

# Interpon D36 FIJI

**Product Description:** **Interpon D36 Fiji** effects powder coating finishes, with fine texture aspect, specifically formulated for use on architectural metal components.

The **Interpon D36** range of polyester powder coatings has been specifically formulated using the **Perform System**, Akzo Nobel's TGIC-free technology.

**Interpon D36 Fiji** coatings give excellent exterior durability and colour retention and conform to the requirements of all the major European architectural finishing standards. **Interpon D36 Fiji** coatings have a superior scratch resistance than many conventional systems.

**Interpon D36** powders are lead-free and meet the requirements of GSB, Qualicoat Class 1, and EN 12206 (formerly BS6496), BS6497:1984.

<b>Powder Properties:</b>	<b>Chemical type</b>	Polyester
	<b>Gloss (60°) ISO2813</b>	15 - 25
	<b>Particle size</b>	Suitable for electrostatic application
	<b>Density</b>	1.5-1.6 depending on colour
	<b>Storage</b>	Dry cool conditions below 30°C peak temperature
	<b>Shelf life</b>	24 months
	<b>Stoving schedule</b> (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.

<b>Substrate</b>	Aluminium (0.5-0.8mm Al Mg1)
<b>Pretreatment</b>	Chromate
<b>Film Thickness</b>	70-80 microns
<b>Stoving</b>	12 minutes at 200°C (object temperature)

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

<b>Corrosion Tests:</b>	<b>Salt Spray</b>	ISO7253	Pass at 1000 hours - no corrosion area more than 2mm from scribe
	<b>Acetic Acid Salt Spray</b>	ISO9227	Pass at 1000 hours - <16mm <sup>2</sup> corrosion/10cm
	<b>Constant Humidity</b>	ISO6270	Pass at 1000 hours - no blistering, creep < 1mm
	<b>Sulphur Dioxide</b>	ISO3231	Pass 30 cycles - no blistering, creep <1mm from scribe
	<b>Permeability</b>	Pressure Cooker Qualicoat B1(o)	Pass - no defects after 1 hour (2 hours boiling water)

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	Chemical Resistance		Generally good resistance to dilute acids, alkalis and oils at normal temperatures
Weathering Resistance:	Mortar Resistance	ASTM C207	No effect after 24 hours
	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 QUV B313	≥50% Gloss retention after 1000 hours ≥50% Gloss retention after 300 hours
	Light Fastness	DIN54004	Minimum 7

**Pretreatment:** For maximum protection it is essential to pre-treat architectural components prior to the application of **Interpon D36 Fiji**. Aluminium components should receive a full multi-stage chromate conversion coating, 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 pre-treatment 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 pre-treatment supplier.

**Interpon D36 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 D36 Fiji** effect powders can be applied by manual or automatic electrostatic spray or tribo charging equipment.

**Interpon D36 Fiji** can be applied by conventional electrostatic spray equipment using the application parameters given below:

- fluidising air pressure 1.0-2.0kg/cm<sup>2</sup>
- transport air pressure 0.5-0.8kg/cm<sup>2</sup>
- additional air pressure 0.4-0.8kg/cm<sup>2</sup>
- 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) PC111

**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.