

## Technical Data Sheet

### intercoat series 460

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**thermosetting powder coating  
epoxy  
zinc-rich primer**

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### Product description

Epoxy paints for interior use Intercoat 460. Compared to polyester paints, epoxy paints have improved anti-corrosion properties and increased chemical resistance. They are characterized as mechanically strong, moisture resistant, have good resistance to solvents, alkalis, lubricants and good adhesion.

### Typical application

This material features good anti-corrosion properties. It is used as a primer for painting metal surfaces pre-treated with spray cleaning, when the item to be painted is exposed to a severe corrosion load.

### Product details

- Packages: carton with antistatic PE bag liner, 20 kg, 25 kg or Big Bag for approx. 500 kg, net
- Storage Stability: min 24 month from manufacture (see printed date on product label)
- Storage temperature: < 25°C
- Moisture: < 80%
- Specific Gravity (ISO 8130-2): 1.70-1.80 g/cm<sup>3</sup> depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): good 120-140 points
- Particle size distribution (ISO 8130-13):
  - O fine fraction up to 10 µm in size: < 10%
  - O base fraction up to 32 µm in size: 25-45%



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## Gloss level

- Primer: 70–100\*

\* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings).

## Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel. Actual product performance may vary due to product specific properties such as gloss, color, effect and finish as well as application related and environmental influences.

Test method	Test	Smooth gloss
<b>ISO 2360</b>	film thickness recommended	60-150 µm
<b>ISO 2409</b>	cross cut test/adhesion 1mm cutting distance	GT 0
<b>ISO 1519</b>	mandrel bending test cracking of coating	≤4 mm
<b>ISO 2815</b>	impression hardness	≥87
<b>ISO 3668</b>	coating color, deviation	≤1
<b>ISO 6272</b>	ball impact test cracking of coating	No cracks
<b>ASTM D 2371</b>	mass fraction of zinc pigment	no more 38%
<b>ISO 6270-1</b>	determination of resistance to humidity 1000 h	≤1 mm
<b>ISO 9227</b>	salt spray test 1000 h	≤1 mm

## Processing

Corona, Tribostatic\*

\* Available upon inquire.



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## Pretreatments

Before the painting, the item should be adequately pretreated in accordance with surface type, final use and required performances. The following table can be used as starting point for the pretreatment choice. The surface shall be clean, dry and appear with a rough and dull profile.

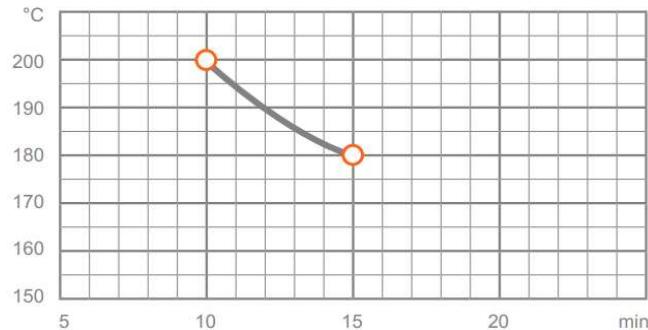
Substrat	Indoor use
Aluminium	soil removal, chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting
Zinc coated steel	acid attack, iron phosphate, chromate

Oxides (rust) cleaning and de-greasing shall be carried out when the simplified process is used! The simplified pre-treatment does not ensure necessary protective properties and decreases the service life of the coating. Hot-dip galvanized steel requires additional mechanical processing (incision).

## Cure parameters

Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing



Please observe cure parameters closely since mechanical properties will develop before full cross-linking!

To obtain optimal stoving conditions you are recommended to carry out practical trials, adapted to the object in question and the stoving oven each time. Temperature conditions of curing for each powder are listed on the label. Our technical service department will be glad to advise you.

The curing mode schedule can be set by agreement with the consumer.



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## Note

The data is provided for informational purposes and is not exhaustive. Any purchaser using the product other than as specified in this data sheet assumes responsibility for the results obtained. As the manufacturer, we provide a more accurate description of the product, conditions of use and all related factors of the application process. Because direct control by us cannot be exercised over compliance with the above conditions, without further written agreement, we make no warranty and assume no liability for the use of the product and the results obtained.



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