222 87 01  
Fax +90 212 222 67 92  
omer@altinboy.com.tr  
www.altinboy.com.tr

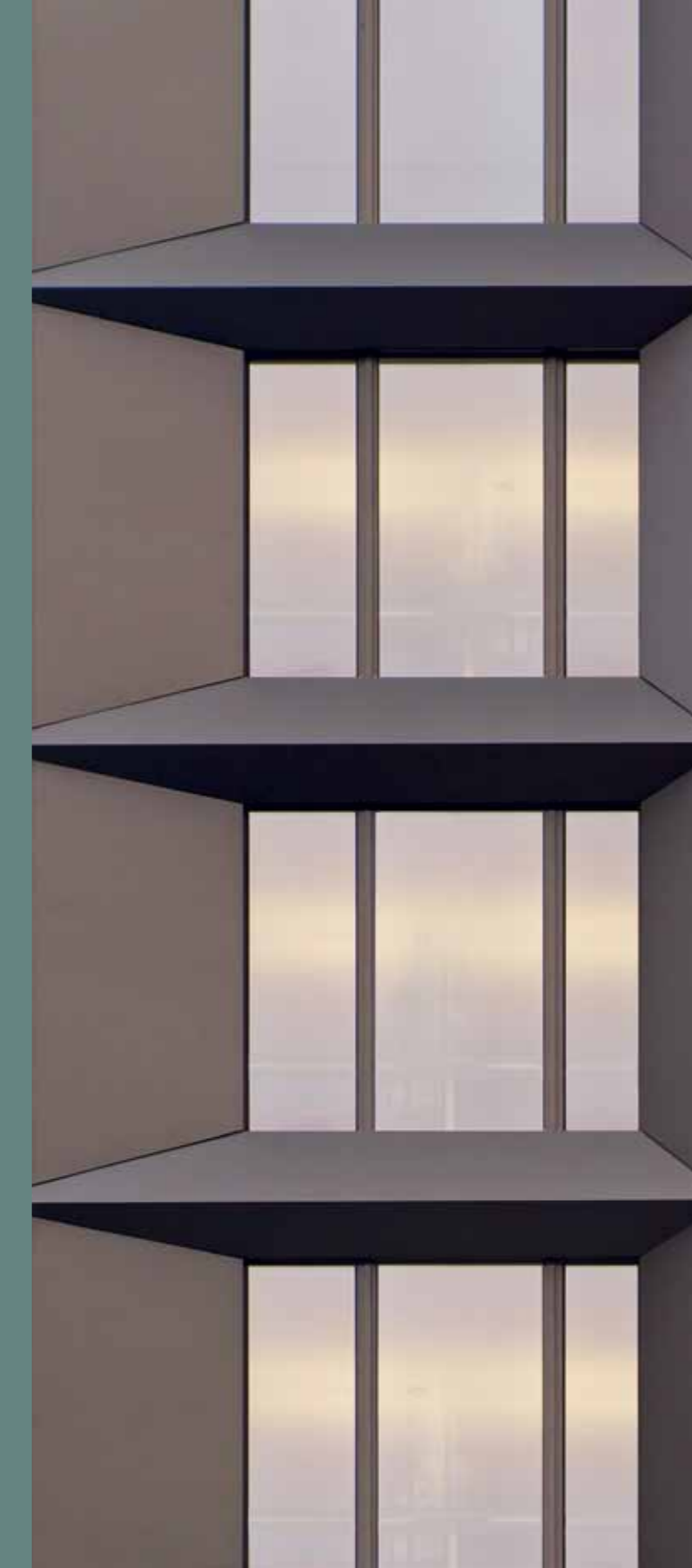
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More information under www.igp.ch

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## IGP-DURA<sup>®</sup>*xal*

Deep-matt powder coating system for an elegant and stylish surface design for use in architectural and design applications



# IGP-DURA<sup>®</sup>*xal* – DEEP-MATT SURFACE DESIGNS FOR TOP QUALITY ARCHITECTURAL AND DESIGN APPLICATIONS

IGP-DURA<sup>®</sup>*xal* is more than just a powder coating! The elegant IGP-DURA<sup>®</sup>*xal* has an unmistakable material quality and resembles smooth matt anodised aluminium, due to its fine micro-structure. It also has excellent cleaning properties and is resistant to weather and mechanical effects.

## Unrivalled surface effect and range of design options

- Deep-matt, satiny surface finish, gloss reflections
- Excellent coating characteristics
- Wide range of colors and effects
- Resembles an anodised surface on steel, cast components and aluminium alloys

## Safety and application

- High recycling stability (IGP premium bonding)
- Simple and safe application
- Reproducible, homogeneous finish

## Environment

- No toxic ingredients
- No emissions after manufacture
- Environmentally-friendly production in powder coating quality

## Economy

- Maximum utilisation of materials
- Long-lasting surface quality
- Problem-free facade cleaning

## Two product qualities for perfect results

### IGP-DURA<sup>®</sup>*xal* 4201

- Highly weather-resistant quality
- Excellent color-fastness and gloss stability
- Approved for highly weather-resistant systems (Qualicoat Class 2, N°. P-1164)
- Long warranty periods
- Effect and plain colors in a highly weather-resistant color spectrum, shades adapted to special shades\*

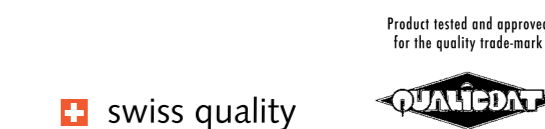
### IGP-DURA<sup>®</sup>*xal* 4601

- Weather-resistant industrial quality
- Above-average chemical resistance
- Expanded color range in effect and plain colors with numerous additional RAL, NCS and special shades\*

## Liquid supplemental lacquer

As a wet variation for IGP-DURA<sup>®</sup>*xal* powder, the optional product DOLD SPACELINE DURA<sup>®</sup>*xal* LIQUID is available for the stationary coating of facades and architectural elements (Manufacturer: DOLD AG, Wallisellen).

\* Special shades in accordance with customer specifications with pearl mica effect can be produced starting at a minimum order quantity of 200 kg.



Gemeindehaus Volketswil, Volketswil

VorZug, Baar

Limmathof, Baden

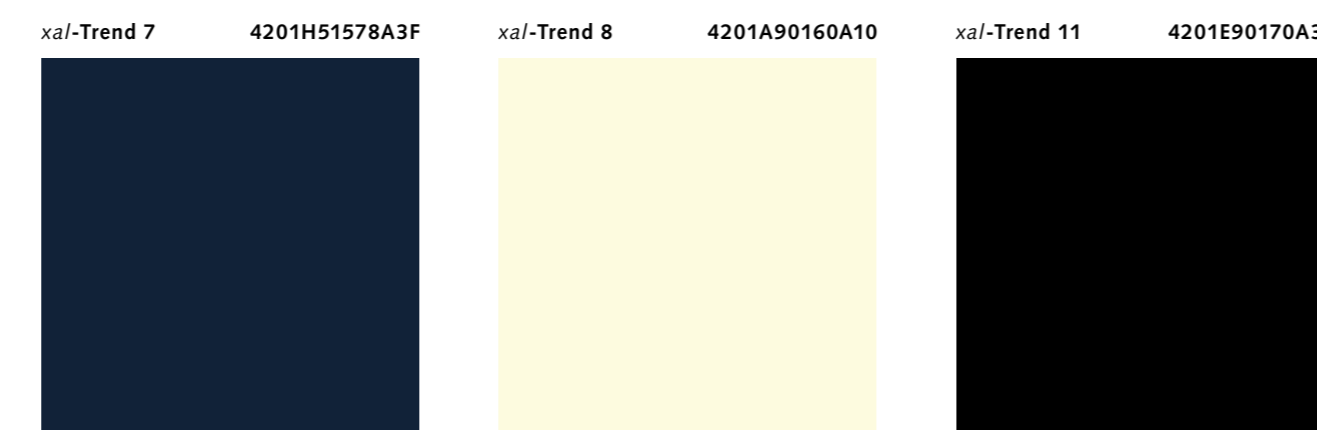
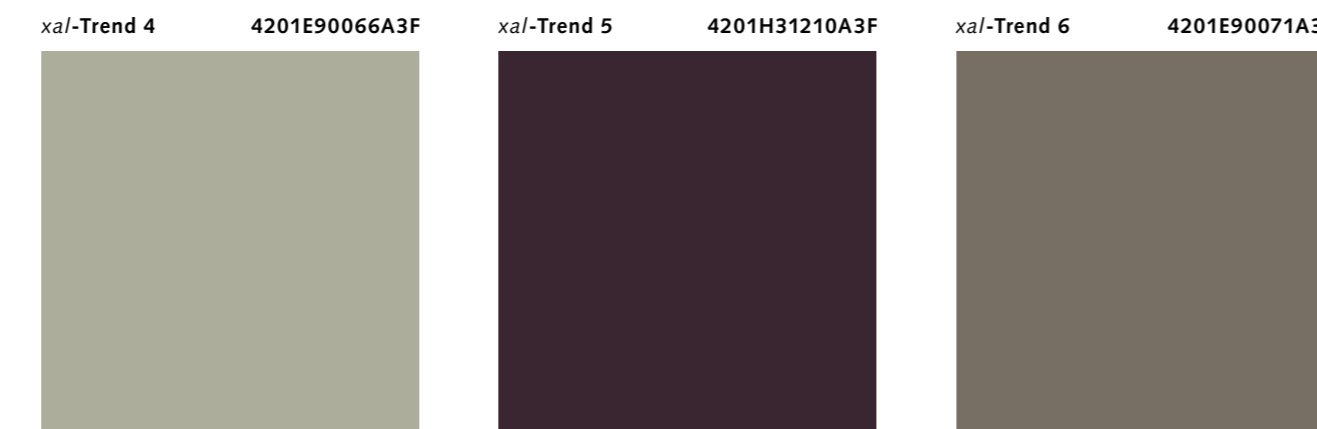


POWDER COATINGS.

**CLASSIC**  
IGP-DURA®*xal* 4201



**TREND**  
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**STYLE**  
IGP-DURA®*xal* 4201



**DESIGN**  
IGP-DURA®*xal* 4601

