

Interpon D1036 Fiji

The information given in this datasheet refers to the products **Interpon D1036 Fiji** and should not be construed as referring to other products in the **Interpon D** or **Interpon D1036** ranges

Product Description:	<p>Interpon D1036 Fiji effects powder coating finishes, with fine texture aspect, specifically formulated for use on architectural metal components.</p> <p>The Interpon D1036 range of polyester powder coatings has been specifically formulated using the Perform System, Akzo Nobel's TGIC-free technology.</p> <p>Interpon D1036 Fiji coatings give excellent exterior durability and colour retention and conform to the requirements of all the major European architectural finishing standards. Interpon D1036 Fiji coatings have a superior scratch resistance than many conventional systems.</p> <p>Interpon D1036 powders are lead-free and meet the requirements of GSB, Qualicoat Class 1, and EN 12206 (formerly BS6496), BS6497:1984.</p>
-----------------------------	--

Powder Properties:	<table border="1"> <tr> <td>Chemical type</td> <td>Polyester</td> </tr> <tr> <td>Gloss (60°) ISO2813</td> <td>15 - 25</td> </tr> <tr> <td>Particle size</td> <td>Suitable for electrostatic application</td> </tr> <tr> <td>Density</td> <td>1.5-1.6 depending on colour</td> </tr> <tr> <td>Storage</td> <td>Dry cool conditions</td> </tr> <tr> <td>Shelf life</td> <td>24 months below 30°C peak temperature 12 months below 35°C peak temperature</td> </tr> <tr> <td>Stoving schedule (object temperature)</td> <td>20-40 minutes at 180°C 12-24 minutes at 200°C 8-14 minutes at 210°C</td> </tr> </table>	Chemical type	Polyester	Gloss (60°) ISO2813	15 - 25	Particle size	Suitable for electrostatic application	Density	1.5-1.6 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
Chemical type	Polyester														
Gloss (60°) ISO2813	15 - 25														
Particle size	Suitable for electrostatic application														
Density	1.5-1.6 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:	<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> <table border="1"> <tr> <td>Substrate</td> <td>Aluminium (0.5-0.8mm Al Mg1)</td> </tr> <tr> <td>Pretreatment</td> <td>Chromate</td> </tr> <tr> <td>Film Thickness</td> <td>70-80 microns</td> </tr> <tr> <td>Stoving</td> <td>12 minutes at 200°C (object temperature)</td> </tr> </table>	Substrate	Aluminium (0.5-0.8mm Al Mg1)	Pretreatment	Chromate	Film Thickness	70-80 microns	Stoving	12 minutes at 200°C (object temperature)
Substrate	Aluminium (0.5-0.8mm Al Mg1)								
Pretreatment	Chromate								
Film Thickness	70-80 microns								
Stoving	12 minutes at 200°C (object temperature)								

Mechanical Tests:	<table border="1"> <tr> <td>Adhesion</td> <td>ISO2409 (2mm Crosshatch)</td> <td>Gt 0</td> </tr> <tr> <td>Erichsen Cupping</td> <td>ISO1520</td> <td>Pass >6mm</td> </tr> <tr> <td>Hardness</td> <td>ISO2815</td> <td>Minimum 80</td> </tr> <tr> <td>Impact</td> <td>ASTM D2794</td> <td>Pass 2.5 joules reverse & direct or 20 inch pounds</td> </tr> <tr> <td>Flexibility</td> <td>ISO1519</td> <td>Pass 5mm</td> </tr> </table>	Adhesion	ISO2409 (2mm Crosshatch)	Gt 0	Erichsen Cupping	ISO1520	Pass >6mm	Hardness	ISO2815	Minimum 80	Impact	ASTM D2794	Pass 2.5 joules reverse & direct or 20 inch pounds	Flexibility	ISO1519	Pass 5mm
Adhesion	ISO2409 (2mm Crosshatch)	Gt 0														
Erichsen Cupping	ISO1520	Pass >6mm														
Hardness	ISO2815	Minimum 80														
Impact	ASTM D2794	Pass 2.5 joules reverse & direct or 20 inch pounds														
Flexibility	ISO1519	Pass 5mm														

Corrosion Tests:	<table border="1"> <tr> <td>Salt Spray</td> <td>ISO7253</td> <td>Pass at 1000 hours - no corrosion area more than 2mm from scribe</td> </tr> <tr> <td>Acetic Acid Salt Spray</td> <td>ISO9227</td> <td>Pass at 1000 hours - <16mm² corrosion/10cm</td> </tr> <tr> <td>Constant Humidity</td> <td>ISO6270</td> <td>Pass at 1000 hours - no blistering, creep < 1mm</td> </tr> <tr> <td>Sulphur Dioxide</td> <td>ISO3231</td> <td>Pass 30 cycles - no blistering, creep <1mm from scribe</td> </tr> <tr> <td>Permeability</td> <td>Pressure Cooker EN12206-1:2004 Part 5.10</td> <td>Pass - no defects after 1 hour (2 hours boiling water)</td> </tr> <tr> <td>Chemical Resistance</td> <td colspan="2">Generally good resistance to dilute acids, alkalis and oils at room temp</td> </tr> <tr> <td>Mortar Resistance</td> <td>EN12206-1:2004 Part 5.9</td> <td>No effect after 24 hours</td> </tr> </table>	Salt Spray	ISO7253	Pass at 1000 hours - no corrosion area more than 2mm from scribe	Acetic Acid Salt Spray	ISO9227	Pass at 1000 hours - <16mm ² corrosion/10cm	Constant Humidity	ISO6270	Pass at 1000 hours - no blistering, creep < 1mm	Sulphur Dioxide	ISO3231	Pass 30 cycles - no blistering, creep <1mm from scribe	Permeability	Pressure Cooker EN12206-1:2004 Part 5.10	Pass - no defects after 1 hour (2 hours boiling water)	Chemical Resistance	Generally good resistance to dilute acids, alkalis and oils at room temp		Mortar Resistance	EN12206-1:2004 Part 5.9	No effect after 24 hours
Salt Spray	ISO7253	Pass at 1000 hours - no corrosion area more than 2mm from scribe																				
Acetic Acid Salt Spray	ISO9227	Pass at 1000 hours - <16mm ² corrosion/10cm																				
Constant Humidity	ISO6270	Pass at 1000 hours - no blistering, creep < 1mm																				
Sulphur Dioxide	ISO3231	Pass 30 cycles - no blistering, creep <1mm from scribe																				
Permeability	Pressure Cooker EN12206-1:2004 Part 5.10	Pass - no defects after 1 hour (2 hours boiling water)																				
Chemical Resistance	Generally good resistance to dilute acids, alkalis and oils at room temp																					
Mortar Resistance	EN12206-1:2004 Part 5.9	No effect after 24 hours																				

Interpon D1036 FIJI

The information given in this datasheet refers to the products **Interpon D1036 Fiji** and should not be construed as referring to other products in the **Interpon D** or **Interpon D1036** ranges

Weathering Tests:	Exterior Durability	ISO2810 (Florida 12 months 5° South)	≥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	≥50% Gloss retention after 1000 hours
		QUV B313	≥50% Gloss retention after 300 hours
	Light Fastness	DIN54004	Minimum 7

Pretreatment: For maximum protection it is essential to pretreat architectural components prior to the application of **Interpon D1036 Fiji**. Aluminium components should receive a full multi-stage chromate conversion coating, suitable chrome-free pretreatment or suitable pre-anodising to clean and condition the substrate. Detailed advice should be sought from the pretreatment 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 galvanising, 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** effect powders can be applied by manual or automatic electrostatic spray or tribo charging equipment.
Interpon D1036 Fiji can be applied by conventional electrostatic spray equipment using the application parameters given below:

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

For solid shades unused powder can be reclaimed using suitable equipment and recycled through the coating system.

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 .

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 Akzo Nobel.

Safety Precautions: Please consult the Material Safety Datasheet (MSDS)

Disclaimer: The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this 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. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Akzo Nobel Powder Coatings Ltd. Worldwide Powder Group. Stoneygate Lane. Felling. Tyne & Wear. NE10 0JY. UK.
 Tel: +44 (0) 191 401 2256 Fax: +44 (0) 191 469 6111 www.interpon.com
 Copyright ©2005 Akzo Nobel Powder Coatings Ltd. Interpon is a registered trademark of Akzo Nobel

D1036 Fiji – Issue 1
 Issued 17/05/2005