

# Product Datasheet



Powder Coatings

**AkzoNobel**  
 Tomorrow's Answers Today

## 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 Metal spraying, Zamak, Cast steel and aluminium, Zinc electro-plated steel and Hot-dip galvanised steel.

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

<b>Substrate</b>	Steel
<b>Pretreatment</b>	Solvent degreasing
<b>Primer Thickness</b>	60-80 microns
<b>Stoving schedule (With topcoat)</b>	10 minutes at 200°C (system) (Topcoat – Interpon D1036 Ral 9010 60-80 microns)

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

**Corrosion Tests on Hot Dip Galvanised 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.

<b>Substrate</b>	Hot Dip Galvanized Steel	
<b>Pre-treatment</b>	Sweeping	
<b>Primer Thickness</b>	60-100 microns	
<b>Stoving schedule (Primer)</b>	10 minutes at 160°C	
<b>Powder Topcoat</b>	Interpon D1036 Ral 6005	
<b>Stoving Schedule (System)</b>	10 minutes at 200°C	
<b>Neutral Salt Spray</b>	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 Phostphating or

Interpon APA 151  
Appendix 2

Cast aluminium		phosphochromating or <b>Cromadex 903</b> liquid primer.
Brass		Degreasing & etching or <b>Cromadex 903</b> liquid primer
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.

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

**Topcoat Application** To ensure optimal results, **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** Any damage to **Interpon APA 151** system must be repaired as soon as possible.

**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.

**Application**  
 For repairs a **Cromadex** PU (2K or 1K) liquid paint is recommended.

**Safety Precautions** Please consult the Material Safety Datasheet (MSDS)

**FOR PROFESSIONAL USE ONLY**

**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 advice 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 datasheet 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 datasheet is current prior to using the product.

Brand names mention