

**Collection Elements
Copper**

Interpon 310

MW435E

The information given in this datasheet refers to the product **Copper** and should not be construed as referring to other products with in the same range.

Product Description: **Copper Interpon 310** is part of Collection Elements specially developed for industrial design.
Interpon 310 is a series of polyester resin based thermo-setting powder coatings, without TGIC. 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 : metal furniture, shop fittings, shelves, light fittings, ...

Powder Properties:	Chemical type	Polyester
	Density	1.51
	Storage	Dry cool conditions
	Shelf life	18 months at 30°C
		12 months at 35°C
	Stoving schedule (object temperature)	at 180°C : min 12 mn - max 24 mn
at 200°C : min 8 mn - max 16 mn		
at 210°C : min 4 mn - max 10 mn		

Coating :	Aspect	Large copper veins, black base Antique texture	
	Test conditions		
	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.		
	Substrate	0.5 mm steel	
	Pre-treatment	Zinc phosphate	
	Film thickness ISO2360	80 microns	
	Stoving	10 minutes at 200°C (object temperature)	
	Mechanical tests		
	Flexibility	ISO 1519	5 mm
	Adhesion	ISO 2409	Gt 0
	Impact	ISO 6272-1	1 kg 0.5 m
	Erichsen Cupping	ISO 1520	> 6 mm
	Chemical and durability test		
	Salt spray	ISO 7253	250 hr pass
	<i>Note test only relates to corrosion resistance</i>		
Constant humidity	ISO 6270	1000 hr pass	
<i>Note test only relates to corrosion resistance</i>			
Chemical resistance	See Post Application		

Industrial application conditions :

Pre-treatment
Aluminium, steel or Zintec surfaces must be clean and free from grease.
Iron phosphate and lightweight zinc phosphating of ferrous metals improves corrosion resistance.
Aluminium surfaces may require a suitable chromate conversion, chrome free pre-treatment or flash anodising for certain applications.
Galvanised steel may require zinc or chromate conversion or sweep blasting.
Detailed advice should be sought from the pre-treatment supplier

Recommended film thickness
80 - 100 microns
A good effect is linked with the recommended thickness.

Application

Copper can be applied by corona electrostatic or tribostatic equipment.

However the aspect obtained by tribostatic equipment may vary when compared to electrostatic application and/or our colour card.

In all application processes the aspect obtained is subject to variation, depending on the method of application (type of gun, nozzle, pot 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 in order to give a finish in accordance with our colour card.

The following procedure is given as a guideline when using these finishes :

We recommend the use of flat jet spray nozzles and a fluidised pot.

Using a pressurised pot or vibrating sieve may not produce a finish conforming to our colour card. To ensure powder homogeneity empty the boxes totally into the tray or feed hopper.

Only one spray run and one batch of powder should be used for components which are to be used in the same project.

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.

Recycling

Not recommended without the Technical Support of Akzo Nobel.

Curing

The aspect can deteriorate if the cure temperature rises too slowly. Care must be taken to ensure that the initial oven temperature is stable and correct and that the mass of metal introduced into the oven doesn't cause the temperature too drop beyond that required.

Post application :

Contact with Chemical Agents

Contact, even of 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.

Exposure to aggressive Environments

The presence of leafing metal particles makes this coating sensitive to aggressive environments (steam areas of high humidity) and sensitive to scratching and scuffing. In these instances protection by overcoating with a clearcoat is recommended.

When using a topcoat the application should be done immediately on the same site. The maximum allowable period between coats is 2 hours.

For further information please contact Akzo Nobel.

Safety Precautions :

Please consult the Material Safety Datasheet (PC010)

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.