

Product Data Sheet

AkzoNobel Powder Coatings

Interpon 310 MW136E Gold

Product Description	<p>Interpon 310 is a series of polyester resin based thermo-setting powder coatings, without TGIC.</p> <p>The Interpon 310 resin system is warning label free. The pigments used in the Interpon 310 series restrict the field of application of this powder coatings class to interior uses. Interpon 310 is designed for interior decoration such as, metal furniture, shop fittings, shelves, light fittings.</p>		
Powder Properties	Chemical type	Polyester TGIC Free	
	Recommended Film Thickness (µm)	60 - 80 µm	
	Density (g/cm³)	1.64 +-0.03 g/cm ³ please refer to COA	
	Application	Suitable for electrostatic spray	
	Storage	Under dry, cool (≤ 30°C) conditions	
	Shelf life	24 months below 30°C	
	Curing schedule	At 170°C: min 20 min – max 40 min At 180°C: min 10 min – max 20 min At 200°C: min 8 min – max 16 min	
Test Conditions	<p>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.</p>		
	Substrate	Gold Seal polished 0.5mm steel	
	Pretreatment	Gold Seal lightweight Zinc Phosphate	
	Film Thickness	80 microns	
	Curing Schedule	12 minutes at 200°C (Object Temperature)	
Mechanical Tests	Adhesion	ISO 2409 (2mm crosshatch)	Class 0
	Erichsen Cupping	ISO 1520	≥ 5mm
	Impact	ISO 6272	> 30 kg·cm direct

Chemical and durability tests

Whilst maintaining the general protective and anti-corrosive properties of powder coatings, aluminum and copper/bronze metallic finishes, when submitted to the listed tests, may rapidly show a loss of metallic aspect.

The results shown are based on tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for advice only, actual performance depends upon the circumstances under which the product is used.

Salt Spray (500 hours)	ISO 9227	Pass - no corrosion creep more than 3 mm from scribe
Cyclic Humidity (1000 hours)	ISO 6270	Pass - no blistering or loss of gloss

*Note: test only relates to corrosion resistance

Pretreatment

Surface preparation depends upon the metal, the type of surface, its conditions and the required performance.

Substrate	Mechanical pretreatment	Chemical pretreatment
Mild steel	Grit Blasting Sa 2.5 in accordance with ISO NF EN 8501-1. Roughness: Rz 42-84 μm / Ra 6-12 μm .	Degreasing & phosphating followed by passivation, DW rinsing and drying.
Cast steel		
Electro Zinc steel	Sanding	
Hot dip galvanized steel	Sweeping with a maximum zinc layer thickness reduction of 5 to 10 μm depending on the initial zinc thickness.	Degreasing by phosphating & passivation or primary wash using liquid primer Cromadex 903 (can be substituted by chemical passivation with Cromadex MC245).
Zinc sprayed (gas flame/electrical deposition)	Light sanding/Light sand Blasting	Not recommended

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

Application

Interpon 310 powder coatings can be applied by corona electrostatic or tribostatic equipment. However, the aspect obtained by tribo-static equipment may vary when compared to electrostatic application and/or our color 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 to give a finish in accordance with our color 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.

All powders can show small color 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 to avoid “marble effect” and changes in aspect after recycling. For more details it is suggested to read the “**Metallic Application Guideline**”.

Different substrates (Aluminium, steel, galvanized steel, etc.), 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 color and gloss.

Recycling	Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% virgin powder should be used.
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Post Application
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 non-visible area before using these types of products on this coating.

Safety Precautions

This product is intended for use only by professional applicators in industrial environments and should not be used without reference to the relevant health and safety data sheet which Akzo Nobel has provided to its customers.

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 fulfil 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.

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