

IGP-DURA[®] *xal* – TECHNOLOGICAL VALUES

Extract of tested product properties

General material characteristics / applications	
Series	Application
IGP-DURA [®] <i>xal</i> , 4201 Type L Material approval Qualicoat class 2	Special powder coating for highly weather-resistant architectural applications with extraordinarily high color and weather stability. Suitable for façade components, infrastructural facilities as well as outdoor accessories.
IGP-DURA [®] <i>xal</i> , 4601 Type L Outdoor-suitable quality	Special powder coating for weather-resistant exterior industrial applications with high decorative demands, including lamp housings, displays, sports equipment, electronic and communication devices.
Optical impression	Both series exhibit outstanding coating characteristics following the edges exactly, without disruptive "photo frame effects", and producing a velvety, deep matt surface.
Processability	Good depth of penetration, suitable for vertical plants (not for tribo); ensures that the conveyor hangers are homogeneously equipped with workpieces of a similar material thickness or the same heating behavior.
Recycling	Adding fresh powder using fluid containers is recommended. When processing items containing effect particles, the share of recycled powder must not exceed 30%. The share is defined by the coater with the aid of limit samples. Start of coating with powder mixture.
Color change	Compatibility with other products, no contamination.
Cleaning	Excellent cleanability thanks to the high degree of cross-linking, low porosity and high density; resistance to neutral cleaning agents. Cleaning must not be performed using abrasive motions or agents.

Material data		
Properties	Norm, testing	Result
Gloss level	DIN EN ISO 2813	< 12R / 60° at object temperature ≥ 180 °C / 20 min.
Coating thickness	DIN EN ISO 2360	Depending on covering power and shade, min. > 60 µm
Density		1,2 – 1,6 kg/l
Consumption		115 g / m ² ± 10g at approx. 80 µm, dependent on shade
Cross-cut adhesion test	DIN EN ISO 2409	Gt 0
Impact penetration	DIN EN ISO 6272-1	> 2,5 Nm, tape test
Richsen 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 AL 631/ST 663; Part IV, DE 2019 12	ΔL: < 4, valid for product quality IGP-DURA [®] <i>xal</i> 4201
Mortar resistance	DIN EN ISO 12206-1 (sect. 5.9)	24 h, can be removed free from residue

The technological properties were measured with a coating thickness of 60–85 µm on chromatinized aluminum 0,8 mm alu sheet. For project coating applications, the object temperature of the work pieces must be at least 180 °C during the intended cross-linking period of 20 min in order to achieve the intended gloss corridor.

For applications on extruded, rolled or cast metals and non-ferrous metals as well as pre-anodized aluminum alloys.

Possible substrates and pre-treatments	
Substrates	Pre-treatment
Aluminium	Chrome-containing (DIN EN 12487) or chrome-free pre-treatment; for chrome-free pre-treatment as well as pre-anodization, a preliminary sample is recommended, as well as compliance with the regulations of the certifications.
Steel	Suitable zinc phosphating. Alternatively: Blasting on SA 2 ½, priming with IGP-KORROPRIMER 60.
Galvanised steel	Chemical pre-treatment with GSB- and Qualicoat-certified pre-treatment chemicals. Alternatively: Sweeping and priming with IGP-KORROPRIMER 60.
Casting, incl.	Pre-treatment is to be checked on a case-by-case basis.

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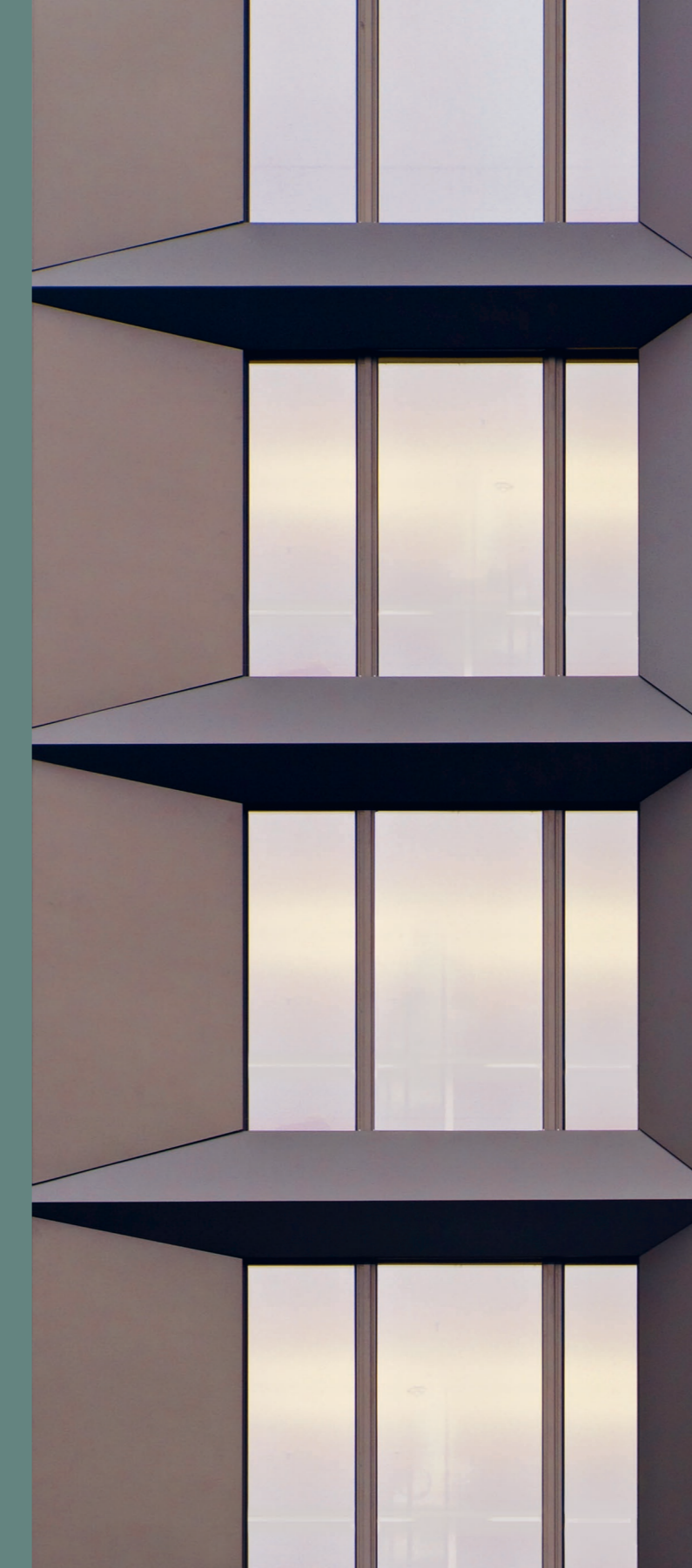
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IGP-DURA[®] *xal*

Deep matt powder coating system for elegant and exceptional surfaces in the architecture and design area

New: Optimized range of curing conditions for accelerated processes and narrower gloss tolerances



IGP-DURA[®] *xal* – DEEP MATT SURFACES FOR THE HIGH-QUALITY ARCHITECTURE AND DESIGN AREA

The elegant IGP-DURA[®] *xal* powder coating has an inimitable material quality and, with its fine micro-structure, has the velvety appearance of matt anodized aluminum. It is very easy to clean and insensitive to weather influences and mechanical effects.

Unrivalled surface effect with variety of designs

- Deep matt, velvety surface, free from gloss reflections
- Excellent coating characteristics
- Resembles anodized surfaces on steel, cast parts and aluminum alloys

Safety and processing

- Optimized curing conditions from 180 °C/20 min.
- High recycling stability (IGP Premium-Bonding)
- Simple and reliable application

Ecology

- Ingredients in accordance with Regulation (EU) No. 1907/2006 (REACH)
- Powder coating suitable for interior environments in accordance with AgBB and M1
- Environmental Product Declaration (EPD) in accordance with ISO 14025 and EN 15804 + A1

Economy

- High material utilization degree due to high recyclability
- Stable surface
- Easy facade cleaning

Two product qualities for perfect results

- IGP-DURA[®] *xal* 4201 Type L**
- Extremely weather-resistant quality
 - Outstanding shade and gloss stability
 - Approvals and examinations for extremely weather-resistant systems: Qualicoat approval class 2, No. P-1536, KAT.1 AAMA 2604-13, examination report 15314-4
 - Long-term warranties on request
 - Effect and solid shades in the extremely weather-resistant color chart as well as special shades*

IGP-DURA[®] *xal* 4601 Type L

- Weather-proof quality
- Above-average resistance to chemicals
- Extended color pallet in effect and solid shades with a variety of additional RAL, NCS and special shades*

Liquid supplemental lacquer

As a wet coating alternative to IGP-DURA[®] *xal* powder, the corresponding DOLD SPACELINE DURA[®] *xal* LIQUID product is available for stationary follow-up coating purposes (Manufacturer: DOLD AG, Wallisellen).

* Customized special shades with pearl mica effect are available for order quantities greater than 400 kg (approx. 4000 m²).



Town hall Volketswil, Volketswil

VorZUG, Baar

Limmathof, Baden



CLASSIC IGP-DURA®*xal* 4201

xal-Classic 01 4201E75281L3F



xal-Classic 31 4201E75268L3F



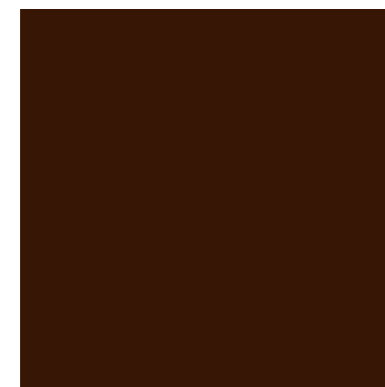
xal-Classic 32 4201E82301L3F



xal-Classic 33 4201E82303L3F



xal-Classic 34 4201E82304L3F



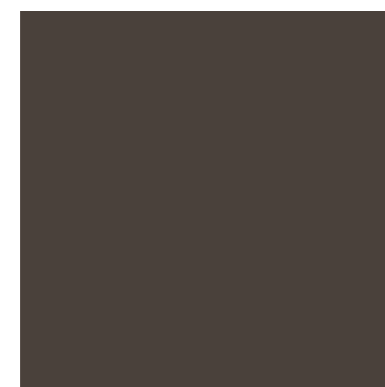
xal-Classic 35 4201E82305L3F



xal-Classic 36 4201E75307L3F



xal-Classic 37 4201E75305L3F



xal-Classic 38 4201E82306L3F



TREND IGP-DURA®*xal* 4201

xal-Trend 12 4201E64139L3F



xal-Trend 10 4201E77053L3F



xal-Trend 3 4201E92246L3F



xal-Trend 4 4201E90066L3F



xal-Trend 15 4201E32117L3F



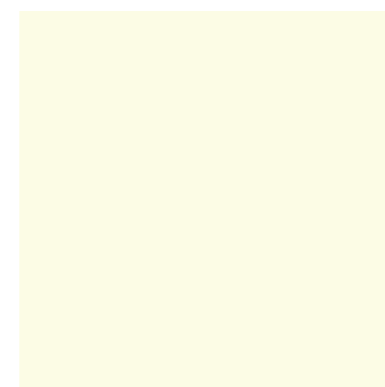
xal-Trend 6 4201E90071L3F



xal-Trend 13 4201E53683L3F



xal-Trend 8 4201A90160L10



xal-Trend 11 4201E90171L3F



STYLE IGP-DURA®*xal* 4201

xal-Style 21 4201E82665L3F



xal-Style 22 4201E13212L3F



xal-Style 23 4201E76256L3F



xal-Style 30 4201E81872L3F



xal-Style 25 4201E13343L3F



xal-Style 26 4201E82291L3F



xal-Style 27 4201E75918L3F



xal-Style 32 4201E77052L30



xal-Style 31 4201E76778L3M



DESIGN IGP-DURA®*xal* 4601

xal-Design 20 4601A11572L10



xal-Design 12 4601A81423L10



xal-Design 15 4601E21244L3F



xal-Design 17 4601A50240L10



xal-Design 21 4601A62175L10



xal-Design 22 4601A11841L10



xal-Design 25 4601A32007L10



xal-Design 24 4601A53422L10



xal-Design 26 4601A63886L10



Non-binding color samples:

Production-related and/or application-related deviations are possible.

Please refer to our "Technical Data Sheets".