

Product Data Sheet

AkzoNobel Powder Coatings

Interpon F2505

Product Code

Product Description

Interpon F2505 is a series of durability TGIC-free powder. It can offer 5 years powder warranty. It is designed to offer significantly higher gloss retention and resistance to color change combined with maximum film integrity to ensure long term cosmetic and functional protection.

Interpon F2505 powders are available in a selected range of colors and pearlescent effects in gloss, satin and matt, fine and coarse texture effect also available.

Powder Properties

Chemical type	TGIC Free
Appearance	Depends on specific product
Particle Size	Suitable for electrostatic spray
Specific gravity	1.2-1.7g/cm ³ (depending on color)
Storage	Dry cool conditions below 25°C (open boxes must be resealed)
Shelf life	12 months
Stoving schedule (object temperature)	15 minutes @ 190°C(Object temperature) 10 minutes@ 200°C Failure to observe the correct curing conditions may cause difference in colour, gloss and the deterioration of the coating properties

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	0.6mm degreased steel (Impact tests) ; Chromating Aluminum(AA6060 or AA6063) panel (Other tests)
Pretreatment	Qualified Cr3+, Cr6+ or non-Cr pretreated
Film Thickness	60-80 microns
Stoving Schedule	10minutes @ 200°C

Mechanical Tests

Adhesion	ASTM D3359	5B
Pencil Hardness	ASTM D3363	H
Impact (Direct)	ASTM D2794	50kg.cm ,no peel off
Abrasion Resistance	ASTM D4060	Weight lose ≤ 60mg (CS-10,1000 cycles)

Chemical and Durability Tests

Satin Resistance (50% Alcohol, 3% acetic acid, 0.1M NaOH, 5%Detergent Solution, Coffee, Tea, Edible Oil)	ASTM1308-03	Pass—T=25±2°C; 24hours. No blister and detachment; slight color and gloss change can be acceptable
Constant Climate Condensation	ASTM D2247	Pass—1000h, No visible color change and no blisters by visual.
Xeon Arc	ISO 16474	Pass—800h, Gloss Retention ≥ 50%, Color shade Δ E<3 (bright color not included)

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Corrosion Tests	Neutral salt spray	ISO 9227	Pass— 1000 h, max creep from scribe $\leq 4\text{mm}$, Max blister area $\leq 16\text{mm}^2$
Pre-treatment	For maximum protection it is essential to pretreat components prior to the application of Interpon F2505 . Aluminium components should receive a full multi-stage chromate conversion coating or suitable chrome-three pre-treatment or suitable chrome-free pretreatment to clean and condition the substrate. Detailed advice should be sought from the pre-treatment supplier.		
Application	Interpon F2505 powders can be applied by manual or automatic electrostatic spray equipment, however for consistency of finish automatic equipment is preferred. Unused powder can be reclaimed using suitable equipment and recycled through the coating system. Fluidizing air pressure ~0.7 bar Transport air pressure ~0.7bar Recommended voltage 40-90kV		
Damage Repair	Surface preparation	Sanding + Air cleaning	
	Application	Recoat : Lower Voltage	
Safety Precautions	When using, do not eat, drink or smoke. Do not breathe the dust. In case of insufficient ventilation wear suitable respiratory equipment. For further information please refer to the specific product Material Safety Data Sheet (MSDS) available on request from your local AkzoNobel sales office.		
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. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel		

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