

## Interpon D1094 HR Gloss

The information given in this datasheet is generic for the range **Interpon D1094 HR Gloss**. Specific products within the range can vary from the generic. For these products individual product datasheets are available

**Product Description:** **Interpon D1094 HR Gloss** is a range of powder coatings intended for use on architectural aluminium and galvanised steel.

Available in a wide stock range **Interpon D1094 HR Gloss** has been specifically formulated without the use of TGIC. As part of the **Interpon D** series of architectural powders, **Interpon D1094 HR Gloss** gives excellent exterior durability and colour retention and conforms with the requirements of all the major European architectural finishing standards.

All **Interpon D1094 HR Gloss** powders are formulated to meet fully the requirements of EN 12206 (formerly BS6496), BS6497:1984, Qualicoat Class 1 and GSB.

<b>Powder Properties:</b>	<b>Chemical type</b>	Polyester
	<b>Gloss</b>	85±5
	<b>Particle Size</b>	Suitable for electrostatic and tribostatic application
	<b>Specific gravity</b>	1.2-1.7 g/cm <sup>3</sup> depending on colour
	<b>Storage</b>	Dry cool conditions
	<b>Shelf life</b>	24 months below 30°C peak temperature 12 months below 35°C peak temperature
	<b>Sales Code</b>	R-series
	<b>Stoving schedule</b> (object temperature)	20 -40 minutes at 170°C 15 - 30minutes at 180°C 10 -25 minutes at 190°C 6-12 minutes at 200°C 4-8 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>Mechanical Tests:</b>	<b>Film Thickness</b>	60-80microns
	<b>Stoving</b>	6 minutes at 200°C (object temperature)
	<b>Adhesion</b>	ISO2409 Gt 0 (2mm Crosshatch)
	<b>Erichsen Cupping</b>	ISO1520 Pass >7mm
	<b>Hardness</b>	ISO2815 Minimum 80
<b>Chemical and Durability Tests:</b>	<b>Impact</b>	ASTM 2794 Pass 2.5 joules reverse and direct or 20 inch pounds
	<b>Flexibility</b>	ISO1519 Pass 3mm
	<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 or creep<1mm
	<b>Sulphur Dioxide</b>	ISO3231 Pass 30 cycles - no blistering, creep <1mm from scribe
	<b>Permeability</b>	Pressure Cooker EN12206-1:2004 Part 5.10 Pass - no defects after 1 hour (2 hours boiling water)

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<b>Chemical and Durability Tests: Cont</b>	<b>Chemical Resistance</b>		Generally good resistance to dilute acids, alkalis and oils at normal temperatures
	<b>Mortar Resistance</b>	EN12206-1:2004 Part 5.9	No effect after 24 hours
<b>Weathering Tests:</b>	<b>Exterior Durability</b>	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
	<b>Accelerated Weathering Test</b>	Suntest Original-Hanau-Quartzlampen ISO11341	50% Gloss retention after 1000 hours
		QUV B313	≥50% Gloss retention after 300 hours
	<b>Light Fastness</b>	DIN54004	Minimum 7

**Pretreatment:** For maximum protection it is essential to pretreat architectural components prior to the application of **Interpon D1094 HR Gloss**. 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 D1094 HR Gloss** 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 D1094 HR Gloss** can be applied by manual or automatic electrostatic spray or tribocharging equipment. For solid shades unused powder can be reclaimed using suitable equipment and recycled through the coating system. Detailed information and specific advice for special finishes is available upon request. Certain colours should be applied at higher film thickness to ensure coverage.

**Post Application:** For specific advice on the suitability of post coating processes such 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.

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