

Product Datasheet



BU Powder Coatings

AkzoNobel

Tomorrow's Answers Today

Interpon D1036 Fiji

The information given in this datasheet is generic for the range **Interpon D1036 Fiji** and should not be construed as referring to other products in the **Interpon D** and **Interpon D1036** ranges. Specific products within the range can vary from the generic. For these products individual product datasheet are available

Product Description

Interpon D1036 Fiji is a range of powder coatings with fine texture aspect intended for use on architectural aluminium and galvanized steel. Available in a wide stock range **Interpon D1036 Fiji** has been specifically formulated without the use of TGIC. **Interpon D106 Fiji** coatings have a better scratch resistance than many conventional systems.

As part of the **Interpon D** series of architectural powders, **Interpon D1036 Fiji** gives excellent exterior durability and colour retention and conforms to the requirements of all the major European architectural finishing standards. All **Interpon D1036 Fiji** powders are lead-free and meet the requirements of GSB standard, Qualicoat Class 1, EN12206, and EN13438 (formerly BS6496 & BS6497), and AAMA 2603.

Powder Properties

Chemical type	Polyester
Gloss (EN ISO 2813 (60°))	15-25
Particle size distribution	Suitable for electrostatic spray
Specific gravity	1.2-1.9g/cm ³ depending on colour.
Storage	Dry, cool conditions
Shelf life	24 months below 30°C peak temperature 12 months below 35°C peak temperature
Stoving schedule (Object temperature)	20-40 minutes at 180°C 12-24 minutes at 200°C 8-14 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.

Substrate	Aluminium (0,5-0,8 mm Al Mg1)
Pretreatment	Chromate (DIN 50539)
Film thickness	70-90microns (ISO 2360)
Stoving conditions	12 minutes at 200° C (object temperature)

Mechanical Tests

Adhesion	ISO 2409	Pass Gt 0 (2mm Crosshatch)
Erichsen cupping	ISO 1520	Pass >6mm
Hardness	ISO 2815	Minimum 80
Flexibility	ISO 1519	Pass 4mm
Impact resistance	ISSO 6272	Pass 2.5 joules reverse & direct or 20 inch pounds

Chemical and Durability tests

Acetic acid salt Spray	ISO 9227	Pass at 1000 hours <16 mm ² corrosion/10cm
Constant humidity	ISO 6270	Pass at 1000 hours - no blistering, creep<1mm
Sulphur dioxide	ISO 3231	Pass 30 cycles- no blistering, loss of gloss or discoloration

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Permeability	Pressure Cooker EN12206-1:2004 Part 5.10	Pass – no defects after 1 hour
Chemical resistance		Generally good resistance to acid, alkalis and oils at normal temperatures.
Mortar Resistance	EN12206-1:2004 Part 5.9	No effect after 24 hours
Exterior durability	ISO 2810	≥50% gloss retention. Colour retention in accordance with GSB or Qualicoat Chalking – none in excess of minimum in ASTM D659:1980
Accelerated Weathering Test	Suntest Original-Hanau- Quartzlampen ISO11341 QUV-B 313	≥50% gloss retention after 1000 hours ≥50% gloss retention after 300 hours
Colour stability at elevated temperatures		Good

Pretreatment

For maximum protection it is essential to pretreat components prior to the application of **Interpon D1036 Fiji**.

Aluminium components should receive a full multi-stage chromate conversion coating or suitable chrome-free pre-treatment or suitable pre-anodising to clean and condition the substrate.

Detailed advice should be sought from the pre-treatment supplier.

Galvanised steel requires surface preparation by either multi-stage pretreatment using either zinc phosphate or chromate conversion or controlled sweep blasting. Depending on the type of galvanizing, degassing or use of anti-bubbling additives may be required – follow the procedural advice of the pretreatment supplier.

Interpon D1036 Fiji products may also be used on cast or mild steel. For outdoor use **Interpon PZ** anti-corrosive primer over a correctly prepared substrate is recommended.

Application

Interpon D1036 Fiji powders can be applied by manual or automatic Electrostatic spray or tribo-charging equipment. using the application parameters given below:

- fluidising air pressure 1.0-2.0 kg/cm²
- transport air pressure 0.5-0.8 kg/cm²
- additional air pressure 0.4-0.8 kg/cm²
- voltage 40-60 kV
- cured film thickness 70-90 µm

For solid shades, unused powder can be reclaimed up to a maximum of 30% using suitable equipment and recycled through the system. Please consult AkzoNobel for further details as to the correct mixing ratio for virgin/reclaim powder.

To ensure good final results, the surface coated must be as uniform as possible.

The thickness of the film must be checked as under thickness or over thickness can lead to a difference in the gloss and in the final aspect.

All powders can show small colour differences from batch to batch, this is normal and unavoidable. While AkzoNobel take every precaution to minimize visible differences, this cannot be guaranteed. Applicators and fabricators are advised to use a single batch for parts that will be assembled together. Differences are more likely with special effect powders.

Bonded products have better application properties than blended products (more stable) but attention should still be paid to line settings in order to avoid “marble effect” and changes in aspect after recycling.

Different substrates (aluminium, steel, galvanized steel...), use of primer, and big changes in film thickness may give a different aspect.

Products with different codes should not be mixed even if same colour and gloss.

Post Application

For specific advice on the suitability of post coating processes such as bending or the use of sealants, adhesives, thermal break, cleaning etc. Please consult AkzoNobel

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Safety information

Please consult the relevant Material Safety Data Sheet (MSDS) available from AkzoNobel.

Maintenance

Minimum once every 12 months, and up to every 3 months in aggressive atmospheres (further advice is available) or on the parts on which it is never raining. Use a solution of warm water and non-abrasive, pH neutral detergent solution. Surfaces should be thoroughly rinsed after cleaning to remove all residues. All surfaces should be cleaned using a soft cloth or sponge or nothing harsher than a soft natural bristle brush. Never use products as gasoline, acetone, alcohol, alkaline or acid products, and any abrasive generally. Never clean elements coated by means of high-pressure and/or high-temperature cleaners.

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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 advice 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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