Product Data Sheet

AkzoNobel Powder Coatings

Interpon 100 Primer Matt – Window Grey Group Code: AL240P

Product Description:

Interpon 100 Primer is a series of epoxy based powder coating primer designed to give optimum mechanical performance and exceptional protective qualities on fabrications and components.
Interpon 100 Primer will improve the corrosion resistance and adhesion of powder topcoats such as Interpon 600;Interpon 610; Interpon 700; Interpon D1000 or Interpon D2525 series.

The information given in this datasheet refers to the range Interpon 100 Primer. Specific products within the range can vary from the generic. For these products individual product datasheets are available

		Result	Method
Powder Properties:	**Chemical type**	Epoxy	
	Colour	Grey	
	Specific Gravity	1.540g/cm³	Theoretical
	Particle size		Suitable for electrostatic spray
	Storage		Dry cool conditions below 25ºc
	Shelf Life		24 months below 30°c peak temperature 12 months below 35°c peak temperature
Test Conditions:	The test 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	Mechanical tests: Gold Seal polished steel	 Gold Seal lightweight
	Pre-treatment	Zinc Phosphate	
	Film Thickness	50 microns	ISO 2360
	Stoving (object temperature)	5 minutes at 200°C	
Mechanical Chemical and Durability Tests:	**Dry Adhesion**	GT-0	ISO 2409 (2mm Crosshatch)
	Flexibility(conical Mandrel)	Pass 3mm	ISO 6860
	Impact	Pass 2 Joules direct & reverse	ASTM D2794
	Hardness	Pass – no penetration to substrate (2000gms)	ISO 1518
	Cyclic Humidity	Pass – no blistering or loss of gloss	DIN 50017 (1000 hours)
	Exterior Durability	Some chalking after 3-6 months continuous outdoor exposure	
	Colour stability at elevated temperatures	Fair – gradual yellowing of white and pastel shades on continuous exposure up to 100°C	
	Chemical Resistance	Generally excellent resistance to most acids, alkalis and oils at normal temperatures	

Pre-treatment:

For maximum protection it is essential to pre-treat components prior to the application of **Interpon 100 Primer**.
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.
Aluminium, steel or Zintec surfaces must be clean and free from grease.
Iron phosphate and lightweight zinc phosphating of ferrous metals improves corrosion resistance.
Galvanised steel may require zinc or chromate conversion or sweep blasting.
Detailed advice should be sought from the pre-treatment supplier

Application:

Interpon 100 Primer can be applied by manual or automatic corona spray equipment. However, different electrostatic gun types may exert different charging characteristics and hence affect the appearance.
Below are starting point application parameters:
- *Fluidising air pressure* 0.4-1.0kg/cm² - *Transport air pressure* 0.4-0.8 kg/cm²
- *Additional air pressure* 0.4-0.8 kg/cm² - *Voltage* 60-80kV

The actual application parameters must be adapted and adjusted depending on the type of application equipment; component and with each powder batch in order to give a finish in accordance with our colour standard.
For manual application it is essential to ensure that an even film thickness is applied and in all instances sinuous gun movements should be avoided.
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.
It is considered standard practice in the industry where colour or finish accuracy is vital, to prepare a test panel of the proposed colour using the supplied coating with the coating/curing facilities that will be used to complete the job so as to ensure satisfaction before commencing the job.

Curing:

Cure window: 15 minutes at 160ºc; 8 minutes at 180°C; 5 minutes at 200°C

Note! Cure temperatures given refers to the substrate temperature.
The flow of the coatings can be affected if the cure temperature rises too slowly.

Recycling:

Unused powder can be reclaimed using suitable equipment and recycled through the coating system. However, due to the nature of the product, care should be taken, by means of sprayouts, to ensure that reclaimed powder has consistency of finish when compared to original virgin material.

Recommended film thickness:

Depending on colour 45-55 microns, appling excessive high film thickness will result in impact failures.
Please contact our technical service department for more information.

Safetey Precautions:

Please consult the Material Safety Datasheet

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Interpon 100 Primer - Issue 6
Issued: 05/03/2018