IGP POWDER COATINGS

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Scheda tecnica

IGP-DURA®*xal* 4601U-L1

Durable deep matte powder coating for premium design objects, featuring a velvety anodized aluminum-like finish. Manufactured with IGP-Effectives® technology for superior effect stability.

Proprietà

- Opaco profondo
- Liscio
- IGP-Effectives®
- Industrial outdoor quality
- Bassa temperatura

Proprietà delle polveri

Granulometria:	< 100 µm
Corpi solidi:	> 99 %
Densità:	1.3 kg/l-1.6 kg/l
Stoccaggio:	min. 12 months a ≤ 25 °C in an unopened original container
app.print.technical_data_sheet.powder_coatings.color_effects	Based on the IGP-Effectives® colour register, which is available on request from your sales organisation. The purchase of specific customer shades, which are refined in the IGP-Effectives® process, is possible after a feasibility check and agreement of minimum quantities.

Applicazione

Pretrattamento

The substrate must be free from oil, grease and oxidation products. The pretreatment depends on the type of substrate and the corrosion protection to be achieved. We recommend the following pretreatments:

Alluminio

- Chromating according to DIN EN 12487
- Pre-anodization
- Chrome-free pretreatment according to GSB International and QUALICOAT specifications

Acciaio

- Zinc phosphating

Acciaio zincato
- Zinc phosphating
- Chrome (III) passivation
- Chromating according to DIN EN 12487

For improved corrosion protection for applications on steel / galvanised steel, the use of corrosion protection primer IGP-KORROPRIMER 10 or IGP-KORROPRIMER 60 is recommended.

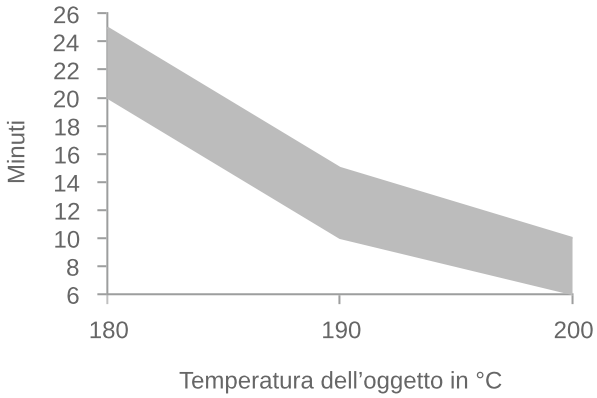
The suitability of the pretreatment method used is generally to be tested by the coater in advance with appropriate test methods. The minimum requirement for aluminium substrates / galvanised steel components is to carry out a boiling water test with a subsequent cross-cut adhesion and tape test. We refer to the guidelines of the GSB International, Qualicoat and Qualisteelcoat certifications. For further information: see also our special leaflet on pre-treatment (IGP-TI 100).

Impianti di verniciatura
All conventional electrostatic systems with corona charging.
For the construction and operation of powder coating plants, the following regulations must be complied with: ATEX RL 2014/34/EU, EN 50177, DIN EN 16985.

Spessore del film consigliato
60 µm - 80 µm

A homogeneous coating result with textured coatings or article-and color specific differences in hiding power may require higher coating thicknesses. The corresponding processing guidelines must be observed.
For a pre-calculation of the required powder coating quantity, the necessary coating thickness must be determined for each article.

Condizioni di cottura



$T_{oggetto}$	t_{min}	t_{max}
180 °C	20 minutes	25 minutes
190 °C	**10 minutes**	**15 minutes**
200 °C	6 minutes	10 minutes

In ogni caso, si raccomanda di effettuare prove pratiche con il rispettivo oggetto e per determinare l'ottimale per determinare il migliore possibile

app.print.technical_data_sheet.processing.application_instruction
IGP processing instruction for "IGP-DURA®xal": VR207.2.

Recupero
Due to the high bonding rate of powder grain and effect agent, the powder can be charged much more uniformly compared to other effect finishing processes. As a result, the powder can be processed with a significantly increased recovery rate. Please also refer to the IGP processing guideline for IGP-Effectives® powder coatings: VR201.2

Caratteristiche del film

Testato per

Substrati:	Aluminum (AlMg1), 0.8mm, chromated
Spessore:	60 µm - 80 µm
Temperatura dell'oggetto:	190 °C, 10 min.

Struttura superficiale

Brillantezza	0-12 R'/60°	DIN EN ISO 2813 2015-02

Prove meccaniche

Cross-cut adhesion test	Gt 0	DIN EN ISO 2409 2020-12
Mandrel bending test / Tape test	≤ 5 mm	DIN EN ISO 1519 2011
Impact test / Tape test	≥ 2.5 Nm	ASTM D 2794 1993
Erichsen cupping / Tape test	≥ 5 mm	DIN EN ISO 1520 2007-11
Buchholz hardness	≥ 80	DIN EN ISO 2815 2003-10 (Anhang A)

Test di resistenza agli agenti atmosferici

QUV/SE-B-313, 300h	> 50 % Brillantezza residua	DIN EN ISO 16474-3 2014-03

Verifiche della resistenza a corrosione

Condensation water test, 1000h	No infiltration, no blisters	DIN EN ISO 6270-2 2018-04
Natural salt spray test, 1000h	No infiltration, no blisters	DIN EN ISO 9227 2017-07

Altre informazioni

Imballaggio
20 kg cardboard box with inserted antistatic PE liner
500 kg cardboard container with 25 antistatic PE-liners each 20kg

Pulizia
The coated parts must be cleaned according to the directives RAL-GZ 632 or SZFF 61.01. Technical Information IGP-TI 106 must also be observed when dealing with pearl mica effects.

Rimozione e smaltimento della pittura
After use, coated goods should be supplied to the normal recycling process. The disposal methods for sludges or residual powders must be observed in accordance with the local official provisions whilst taking Waste Code "080201 Coating Powder Wastes" in accordance with the European Waste Catalogue into consideration.

Le presenti informazioni di natura tecnica relative all'utilizzo sono fornite sulla base delle conoscenze attuali. Tuttavia devono essere considerate come indicazioni non vincolanti che non esonerano dall'effettuazione di controlli autonomi. Utilizzo, destinazione e applicazione di prodotti hanno luogo senza possibilità di controllo da parte nostra e, pertanto, soggiacciono esclusivamente alla vostra responsabilità.

Prima dell'applicazione consultare la scheda di sicurezza. Scheda di sicurezza specifica per l'articolo e misure più approfondite sulla gestione del rischio alla pagina: **igp-powder.com**