

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon 310 AC

#### Product Description

Interpon 310 AC powder coatings are part of the Interpon 310 range of powder coatings designed for interior use. They maintain the film properties of the parent range but are designed to offer users significant improvements in their application characteristics. They can be sprayed on conventional equipment and are compatible with standard powders but give a more uniform coverage, and in particular give improved coverage in Faraday Cage areas. Powders are available in a wide range of colours and gloss levels, and are always custom matched to the user's requirements.

#### Powder Properties

<b>Chemical type</b>	Polyester TGIC-free
<b>Particle Size</b>	Suitable for electrostatic spray
<b>Specific gravity</b>	1.2-1.95 g/cm <sup>3</sup> depending on colour and effect
<b>Storage</b>	Dry cool conditions below 25°C (open boxes must be resealed)
<b>Shelf life</b>	12 months
<b>Stoving schedule</b> (object temperature)	12 to 24 minutes at 180°C 8 to 16 minutes at 200°C 4 to 10 minutes at 210°C

#### Test Conditions

The results shown below are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only. Actual product performance will depend upon the circumstances under which the product is used.

<b>Substrate</b>	Gold Seal polished 0.5mm steel
<b>Pretreatment</b>	Gold Seal lightweight Zinc Phosphate
<b>Film Thickness</b>	80 microns
<b>Stoving Schedule</b>	12 minutes at 200°C (object temperature)

#### Mechanical Tests

		Smooth	Fine Structure	Coarse Texture
<b>Flexibility</b> (Cylindrical Mandrel)	ISO 6860	Pass 6 mm	Pass 5 mm	Pass 5 mm
<b>Adhesion</b>	ISO 2409 (2mm Crosshatch)	Gt 0	Gt 0	Gt 0
<b>Erichsen Cupping</b>	ISO 1520	Pass 6 mm	Pass 6 mm	Pass 6 mm
<b>Impact</b>	ISO 6272 (1993)	50kgcm	50kgcm	50kgcm

#### Chemical and Durability Tests

<b>Salt Spray</b> (250 hours)	ISO 7253	No corrosion creep >2mm from scribe. Class 0 No change of visual appearance
<b>Cyclic Humidity</b> (1000 hours)	ISO 6270-1	No corrosion creep >2mm from scribe. Class 0 No change of visual appearance

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## Pre-treatment

Aluminium, steel or Zintec surfaces to be coated must be clean and free from grease. Iron phosphate and particularly lightweight zinc phosphating of ferrous metals improves corrosion resistance. Aluminium substrates may require a chromate conversion coating, chrome free pre-treatment or flash anodizing for certain applications. Galvanised steel may require zinc or chromate conversion or sweep blasting. Detailed advice should be sought from the pre-treatment supplier.

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## Application

Interpon 310 AC powder coatings can be applied by corona electrostatic or tribo-static equipment. However the aspect obtained by tribo-static equipment may vary when compared to electrostatic application and/or our colour card. In all application processes the aspect obtained is subject to variation, depending on the method of application (type of gun, nozzle, etc) and the shape/type of component. We recommend that the actual application parameters are adapted and adjusted depending on the type of component and with each powder batch in order to give a finish in accordance with our colour card. The following procedure is given as a guideline when using these finishes. We recommend the use of flat jet spray nozzles. To ensure powder homogeneity, the complete content of the boxes should be emptied completely into the feed hopper. For manual application it is essential to ensure that an even film thickness is applied and in all instances sinusoidal gun movements should be avoided.

<b>Recycling</b>	Depending of the product - Consult Technical Support of AkzoNobel.		
<b>Recommended Film thickness</b>	<b>Smooth</b> 60-80 microns	<b>Fine Structure</b> 60-90 microns	<b>Coarse Texture</b> 80-100 microns

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## Additional Information

### Contact with Chemical Agents

Contact, even for a short duration, with certain household products and chemicals, can cause irreversible changes in the gloss and appearance. We recommend that a test is carried out on a nonvisible area before using these types of products on these coatings

For further information please contact your AkzoNobel representative.

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## Safety Precautions

Please consult the Material Safety Datasheet (MSDS)

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## Disclaimer

**IMPORTANT NOTE:** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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