

Recommended maintenance cycles:

COASTAL 2000 to 5000 meters from the coast - 3 MONTHS

INLAND - 6 MONTHS

Correct cleaning and maintenance regimes can improve the expected lifespan:

- Cleaning should start at the time the products are installed, ensuring that construction materials such as concrete, plaster and paint splashes are removed before they have a chance to dry. Failure to remove these materials at this early stage will require the use of aggressive cleaning materials and techniques with potential damage to the powder coated surface.
(Consult a sales representative)
- The best method of cleaning of powder coated products is by regular washing of the coating using a solution of warm water and non-abrasive, pH neutral detergent solution. Surfaces should be thoroughly rinsed after cleaning to remove all residues. All surfaces should be cleaned using a soft cloth or sponge or nothing harsher than a soft natural bristle brush. Cleaning of powder coated sections can be conveniently carried out at the same time as window cleaning
- Mechanical components are to be lubricated with a reputable silicone based lube spray.

MAINTENANCE

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Interpon[®]
POWDER COATINGS

AkzoNobel

Interpon D Cleaning and Maintenance Guidelines

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Maintaining the good looks of your powder coated products is just like caring for your car

– and is a smart way to protect your investment.

Over time with exposure to the elements, powder coatings may show signs of weathering such as loss of gloss, chalking and slight colour change. A simple regular clean will minimise the effects of weathering and will remove dirt, grime and other build-up detrimental to all powder coatings.

Cleaning coated surfaces

Cleaning should start at the time the products are installed, ensuring that construction materials such as concrete, plaster and paint splashes are removed before they have a chance to dry. Failure to remove these materials at this early stage will require the use of aggressive cleaning materials and techniques with potential damage to the powder coated surface.

Method

The best method of cleaning of Interpon D products is by regular washing of the coating using a solution of warm water and non-abrasive, pH neutral detergent solution. Surfaces should be thoroughly rinsed after cleaning to remove all residues. All surfaces should be cleaned using a soft cloth or sponge or nothing harsher than a soft natural bristle brush. Cleaning of powder coated sections can be conveniently carried out at the same time as window cleaning.

If the project is subject to any hazardous unusual environmental factors, or is close to salt water, an estuary or marine environments then Akzo Nobel must be consulted on an individual project basis.

Renovation can be required in the case of heavy soiling (due to lack of maintenance). It is then recommended to consult a specialized company.

Cleaning products

Before cleaning, attention must, without exception be paid to the cleaning agent's datasheet and the applicable guidelines of the various associations:

- GRM
- Qualicare
- AMRAL

Usual maintenance can be done using water with mild detergent (pH 5 to 8).

If the atmospheric pollution has resulted in heavy soiling of the coating, some stains or marks may require stronger domestic products. In such cases, they should always be diluted, and small inconspicuous test areas cleaned first.

In no circumstance should any abrasive cleaner or polish, or any cleaner containing ketones, esters be used.



The frequency of such cleaning will depend on many factors, including:

- Geographical location of the building.
- The environment surrounding the building, i.e., marine, swimming pool, industrial, or a combination of these environments etc.
- Levels of atmospheric pollution
- Prevailing wind
- Protection of the building by other buildings
- Possibility of airborne debris (e.g., sand/dust etc.) causing erosive wear of the coating.
- If the environmental circumstances change during the lifetime of the building (e.g. rural becomes industrial)
- The powder coating chemistry

The frequency of cleaning depends in part on the standard of appearance that is required and also the requirements to remove deposits, which could, during prolonged contact with either the powder film or the metal substrate, (if exposed) cause damage.

Sheltered areas can be more at risk of coating degradation than exposed areas. This is because wind-blown salt and other pollutants may adhere to the surface and will not be cleaned away with rainfall. These areas should be inspected and cleaned if necessary on a more regular basis.

Records of all cleaning schedules and frequencies shall be kept and maintained and made available to Akzo Nobel if requested.

The Akzo Nobel cleaning frequency specifications are shown below.

Global Cleaning Recommendation

Climate		Temperate and Arid			Tropical		
Environment		D1000 series	D2000 series	D3000 series	D1000 series	D2000 series	D3000 series
Normal - C3 Inland		12 months	18 months	24 months	9 months	15 months	18 months
Marine - C4 Coastal	2000 to 5000m from coastline	12 months	18 months	24 months	9 months	15 months	18 months
	500 to 2000m from coastline	6 months	9 months	12 months	6 months	6 months	9 months
	50 to 500m from coastline	3 months	6 months	9 months	3 months	3 months	3 months
	< 50m from coastline	Not available	Not available	Not available	Not available	Not available	Not available
Industrial - C5I	2000 to 5000m from source of pollution	12 months	18 months	24 months	9 months	15 months	18 months
	500 to 2000m from source of pollution	6 months	9 months	12 months	6 months	6 months	9 months
	50 to 500m from source of pollution	3 months	6 months	9 months	3 months	3 months	6 months
	Less than 50m from source of pollution	Not available	Not available	Not available	Not available	Not available	Not available
Swimming Pool	Greater than 2m from edge of pool	3 months	3 months	3 months	3 months	3 months	3 months
	2m from edge of pool	Not available	Not available	Not available	Not available	Not available	Not available

Type of Climate	Temperature Range	Temperature Range Highest Temperature with RH ≥95%
Temperate	-33OC to 35OC	25OC
Arid		
Warm Arid	-20OC to 40OC	27OC
Extremely Warm Arid	3OC to 55OC	28OC
Tropical	5OC to 40OC	33OC

For more detailed definitions of environment and climate please refer to ISO9223

Cleaning of Brick and Concrete

Chemical Cleaners

The cleaning solutions used on both brick and concrete contain strong chemicals that can cause damage to the powder-coated surface. All exposed powder-coated surfaces should be fully protected.

If any such solutions or chemicals come in contact with the powder-coated surface, wash immediately with copious amounts of water.

Prolonged exposure can cause discolouration of the film, loss of gloss and damage to the coating surface.

Abrasive Blasting

The cleaning of concrete or brick by using abrasive shot blasting must be carried out in such a way that all structures coated with powder coating must be fully protected.

The abrasive medium will strip the powder coating from the metal substrate.

Only protective tape with a low tack and approved by the suppliers of the protective tape for use on Powder Coatings should be used.

Low Tack Tapes

These tape should be removed after a period not exceeding six (6) months. If further protection is required new tape should be applied.

Any residue from the tape should be removed as soon as possible.

Do not use scrapers, abrasive papers or similar items to clean the area as this may damage the surface of the powder coating.

Water and a small amount of mild detergent may be used to clean the surface of the powder coating.

Where it is absolutely necessary a small amount of white spirit may be used followed by cleaning with water and mild detergent.

WARNING: Do not under any circumstances use strong solvents or solutions containing: Chlorinated Hydrocarbons, Esters, Ketones or abrasive cleaner or polish



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Powder Coatings by AkzoNobel



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 or speak to your local representative.

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Architectural Powder Coatings

Interpon D Repair Procedure - Guidance Note ZA

August 2020

Introduction

Coatings can get damaged during fabrication, shipping and installation, and then require repairs onsite. The powder coatings can be repaired with a suitable spray on or brush on liquid, depending on the area to be repaired.

NB! Any repair will age / weather at a different rate compared to the powder coated surface. This will become more noticeable as the coating ages.

For AAMA2603 and 2604 / Qualicoat Class 1 or 2 systems:

For onsite rectification of small damaged areas, **Sikkens Autocryl**, matched for colour and gloss, to the appropriate Interpon D shade, should be used. Where damage has exposed the aluminium substrate only the exposed aluminium should be primed with **Sikkens Washprimer 1K**. Please read the relevant data sheet for thinning ratios and drying times.

1. Minimum requirements to repair small isolated areas (approx. 5 6cm) and scratch damage.

- a. Using a clean lint free cloth, liberally apply **Sikkens Degreaser** or equivalent to clean all surfaces to be painted, then wipe dry using a lint free cloth to physically remove all sealants and mastics etc.
- b. Abrade all areas to be coated with 220 – 320 grit wet & dry type sandpaper to ensure a suitably keyed surface. Wipe clean using lint free tac rags.
- c. Apply a single coat of **Sikkens Washprimer 1K**, to exposed metal surfaces only and allow to dry. The wash primer will provide good adhesion onto the substrate
- d. Apply a coat of **Sikkens Autocryl**, matched to shade and gloss. Please read the relevant data sheet for mixing/ thinning ratios and drying times.

Very small scratches can be touched up using a brush, for any larger repairs only spray application is recommended.

2. Minimum requirements to repair larger areas of damage.

- a. Mask all surrounding surfaces of the damaged areas, to the edge of the panel, or a suitable break line.
- b. Using a clean lint free cloth, liberally apply **Sikkens Degreaser** or equivalent to clean all surfaces to be painted, then wipe dry using a lint free cloth to physically remove all sealants and mastics etc.
- c. Mechanically abrade to sound substrate. Drilled holes to be countersunk and butt joints to be filled. The surface should taper on the side for filling.
- d. Abrade areas to receive filling media mechanically or by hand, using 60/80 abrasive paper.
- e. Clean areas to be filled with vacuum or compressed air.
- f. Mix the components of the **Sikkens Polykit** filling media or equivalent as specified in the manufacturers recommendations and apply directly to the substrate. Work the material to remove any trapped air and finish to profile shape. Allow to cure fully as per manufacturer's instructions.
- g. Abrade with 80 abrasive paper to correct profile, either by hand or mechanical action.
- h. Repeat filling procedure if required.
- i. Clean after each operation to remove dust and debris.
- j. Finish sand the filler with 220 grit wet and dry sand paper to remove deep sanding marks.
- k. Abrade all areas coated with 320/400 grit wet and dry sand paper to ensure a suitably to ensure a suitably keyed surface, then wipe clean using lint free tac rags.
- l. Abrade all areas to be coated with 220 – 320 grit wet & dry type sandpaper to ensure a suitably keyed surface. Wipe clean using lint free tac rags.
- m. Observing the technical data sheet recommendation for mixing, application and drying times. Apply one coat of **Sikkens Washprimer 1K**, only to exposed aluminium surfaces.
- n. Apply two coats of **Sikkens Autocryl** matched to shade and gloss, prepared as detailed in the Technical Data Sheet.

3. Minimum requirements for complete re sprays on site.

Substrate Preparation

- a. To clean all surfaces to be painted, use clean lint free cloths. Apply **Sikkens Degreaser** or equivalent liberally and wipe dry physically removing all sealants and mastics etc.
- b. Inspect and remove all mastic sealant adjoining any surface, to below 4mm of metal edges.
- c. Apply protective masking to unaffected areas as required.
- d. Mechanically abrade to sound substrate. Drilled holes to be countersunk and butt joints to be filled. The surface should taper on the side for filling.
- e. Abrade areas to receive filling media mechanically or by hand, using 60/80 abrasive paper.
- f. Clean areas to be filled with vacuum or compressed air.
- g. Thoroughly degrease with **Sikkens Degreaser** or equivalent.
- h. Mix the components of the **Sikkens Polykit** filling media or equivalent as specified in the manufacturers recommendations and apply directly to the substrate. Work the material to remove any trapped air and finish to profile shape. Allow to cure fully as per manufacturer's instructions.
- i. Abrade with 80 abrasive paper to correct profile, either by hand or mechanical action.
- j. Repeat filling procedure if required.
- k. Clean after each operation to remove dust and debris.
- l. Finish sand the filler with 220 grit wet and dry sand paper to remove deep sanding marks.
- m. Abrade all areas coated with 320/400 grit wet and dry sand paper to ensure a suitably keyed surface, ready to be coated, then wipe clean using lint free tac rags.
- n. De mask and clean thoroughly.

Recoating

- a. Mask unaffected areas prior to painting.
- b. To clean surfaces to be painted, use clean lint free cloths, apply **Sikkens Degreaser** or equivalent liberally and wipe dry
- c. Observing the technical data sheet recommendation for mixing, application and drying times; Evenly apply one coat of **Sikkens Washprimer 1K**, to the exposed aluminium surfaces.
- d. Apply one spray coat of **Sikkens Autosurfacers Rapid**, prepared and applied as per the data sheet. Allow to dry and de-nib with 400 grit abrasive paper. Remove all debris and wipe clean using lint free tac-rags.
- e. Apply two coats of **Sikkens Autocryl** matched to shade and gloss, prepared as detailed in the Technical Data Sheet
- f. De-mask, clean and remove all debris etc.
- g. Re-apply sealant / mastic on required areas.
- h. Present finished painted areas for inspection and approval of client.

Some Interpon D finishes may require a base and top clear coat to achieve a match, please be guided by the wet coat supplier's expertise mentioned below.

Sikkens Autocryl colour matched in Interpon D Range shades and gloss levels and relevant Data Sheets, are available from Top Coat Automotive + 27 (0 11 453 9600).

For further information refer to AkzoNobel technical services: +27 (0 11 861 0500).



This Guideline is not intended to replace, but is intended to supplement, the various industry specifications and standards (BS, ISO, AS, Qualicoat, GSB, AAMA etc). Wherever the specifier nominates such an industry specification, then the requirement of that specification (pretreatment, film thickness etc) shall be overriding.

Disclaimer: The information included in this document is given in good faith, but since metal manufacture, metal pre treatment and coatings application may be subject to a wide variety of external and unknown factors, we cannot take responsibility for any failure or shortcoming arising from following any of the advice given, except as may be covered by the relevant Product Data Sheet or Product Guarantee. It is the responsibility of the user to establish what is the correct procedure for his particular set of circumstances, for the substrate he has selected and for the processes he will use to apply the powder coating for decoration and/or anti corrosion protection.