

Product Data Sheet

AkzoNobel Powder Coatings Interpon APA151 (FL151F)

Product Description

Interpon APA151 is a polyester-epoxy based **Anti-gassing** primer especially designed for direct application on substrates that are susceptible to out-gassing, such as Hot Dip Galvanized Steel, Metal spraying, Zamak, Cast steel and aluminium, brass, etc

Qualisteelcoat:

Metal spray up to C5M/C5I environments - mechanical pretreatment

Interpon APA151: approval P0034

Galvanized steel up to C5M/C5I environments – mechanical pretreatment

Interpon APA151: approval P0032

Powder Properties

Chemical type	Epoxy-Polyester
Aspect	Grey, smooth
Particle Size	Suitable for electrostatic spray only
Specific gravity	1,70 g/cm ³
Storage	Dry condition below 35°C
Shelf life	36 months
Stoving schedule	To match user's requirements
Gloss	50-70 units

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.

Substrate	Steel
Pretreatment	Solvent degreasing
Film Thickness	60-80 microns
Stoving Schedule (with TopCoat)	10 minutes at 200°C (system) <i>(Topcoat – Interpon D1036 Ral 9010 60-80 microns)</i>

Mechanical Tests

Flexibility	ISO1519:1973 (Cylindrical Mandrel)	Pass 5mm (APA mono-coat) Pass 5mm (System)
Adhesion	ISO2409-1992 (2mm crosshatch)	GT0 (BPP mono-coat) GT0 (System)
Erichsen Cupping	ISO1520	Pass 6mm (APA mono-coat) Pass 4mm (System)
Impact	ISO6272:1993	Pass 0.5 kg.m (APA mono-coat) Pass 0.2 kg.m (System)

Corrosion Tests on Hot Dip Galvanized Steel

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	Hot Dip Galvanized Steel
Pretreatment	Sweeping
Primer Thickness	60-100 microns

Stoving schedule (Primer)	10 minutes at 160°C	
Powder Topcoat	Interpon D1036 Ral 6005	
Stoving Schedule (system)	10 minutes at 200°C	
Neutral Salt Spray	ISO 9227 (1500h)	Adhesion GT0, no rust, no blistering

Pretreatment

Surface preparation depends upon the metal, the type of surface, its conditions and the required performance. Hereunder specification are given for C to C4 environment

Substrate	Mechanical pretreatment	Chemical pretreatment
Cast steel	Grit blasting SA 2.5 in accordance with ISO 8501.1, 1998 (F), roughness equivalent to B9a, B10a (Rz 35-65 microns; Ra 6-10 microns) using Rugotest n°3 LCA-CEA, in accordance with NFE 05051 (1981)	Degreasing & phosphating followed by passivation, DW rinsing and drying.
Zamak	Sweeping	Chromating or Phosphating or phosphochromating or Cromadex 903 liquid primer.
Cast aluminium		Degreasing & etching or Cromadex 903 liquid primer
Brass		Zinc phosphating
Hot dip galvanized steel	Sweeping with a maximum zinc layer thickness reduction of 5 to 10 µm depending on the initial zinc thickness	Zinc phosphating
Zinc sprayed	Light Sanding	Not recommended

Application

Interpon APP 151 is suitable for corona electrostatic spray and for tribo depending on the tribo equipment.

Recommended film thickness 60-80 µm

Recycling

Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% new powder should be used.

Curing

Interpon APA 151 shall be fully cured before application of the top coat.

	Object temperature	APA 151	
		Mini	Max
Stoving Schedule	160°C	10'	60'
	180°C	7'	40'
	200°C	5'	30'

Interpon APA 151

Topcoat Application	To ensure optimal results, Interpon APA 151 should be overcoated within 24 hours after its application. Top coat should in any case be applied within a period not exceeding one week after APA 151 has been cured. To ensure optimum performance, the system APA 151 + topcoat should be fully curing according to the topcoat stoving recommendations.
Damage repair	<p>Any damage to Interpon APA 151 system must be repaired as soon as possible.</p> <p>Surface preparation Damaged areas must be clean and free of grease or rust. Dry-sand the area with 600 grade paper down to the substrate. The area must be completely free of dust and cleaned with a non-aggressive solvent before proceeding.</p> <p>Application For repairs a Cromadex PU (2K or 1K) liquid paint is recommended.</p>
Safety Precautions	Please consult the Material Safety Datasheet (MSDS)
Disclaimer	<p>IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data 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. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.</p> <p>Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel</p>

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