

Technical Data Sheets

All Intercoat powder coating series in one file — product description, typical application, technical parameters and application data.

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Issue 08/2026. Each data sheet in this file is reproduced as issued for the series named on its first page. Before specification or production approval, check that the revision you hold is the current one at intercoat.eu/documentation, where every series is also available as a separate file. Safety information is given in the safety data sheet, not here.

Technical Data Sheet

INTERCOAT series 420

thermosetting powder coating for outdoor use
polyester
smooth gloss | semi - gloss | smooth matt | semi - matt
rough gloss structure | rough matt structure | fine texture

Product description

Thermosetting powder coatings, formulated without TGIC both outdoor and indoor use. The curing coatings **Intercoat 420** paints for protective and decorative coatings on various metal surfaces. It has moderate physical-mechanical properties and moderate quality of coating surface.

Typical application

The **Intercoat 420** powder coating is designed for application on aluminum extrusion and sheets, steel and galvanized substrates, architectural aluminum profiles and facades.

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): smooth 1.50-1.65 g/cm³
- rough structure/fine texture 1.50-1.80 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): good 120-140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 6%
 - base fraction up to 32 µm in size: 25-45%

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				Fine texture	Rough structure	
		Gloss	Semi -gloss	Matt	Semi -matt		Gloss	Matt
ISO 2360	film thickness recommended	60-80 µm	60-80 µm	60-80 µm	60-80 µm	70-90 µm	80-100 µm	80-100 µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤5mm	≤5mm	≤6mm	≤6mm	≤10mm	≤10mm	≤25mm
ISO 2815	impression hardness	≥87	≥87	≥87	≥87	-	-	-

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intercoat
Powder coating

ISO 3668	coating color, deviation	≤3	≤3	≤3	≤3	≤3	≤3	≤3
ISO 6272	ball impact test cracking of coating	No cracks	No cracks	Cracks	Minor cracks	Cracks	Cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000 h	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm
ISO 9227	salt spray test 1000 h	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm

Gloss level

- Smooth gloss 75-100*
- Semi – gloss 60-75*
- Smooth matt 10-40*
- Semi – matt 40-60*
- Rough gloss structure: visual comparison
- Rough matt structure: visual comparison
- Rough matt structure: visual comparison

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

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer

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.

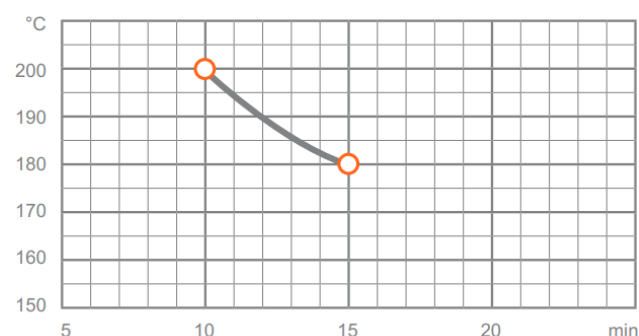
Substrat	Indoor use	Outdoor use
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting
Zinc coated steel	acid attack, iron phosphate, chromate	acid attack, zinc phosphate, chromate

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

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Technical Data Sheet

INTERCOAT series 440

thermosetting powder coating for outdoor use
polyester
low temperature cure (LT)
smooth gloss | rough gloss structure | fine texture

Product description

Thermosetting powder coatings, formulated without TGIC especially for both outdoor and indoor use. The curing coatings **Intercoat 440** offers good weather resistance, mechanical properties and good quality of coating surface. The low temperature coatings can be cured from 150-170 °C thereby offering energy saving during the cure process

Typical application

The **Intercoat 440** powder coating is designed for use in the construction industry, various road safety elements. Resistant to various external influences, high temperatures, chemical solvents, gives an attractive appearance of the coating. Typical application **Intercoat 440**: articles for garden, car accessories, cycles and motorbikes parts, agricultural machinery and domestic items.

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): smooth 1.50-1.65 g/cm³
- rough structure/fine texture 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): excellent ≥140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 5%
 - base fraction up to 32 µm in size: 25-45%

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	Fine texture	Rough gloss structure
ISO 2360	film thickness recommended	60-80µm	70-90µm	80-100µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0

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intercoat
Powder coating

ISO 1519	mandrel bending test cracking of coating	≤5mm	≤12mm	≤12mm
ISO 2815	impression hardness	≥87	-	-
ISO 3668	coating color, deviation	≤1	≤1	≤1
ISO 6272	ball impact test cracking of coating	No cracks	Cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000 h	≤1 mm	≤1 mm	≤1 mm
ISO 9227	salt spray test 1000h	≤1 mm	≤1 mm	≤1 mm

Gloss level

- Smooth gloss 75-100*
- Fine texture: visual comparison
- Rough gloss structure: visual comparison

* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings). The gloss index can be set by agreement with the consumer. Gloss of coating parameters other than indicated in the table can be agreed with the customer.

Processing

Corona, Tribostatic*
 * Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.
 * Color of coating parameters other than indicated in the table can be agreed with the customer

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

10-12°C 160 min

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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Technical Data Sheet

INTERCOAT series 460

thermosetting powder coating
epoxy
zinc-rich primer

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/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): good 120-140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 10%
 - base fraction up to 32 µm in size: 25-45%

Gloss level

- Primer: 70–100*

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

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

Processing

Corona, Tribostatic*

* Available upon inquire.

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).

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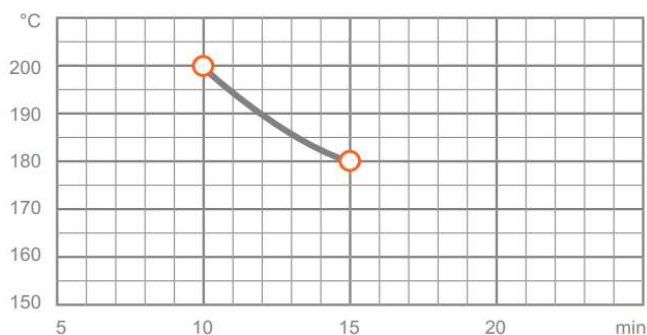
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Cure parameters

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.

Note

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Technical Data Sheet

INTERCOAT series 490

thermosetting powder coating for outdoor use

polyester

smooth gloss | smooth matt | fine texture | anodized effect | antique | hammertone

Product description

Intercoat 490 weather-resistant polyester paints with special surface effects. Exterior paints reflect trends and are designed to suit the end product's application. Recommended for achieving an aesthetic appearance of products for use in open areas.

Typical application

Intercoat 490 used for exterior and interior works. UV, weather, temperature, acid and detergent resistant, high level of covering power, excellent decorative effect.

Product details

- Packages: carton with antistatic PE bag liner, 20 kg, 25 kg or Big Bag for approx. 500 kg, net
- Storage Stability: min 6 month from manufacture (see printed date on product label)
- Storage temperature: <25°C
- Moisture: <80%
- Specific Gravity (ISO 8130-2): smooth 1.70-1.80 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): <0.4%
- Fluidization (ISO 8130-5): good 120 - 140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: <6%
 - base fraction up to 32 µm in size: 25-45%

Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel.

Test method	Test	Gloss	Matt	Fine	Anodized	Antique	Hammer
ISO 2360	film thickness recommended	60-80µm	60-80µm	70-90µm	70-90µm	100-150µm	100-180µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤10mm	≤10mm	≤10mm	≤10mm	≤32mm	-
ISO 2815	impression hardness	≥87	≥87	-	≥87	-	-
ISO 3668	coating color, deviation	≤1	≤1	≤1	≤1	≤1	≤1

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intercoat
Powder coating

ISO 6272	ball impact test cracking of coating	No cracks	Minor cracks	Cracks	No cracks	Cracks	Cracks
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Gloss level

N/D* (visual comparison)

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

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer

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.

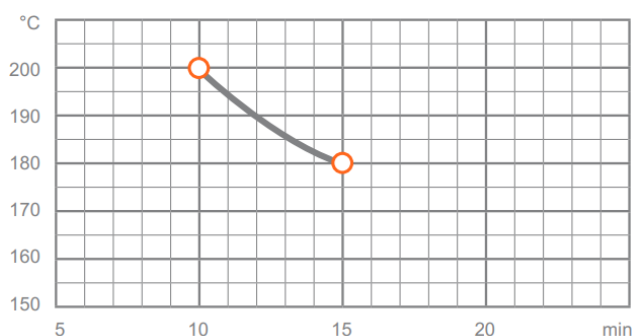
Substrat	Indoor use	Outdoor use	Architecture
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting	-
Zinc coated steel	acid attack, iron phosphate, chromate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

Note

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Technical Data Sheet

INTERCOAT series 500

thermosetting powder coating architectural application
polyester
smooth gloss | semi - gloss | smooth matt | semi - matt
rough gloss structure | fine texture

Product description

Thermosetting powder coatings, formulated without TGIC especially for architectural (both outdoor and indoor) use. The curing coatings **Intercoat 500** offers good weather resistance, mechanical properties, resistance to UV, reduced consumption and good quality of coating surface. Recommended for outdoor use under standard conditions.

Typical application

The **Intercoat 500** powder coating is designed for application on aluminum extrusion and sheets, steel and galvanized substrates, architectural aluminum profiles and facades.

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): smooth 1.50-1.65 g/cm³
- rough structure/fine texture 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): excellent ≥140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 5%
 - base fraction up to 32 µm in size: 25-45%

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				Fine texture	Rough gloss structure
		Gloss	Semi -gloss	Matt	Semi -matt		
ISO 2360	film thickness recommended	60-80µm	60-80µm	60-80µm	60-80µm	70-90µm	80-100µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤3mm	≤4mm	≤5mm	≤6mm	≤10mm	≤10mm

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intercoat
Powder coating

ISO 2815	impression hardness	≥87	≥87	≥87	≥87	-	-
ISO 3668	coating color, deviation	≤1	≤1	≤1	≤1	≤1	≤1
ISO 6272	ball impact test cracking of coating	No cracks	No cracks	No cracks	Minor cracks	Cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000 h	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm
ISO 9227	salt spray test 1000h	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm	≤1 mm

Gloss level

- Smooth gloss 75-100*
- Semi – gloss 60-75*
- Smooth matt 10-40*
- Semi – matt 40-60*
- Rough gloss structure: visual comparison
- Fine texture: visual comparison

* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings). The gloss index can be set by agreement with the consumer. Gloss of coating parameters other than indicated in the table can be agreed with the customer.

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer

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

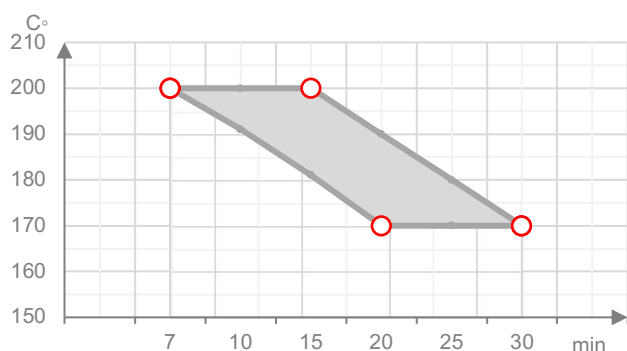
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Cure parameters

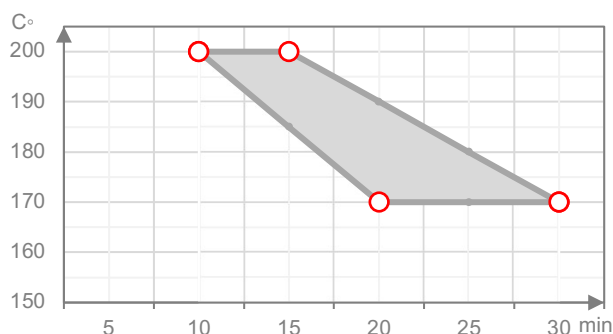
Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing

smooth gloss | smooth matt



fine texture



Contact:

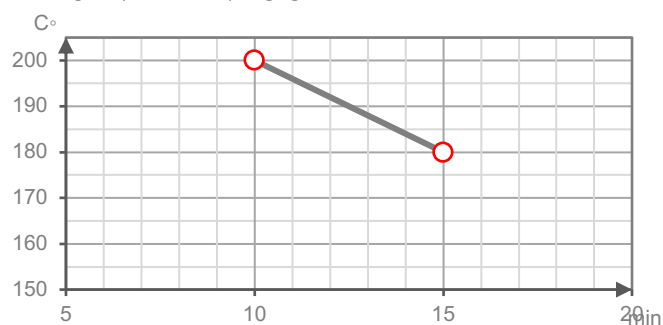
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intercoat
Powder coating

semi - gloss | semi - matt | rough gloss structure



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

INTERCOAT series 700

thermosetting powder coating for outdoor use

polyester

smooth gloss | smooth matt | fine texture | anodized effect | antique | chrome metallic

Product description

Intercoat 700 - premium series of bonded polyester paints for outdoor use.

Collection of premium powder coatings "BONDALUX", produced using bonding technology for outdoor use. Powder coatings produced using bonding technology have a number of advantages:

- Unique metallic effect
- Uniform and constant decorative properties
- Saving up to 30% powder
- Increased atmospheric resistance of the coating.

Typical application

Intercoat 700 is used for painting objects where good weather resistance and improved appearance are required. It has increased performance properties and rich color.

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): smooth 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): good 120 - 140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 6%
 - base fraction up to 32 µm in size: 25-45%

Test results

Checked under laboratory conditions on a chromated 0.8 mm thick aluminium test panel.

Test method	Test	Gloss	Matt	Fine	Anodized	Antique	Chrome
ISO 2360	film thickness recommended	60-80µm	60-80µm	70-90µm	70-90µm	100-150µm	60-80µm

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Powder coating

ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤10mm	≤10mm	≤10mm	≤10mm	≤32mm	≤10mm
ISO 3668	coating color, deviation	≤1	≤1	≤1	≤1	≤1	≤1
ISO 6272	ball impact test cracking of coating	No cracks	Minor cracks	Cracks	No cracks	Cracks	No cracks

Gloss level

N/D* (visual comparison)

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

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer

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.

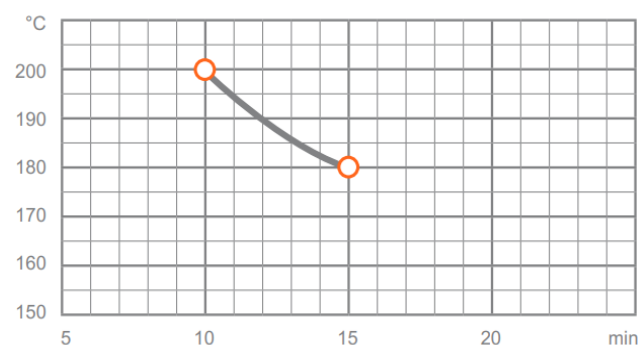
Substrat	Indoor use	Outdoor use	Architecture
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting	-
Zinc coated steel	acid attack, iron phosphate, chromate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

Our technical service department will be glad to advise you.

Contact:

+ 372 655 10 10
Intercoat.ee
Email: info@intercoat.ee

Bank details:

WISE
BIC: TRWIBEB1XXX
IBAN: BE60 9676 9925 4370

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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Technical Data Sheet

INTERCOAT series 900

thermosetting powder coating architectural application
polyester
smooth gloss | smooth matt | fine texture

Product description

Polyester paints **Intercoat 900** for architectural (exterior) applications - Qualicoat 1. High quality paints for architectural and construction applications. It has the highest mechanical strength, resistance to UV and weathering and overheating, high physical and mechanical properties and reduced consumption. Polyester powder paint is most often used in industrial production for painting metal structures and parts. It is recommended for painting architectural systems for ultra-long term weathering applications. Qualicoat class 1 approval.

Typical application

The **Intercoat 900** powder coating is designed for application on aluminum extrusion and sheets, steel and galvanized substrates, architectural aluminum profiles and facades.

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): smooth 1.50-1.65 g/cm³
- fine texture 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): excellent ≥ 140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 μm in size: < 5%
 - base fraction up to 32 μm in size: 25-45%

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	Smooth matt	Fine texture
ISO 2360	film thickness recommended	60-80 μm	60-80 μm	70-90 μm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0

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intercoat
Powder coating

ISO 1519	mandrel bending test cracking of coating	≤3mm	≤5mm	≤10mm
ISO 2815	impression hardness	≥95	≥95	-
ISO 3668	coating color, deviation	≤1	≤1	≤1
ISO 6272	ball impact test cracking of coating	No cracks	No cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000 h	≤1mm	≤1mm	≤1mm
ISO 9227	salt spray test 1000h	≤1mm	≤1mm	≤1mm

Gloss level

- Smooth gloss 75-100*
- Smooth matt 10-40*
- Fine texture: visual comparison

* Gloss level acc. to DIN EN ISO 2813/60° angle (doesn't apply to metallic effect powder coatings). The gloss index can be set by agreement with the consumer. Gloss of coating parameters other than indicated in the table can be agreed with the customer.

Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

* Color of coating parameters other than indicated in the table can be agreed with the customer

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

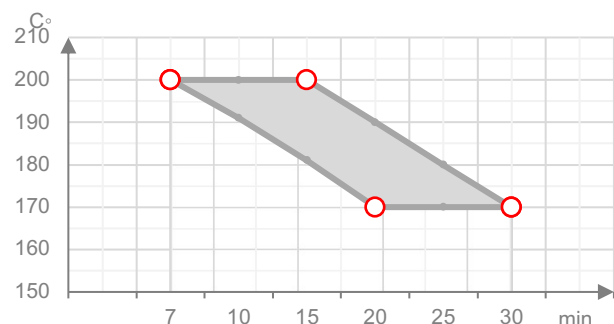
Oxides (rust) cleaning and de-greasing shall be carried out when the simplified process is used! The simplified pre-treatment does not ensure necessary protective properties and decreases the service life of the coating. Hot-dip galvanized steel requires additional mechanical processing (incision).

Cure parameters

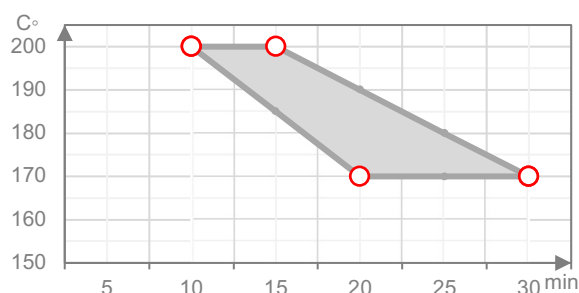
Temperature and time combinations resulting in the optimal cross-linking of the coating.

Typical curing

smooth gloss | smooth matt



fine texture



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intercoat
Powder coating

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Technical Data Sheet

INTERCOAT series 910

thermosetting powder coating architectural application
polyester
smooth gloss | smooth matt | fine texture

Product description

Polyester paints **Intercoat 910** for architectural (exterior) applications - Qualicoat 2.

High quality paints for architectural and construction applications. It has the highest mechanical strength, resistance to UV and weathering and overheating, high physical and mechanical properties and reduced consumption. Polyester powder paint is most often used in industrial production for painting metal structures and parts. It is recommended for painting architectural systems for ultra-long term weathering applications. Qualicoat class 2 approval.

Typical application

The **Intercoat 910** powder coating is designed for application on aluminum extrusion and sheets, steel and galvanized substrates, architectural aluminum profiles and facades.

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): smooth 1.50-1.65 g/cm³
- fine texture 1.50-1.75 g/cm³ depending on pigmentation
- Moisture content (ISO 8130-7): < 0.4%
- Fluidization (ISO 8130-5): excellent ≥140 points
- Particle size distribution (ISO 8130-13):
 - fine fraction up to 10 µm in size: < 5%
 - base fraction up to 32 µm in size: 25-45%

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	Smooth matt	Fine texture
ISO 2360	film thickness recommended	60-80µm	60-80µm	70-90µm
ISO 2409	cross cut test/adhesion 1mm cutting distance	GT 0	GT 0	GT 0
ISO 1519	mandrel bending test cracking of coating	≤3mm	≤5mm	≤10mm
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intercoat
 Powder coating

ISO 3668	coating color, deviation	≤1	≤1	≤1
ISO 6272	ball impact test cracking of coating	No cracks	No cracks	Cracks
ISO 6270-1	determination of resistance to humidity 1000 h	≤1 mm	≤1 mm	≤1 mm
ISO 9227	salt spray test 1000 h	≤1 mm	≤1 mm	≤1 mm

Gloss level

- Smooth gloss 75-100*
- Smooth matt 10-40*
- Fine texture: visual comparison

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Processing

Corona, Tribostatic*

* Available upon inquire.

Color shades

Mainly RAL shades; also, special domestic shades on request*.

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Pretreatments

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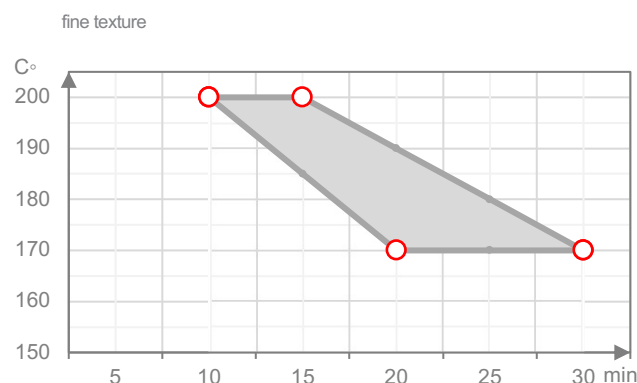
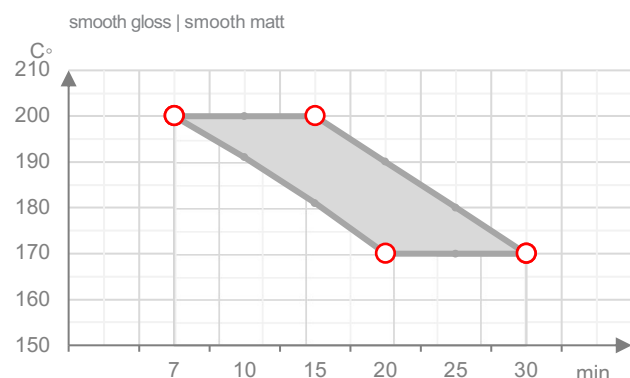
Substrat	Indoor use	Outdoor use	Architecture
Aluminium	soil removal, chromate, chrome-free	chromate, chrome-free	chromate, chrome-free
Steel	soil removal, iron phosphate, zinc phosphate, sand-blasting	iron phosphate, zinc phosphate, sand-blasting	-
Zinc coated steel	acid attack, iron phosphate, chromate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



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