

Dulux Powder Coatings Duralloy®

AU_DP01899

Product Code	272 Line
Approval	Meets and/or exceeds requirements of AS3715, BS6496.

Description

Duralloy® is a TGIC free, tough thermosetting powder coating that exhibits decorative and durability characteristics suitable for interior and exterior product applications combined with excellent overall performance. Supported by a 10 year durability warranty* on residential projects up to 3 floors from the ground.

*Subject to the terms and conditions of the relevant product warranty. Please contact your local Dulux representative for further details.

Features And Benefits

- | | |
|---|--|
| <ul style="list-style-type: none"> ▪ Guaranteed 10 year performance on correctly pre-treated aluminium ▪ Lower temperature cure ▪ Wide product range ▪ No solvents or emissions | <ul style="list-style-type: none"> ▪ Very good colour retention ▪ Cost savings on energy or increased line speeds ▪ Extensive selection of colours ▪ Less waste and pollution to the environment |
|---|--|

Uses

Duralloy® was developed primarily for use on extruded aluminium, including window and door joinery, and extruded aluminium panel work on class 1 & 10 Residential buildings. Duralloy® is also suitable for use in many applications over a variety of substrates, including mild steel and aluminium.

Precautions And Limitations

- Duralloy® is only available in colours which meet Dulux Powder Coatings pigmentation criteria. Strong, bold colours may not necessarily meet these criteria and should be referred to Dulux Powder Coatings before specifying.
- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
- For optimum performance ensure recommended dry film thickness is obtained.
- Not recommended for use in highly corrosive environments such as severe marine or industrial locations.
- Not recommended for components which are exposed to constant temperatures exceeding 120°C.
- Excessive bending or post fabrication may cause cracking of the pretreatment and powder coating. Specifiers are advised to discuss post fabrication techniques with Dulux prior to commencing such fabrication.
- Please refer to the Duralloy Performance Warranty for conditions & limitations which effect the warranties described in this data sheet.

Performance Guide

Exterior Durability	Very good resistance to weathering.	Salt	Excellent salt spray resistance over pre-treated aluminium. (3000 hours ASTM B117)
Heat Resistance	Excellent resistance to 120°C continuous service conditions.	Water	Excellent resistance to 38°C/100% humidity for 1000 hours on pre-treated aluminium.
Solvent	Resistant to alcohol and white spirits.	Abrasion	Very good resistance to abrasion.
Acid	Resistant to spills of dilute acid. Avoid contact.	Alkali	Resistant to spills of dilute alkali. Avoid contact.

Typical Properties															
Gloss Level	30 98%	Coverage	Theoretical spreading rate at recommended film thickness: A												
Shelf Life	12 months when stored below 25°C/dry conditions.	V.O.C Level	Nil												
Colour	A range of stock and made to order solid & pearl colours.														
Meets GBCA VOC Requirement?	Yes. Dulux Powder Coatings: <ul style="list-style-type: none"> ▪ Contain no harmful volatile organic solvents ▪ Free of heavy metal pigments such as lead, cadmium, arsenic & mercury ▪ Proven low temperature curing technology ▪ Produced with stringent Safety, Health & Environmental policies and standards ▪ Developed with consideration of life cycle analysis, to guide our suppliers and the materials we use ▪ Manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place ▪ Produced and used with minimal waste Consequently, Dulux ® Powder Coatings are a prime consideration for projects where air quality standards have been set, such as 4, 5 & 6 Green Star Rating Projects.														
Film Build (microns)	Minimum 50 microns, Maximum 110 microns	Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.												
Application Method	Electrostatic Spray	Specific Gravity	1.52 - 1.59 @ colour												
Flexibility	Limited < or = 80 inch/lb Avoid post fabrication or refer to	Pencil Hardness	Min F												
Knoop Hardness	Min 15	Cross Hatch Adhesion	No removal Chemical												
Chemical Resistance	<table border="0" style="width: 100%;"> <tr> <td style="width: 15%;">Mortar</td> <td>Resistant</td> </tr> <tr> <td>White Sprits</td> <td>Resistant</td> </tr> <tr> <td>Ethanol</td> <td>Resistant</td> </tr> <tr> <td>Xylene</td> <td>Slight softening/limit contact</td> </tr> <tr> <td>Methyl Ethyl Ketone</td> <td>Softens/avoid contact</td> </tr> <tr> <td>Ethyl Acetate</td> <td>Softens/avoid contact</td> </tr> </table>			Mortar	Resistant	White Sprits	Resistant	Ethanol	Resistant	Xylene	Slight softening/limit contact	Methyl Ethyl Ketone	Softens/avoid contact	Ethyl Acetate	Softens/avoid contact
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Cure Schedule	Metal Temperature (°C)	Time (minutes)	Comments												
	210	4 mins													
	200	5 mins													
	180	8 mins													

Application Guide

Surface Preparation	<ul style="list-style-type: none"> ▪ Surfaces should be prepared according to AS1627.6-2003 Section 3 to achieve a conversion coating corresponding to Class 1. Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes: <ul style="list-style-type: none"> - Aluminium: Chrome chromate or green chromate/phosphate (refer AS1627.6-2003) - Ferrous metals: Abrasive blast (SA 2.5) / Zincshield™ powder primer (refer Zincshield™ Data Sheet), or Zinc phosphate or Iron phosphate (refer BS6497) - Zinc Coated Steels (eg. Galvanising): Zinc Phosphate or chromate (refer BS6497) - Stainless Steel: Suitable metal blast. Recommended maximum blast profile of 25 microns
Application Procedure And Equipment	<ul style="list-style-type: none"> ▪ 1a) For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble "simmering liquid". Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly. 1b) For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations. Box feeders are not suitable for the application of pearlescent and metallic finishes. 2) Apply by electrostatic spray. 3) Cure as per recommendations outlined above. <p>Metal temperatures in excess of 210°C should be avoided due to the possibility of colour change or thermal degradation of the polymer.</p> <p>4) Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.</p> <p>Electrostatic spray</p> <p>NOTES:</p> <ul style="list-style-type: none"> * Light colours may require a higher minimum film build for optimum coverage and colour consistency. <p>Theoretical spreading rate at recommended film thickness: A coverage rate of 8 - 10 sqm/kg corresponds to 80 microns cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.</p>

Care And Maintenance

As a general rule, cleaning of externally located powder coating surfaces must take place every six months. Where salts/pollutants are more prevalent such as seaside, industrial and geothermal areas, a cleaning program should be carried out more frequently.

THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

WARNING

In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes and will render the warranty void if used. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Ethyl Alcohol, Isopropanol.

Health And Safety

MSDS Number	10489	Safety Precautions	The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information. For detailed information, refer to product label and the current Chemical Data Sheet (No. 10489) is available through Sales and Customer Service Offices. Phone: Australia:- 13 24 99
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In the case of emergency, please call 1800 033 111

Transport And Storage

Package Weight	20 Kg	Shipment Name	Not dangerous goods. No special transport requirements.
Flash Point	N/A	UN Number	N/A
Dangerous Goods Class	N/A		

Disclaimer

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Please note that this document is only valid for 60 days from the date of issue.

DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton, Victoria 3168 AU ABN 67 000 049 427

Dulux Powder Coatings Duratec®

AU_DP01897

Product Code	900 Line
Approval	Meets and/or exceeds requirements of AAMA2604-10.

Description

Duratec® is a thermosetting TGIC free powder coating designed specifically for where colour and gloss retention are critical. Duratec® is formulated with advanced polyester resin technology and high performance pigments to conform with the performance requirements of AAMA2604-10. It has superior gloss and colour retention compared with standard polyester powder coatings. Duratec® is supported by a 20 year durability warranty* when applied by a Dulux Registered Applicator.

*Subject to the terms and conditions of the relevant product warranty. Please contact your local Dulux representative for further details.

Features And Benefits

- | | |
|--|---|
| <ul style="list-style-type: none"> ▪ 20 year durability warranty* ▪ Good flow out ▪ No solvents or emissions & TGIC free ▪ Tough polyester ▪ Guaranteed performance | <ul style="list-style-type: none"> ▪ Excellent colour retention ▪ Smooth film appearance ▪ Less waste and pollution to the environment & reduced risk to health ▪ Hard wearing/serviceable finish |
|--|---|

Uses

Duratec® is suitable for a variety of substrates where colour retention is desired.

Precautions And Limitations

Duratec® is only available in solid and pearl colours which meet Dulux Powder Coatings pigmentation criteria. Strong, bold colours may not necessarily meet these criteria and should be referred to Dulux Powder Coatings before specifying.

As a result of possible wide application variations and stoving conditions, some products and colours may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.

Matt products require higher temperature or longer cure duration than Gloss and Satin products, please refer to the cure schedules above.

For optimum performance ensure recommended dry film thickness is obtained. Some light colours require increased film thickness average to achieve optimal consistency.

Not recommended for components which are exposed to constant temperatures exceeding 120°C.

Not recommended for post-forming.

Performance Guide

Exterior Durability	Excellent resistance to weathering, providing extended protection for aluminium.	Salt	Excellent salt spray resistance over pre-treated aluminium. (3000 hours ASTM B117)
Heat Resistance	Excellent resistance to 120°C continuous service conditions.	Water	Excellent resistance to 38°C/100% humidity for 3000 hours on pre-treated aluminium.
Solvent	Resistant to alcohol and white spirits.	Abrasion	Excellent resistance to abrasion. Abrasion Coefficient > 20 (ASTM D968)
Acid	Resistant to spills of dilute acid. Avoid contact.	Alkali	Resistant to spills of dilute alkali. Avoid contact.

Typical Properties																						
Gloss Level	At 60° as required: Gloss: >80%, Satin: 60 - 80%		Coverage	8 - 10m ² /kg corresponds to 80 microns cured film thickness																		
Shelf Life	12 months when stored below 25°C/dry conditions		V.O.C Level	N/A																		
Colour	A range of stock and project specific colours.																					
Meets GBCA VOC Requirement?	<p>Yes. Dulux Powder Coatings:</p> <ul style="list-style-type: none"> ▪ Contain no harmful volatile organic solvents ▪ Free of heavy metal pigments such as lead, cadmium, arsenic & mercury ▪ Proven low temperature curing technology ▪ Produced with stringent Safety, Health & Environmental policies and standards ▪ Developed with consideration of life cycle analysis, to guide our suppliers and the materials we use ▪ Manufactured in facilities where significant energy and resources employed in production, are measured with aggressive reduction targets in place ▪ Produced and used with minimal waste <p>Consequently, Dulux® Powder Coatings are a prime consideration for projects where air quality standards have been set, such as 4, 5 & 6 Green Star Rating Projects.</p>																					
Film Build (microns)	Between 50- 110 microns		Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.																		
Application Method	Electrostatic Spray		Specific Gravity	1.3-1.5 @colour																		
Flexibility	Ltd <or= 80 inch/lb		Pencil Hardness	Min H																		
Knoop Hardness	Min 18		Cross Hatch Adhesion	No removal																		
Chemical Resistance	<table border="0"> <tr> <td>Motar</td> <td>Resistant</td> </tr> <tr> <td>White Spirits</td> <td>Resistant</td> </tr> <tr> <td>Ethanol</td> <td>Resistant</td> </tr> <tr> <td>Xylene</td> <td>Slight softening/limit contact</td> </tr> <tr> <td>Methyl Ethyl Ketone</td> <td>Softens/avoid contact</td> </tr> <tr> <td>Ethyl Acetate</td> <td>Softens/avoid contact</td> </tr> </table>			Motar	Resistant	White Spirits	Resistant	Ethanol	Resistant	Xylene	Slight softening/limit contact	Methyl Ethyl Ketone	Softens/avoid contact	Ethyl Acetate	Softens/avoid contact							
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180	15	Matt Products																				

Application Guide

Surface Preparation	<ul style="list-style-type: none"> • For Aluminium surfaces should be prepared according to AS1627.6-2003 Section 3 to achieve a conversion coating corresponding to Class 1. Chemical supplier recommendations should also be adhered to, as appropriate. Suitable pre-treatment includes: Aluminium - Chrome chromate (refer AS1627.6-2003 Section 3) For Mild Steel Mild steel contains less than 0.25% carbon. New mild steel surfaces should be inspected for millscale, rust, sharp edges, burr marks and welding flux, forming or machine oils, salts, chemical contamination or mortar splashes on them, all of which which must be removed. Sa 2½ Very thorough blast cleaning. When viewed without magnification, the surface shall be free from visible oil, grease and dirt, and shall be free from mill scale, rust, paint coatings and foreign matter. Any remaining contamination shall show only as slight stains in the form of spots or stripes and correspond to the prints designated Sa 2½ in AS 1627.9.
Application Procedure And Equipment	<ul style="list-style-type: none"> • 1 For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations. Box feeders are not suitable for the application of pearlescent & metallic finishes. 2 Apply by electrostatic spray. 3 Cure as per recommendations outlined above. Metal temperatures in excess of 210°C should be avoided due to the possibility of colour change or thermal degradation of the polymer. 4 Test for cure of the coating by contact with a drop of Corsol PGMA for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur. <p>Electrostatic spray. Light colours may require a higher minimum film build for optimum coverage and colour consistency. Theoretical spreading rate at recommended film thickness: A coverage rate of 8 - 10m²/kg corresponds to 80 microns cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.</p>

Care And Maintenance

Reference should be made to AAMA 609 & 610-02 standard for cleaning of surfaces. In broad terms, cleaning of externally located powder coating surfaces must take place every three months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.

THREE STEPS TO CLEANING POWDER COATED SURFACES

1. Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting).
2. Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits.
3. Always rinse after cleaning with fresh water to remove any remaining detergent.

WARNING:

In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes and will render the warranty void if used. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Ethyl Alcohol, Isopropanol.

Health And Safety

MSDS Number	13960128	Safety Precautions	The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information. For detailed information, refer to product label and the current Chemical Data Sheet (No. 13960128) available through Sales and Customer Service Offices. Phone: Australia: 13 24 99
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In the case of emergency, please call 1800 033 111

Transport And Storage

Package Weight	20 Kg	Shipment Name	Not dangerous goods. No special transport requirements.
Flash Point	N/A	UN Number	N/A
Dangerous Goods Class	N/A	Package Group	N/A

Disclaimer

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DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton, Victoria 3168 AU ABN 67 000 049 427

Product Datasheet



BU Powder Coatings Interpon D1000

AkzoNobel
Tomorrow's Answers Today

Product Description

Interpon D1000 is a new generation TGIC Free Polyester based powder coating formulated on AkzoNobel proprietary resin technology. **Interpon D1000** is designed for the exterior environment offering excellent long term light and weather resistance from a single coat finish on a variety of substrates. **Interpon D1000** exhibits a tougher cured film which provides superior damage resistance to packaging materials. **Interpon D1000** incorporates AkzoNobel patented Particle Management Technology providing outstanding powder application and enhanced recess penetration.

Interpon D1000 powder coatings are available in a wide range of colours in full gloss, satin and matt finishes and are designed to meet or exceed the performance requirements of AS3715-2002 and WANZ. Textured, pearlescent and other special effects can be custom matched to the users' requirements.

Powder properties*

Chemical type	Polyester
Particle size	Suitable for electrostatic spray
Specific gravity	1.2 - 1.7 depending on colours
Storage	Dry cool conditions (below 30°C)
Shelf Life	18 months
Sales code	G-Series
Stoving Schedule	10 mins at 180°C or 5 mins at 200°C or 4 mins at 210°C (Object temperature)

Typical specifications

AS3715, WANZ, AS4506, BS6496, BS6497, AAMA2603

Film properties

Mechanical, chemical and durability tests carried out on chromate conversion coated aluminium panels. All tests were performed on panels coated with 50 -70 microns of a gloss finish powder coating stoved for 10 minutes at 200°C (metal temperature).
Reduced gloss finishes may show lower values for mechanical performance.

Mechanical tests*

Flexibility	(Bend Test) AS1580 402.1	Pass 6mm
Adhesion	(2mm Crosshatch) AS1580 408.4	Classification 1 maximum
Cupping test	ISO 1520	Pass > 3mm
Pencil Hardness	AS1580 405.1	F - minimum
Reverse Impact	AS3715 Section 2.5.8	Pass 2.5Nm

Chemical Durability tests

Salt Spray	AS3715 Section 2.5.10	Pass 1000 hours - no corrosion creep more than 2mm from scribe
Humidity Resistance	AS3715 Section 2.5.7	Pass at 1000 hrs - no blistering or loss of adhesion
Distilled water immersion	BS3900-F7 at 40°C	Pass - no blistering or loss of gloss after 240 hours
Exterior durability	Excellent - pass AS3715 after 12 months continuous exposure with no film breakdown or reduction in protective properties.	
Colour stability	Excellent for continuous exposure up to 120°C.	

Interpon D1000 - Version 005
Issued: Jun 2013

AkzoNobel Coatings Ltd
686 Rosebank Road
Avondale Auckland 1007
New Zealand
Ph: 0800 801 342
Fax: 0800 809 679
Email: salesnz@interpon.com
Web: www.interpon.co.nz

AkzoNobel Pty Limited
51 McIntyre Road
Sunshine Victoria 3020
Australia
Ph: 1800 630 516
Fax: 1800 650 786
Email: salesoz@interpon.com
Web: www.interpon.com.au

Interpon
powder coatings
EVERY COLOR IS GREEN

Pre-treatment

For optimum coating performance the following pre-treatment is recommended prior to the application of **Interpon D1000**. The pre-treatment should be used in accordance with the supplier's recommendations.

A. Aluminium	Multistage chrome chromate or chrome phosphate
B. Galvanised Steel	Multistage zinc phosphate or chromate
C. Steel	Multistage zinc or iron phosphate

Application

Interpon D1000 powder coatings can be applied by manual or automatic electrostatic spray equipment. Unused or over-sprayed powder coating can be reclaimed and recycled through the coating system.

Additional Information

Product performance warranties are available with the **Interpon D1000** range through accredited applicators. For further information on the available warranties and the applicable terms and conditions, please contact your local AkzoNobel sales office.

AkzoNobel Pty Limited has a policy not to use lead or other heavy metal based pigments in our range of powder coatings. As a result of this policy, the use of bright and deep colours such as Yellows, Oranges and Reds are not recommended for severe outdoor exposure where long-term colour fastness is required.

Interpon D1000 powder coatings as supplied by AkzoNobel contain no organic solvents and can contribute toward satisfying the IEQ credits in the following Green Star® rating tools:

IEQ11 Office Interiors v1.1	IEQ8 Education v1
IEQ13 Office Design v2	IEQ8 Retail Centre v1
IEQ13 Office As-Built v2	IEQ8 Healthcare v1
IEQ8 Multi Unit Residential v1	IEQ8 Industrial v1

Note: Products are not reviewed or certified under the Green Star® rating system. Green Star® credit requirements cover the performance of materials in aggregate, not the performance of individual products or brands. For more information on Green Star®, visit www.gbca.org.au.



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 AkzoNobel has provided to its customer. If for any reason a copy of the relevant health and safety data sheet is not immediately available the user should contact AkzoNobel to obtain a copy before using the product. Minimum safety precautions in dealing with all powder coatings are as follows. All dusts are respiratory irritants. Therefore, inhalation of the dust or of the vapors resulting from the cure should be avoided. Take steps to prevent skin contact, but should contact occur, wash skin with soap and water. In case of eye contact flush immediately with clean water and seek medical advice. Dust clouds of any finely divided organic material can be ignited with an electric spark or open flame. Dust and powder should not be allowed to build up on surfaces or ledges. Dust collection equipment should be used which has provision for adequate explosion release. All equipment should be electrically earthed to prevent build up of static. Users are recommended to follow the guidelines laid down in AS3754:1990, "Safe Application of Powder Coatings by Electrostatic Spraying".

Disclaimer

Unless otherwise agreed by us in writing, any contract to purchase products referred to in this brochure and any advice which we give in connection with the supply of products are subject to our standard conditions of sale. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

* Typical minimum specifications. Performance may vary slightly between individual products.

*Interpon D1000 - Version 005
Issued: Jun 2013*

AkzoNobel Coatings Ltd
686 Rosebank Road
Avondale Auckland 1007
New Zealand
Ph: 0800 801 342
Fax: 0800 809 679
Email: salesnz@interpon.com
Web: www.interpon.co.nz

AkzoNobel Pty Limited
51 McIntyre Road
Sunshine Victoria 3020
Australia
Ph: 1800 630 516
Fax: 1800 650 786
Email: salesoz@interpon.com
Web: www.interpon.com.au

