

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D2525 Matt (25)

Product Description

Interpon D2525 Matt (25) is a series of ultra-durable powder coatings specifically formulated without TGIC, intended for use on architectural aluminium and galvanized steel. Providing new levels of weathering resistance **Interpon D2525 Matt (25)** surpasses the performance of leading architectural powders. It offers significantly higher gloss retention and resistance to colour change combined with maximum film integrity to ensure long term cosmetic and functional protection.

These powder coatings are classified in Family I – class 6c under standard NFT 36-005.

Interpon D2525 Matt (25) meets the requirements of GSB Master, Qualicoat Class 2, EN 12206 (formerly BS6496), EN13438 (formerly BS6497:1984) and AAMA 2604.

Some colours may not be available in **Interpon D2525 Matt (25)**.

Following RAL shades are excluded from the RAL families for Qualicoat class 2: Ral 1003, 1012, 1018, 1028, 1033, 2004, 2011, 3015, 3017, 3018, 3020, 4001.

Qualicoat Licence number: P-1210 (France), P-1212 (Italy), P-1201 (UK), P-1512 (Turkey), P-1673 (Czech Republic)

GSB Licence number: 183b (gloss 25)

Powder Properties

Chemical type	Polyester
Appearance	Smooth Matt
Gloss level	20 - 30 gloss units
Particle Size	Suitable for electrostatic spray
Specific gravity	1.2-1.9g/cm ³ depending on colour.
Storage	Dry, cool conditions (open boxes must be resealed)
Shelf life	24 months below 30°C peak temperature 12 months below 35°C peak temperature
Curing schedule (at object temperature)	15-35 minutes at 180°C 12-25 minutes at 190°C 10-20 minutes at 200°C

Powder on Powder application:

1st phase: Melting and partial curing of the base coat suggested 110-120°C for 15-20 min. (object temp) otherwise refer to the instruction of the spraying equipment supplier

2nd phase: Application of the wood decorative powder according to the instruction of the spraying equipment supplier

3rd phase: Complete curing of the full package for 10-20 minutes at 200°C (object temperature)

Mechanical Tests	Flexibility	ISO 1519 (cylindrical Mandrel)	Pass Qualicoat class 2 requirements	
	Adhesion	ISO 2409 (2mm Crosshatch)	Pass Gt0	
	Erichsen cupping	ISO1520	Pass Qualicoat class 2 requirements	
	Impact resistance	ISO 6272	Pass Qualicoat class 2 requirements	
	Hardness	ISO 2815	> 80	
	Mar Resistance Martindale Test (for X-Pro series)	CEN/TS 16611:2016	80 runs(5 cycles) Gloss Retention: 50-75% (depending on color)	
	Environmental and Durability Tests	Acetic Acid Salt Spray	ISO 9227	<16 mm ² corrosion/10cm (1000 hrs)
Constant Humidity		ISO 6270	No blistering, creep <1mm (1000 hrs)	
Sulphur Dioxide		ISO 3231	Pass 30 cycles– no blistering, loss of gloss or discoloration	
Permeability		Pressure Cooker EN12206-2004	Pass 1 hour, no blistering	
Chemical Resistance			Generally good resistance to acid, alkalis and oils at normal temperatures.	
Mortar Resistance		EN12206-2004	No effect after 24 hours	
Accelerated Weathering		ISO16474-2 (1000 hrs) ISO11507:1997 QUV B 313 (600 hrs)	>90% Gloss retention >50% Gloss retention	
Exterior Durability		ISO 2810	Meets qualicoat class 2 requirements after 3 years Florida Meets AAMA 2604-13 requirements after 5 years Florida	
Test Conditions		Testing has been determined under laboratory conditions using the following application properties and is for guidance only.		
		Substrate	Aluminum (0.5-0.8 mm Al Mg1)	
	Pretreatment	Chrome free Qualicoat/GSB approved pretreatment		
	Film thickness	60-80 microns (ISO 2360)		
	Cure schedule	10 minutes at 200° C (object temperature)		
Actual film performance will depend on the individual circumstances in which the product is used.				

Pre-treatment

For maximum protection it is essential to pretreat components prior to the application of **Interpon D2525 Matt (25)**.

Aluminium components should receive a full multi-stage chromate conversion coating or suitable chrome-free pre-treatment or suitable pre-anodising to clean and condition the substrate. Detailed advice should be sought from the pre-treatment supplier.

Interpon D2525 Matt (25) products may also be used on cast or mild steel. For outdoor use **Interpon PZ** anti-corrosive primer over a correctly prepared substrate is recommended

Application

Interpon D2525 Matt (25) powders can be applied by manual or automatic electrostatic spray equipment. For solid shades, unused powder can be reclaimed up to a maximum of 30% using suitable equipment and recycled through the system. Please consult AkzoNobel for further details as to the correct mixing ratio for virgin/reclaim powder.

Interpon D2525 Matt (25) powders should be applied at minimum 60µm.

All powders can show small color differences from batch to batch, this is normal and unavoidable. While AkzoNobel take every precaution to minimize visible differences, this cannot be guaranteed. Applicators and fabricators are advised to use a single batch for parts that will be assembled together. Differences are more likely with special effect powders.

Bonded products have better application properties than blended products (more stable) but attention should still be paid to line settings in order to avoid “marble effect” and changes in aspect after recycling. A constant ratio between virgin and recycled powders should be fixed by the coater in order to achieve a consistent effect. For more information, it is suggested to read the *Metallic Applications Guidelines*.

Products with different codes should not be mixed even if same colour and gloss.

Post Application

For specific advice on the suitability of post coating processes such as bending or the use of sealants, adhesives, thermal break, cleaning etc. Please consult AkzoNobel.

Maintenance

For specific advice on Cleaning and Maintenance, please consult the *Interpon D series Cleaning and Maintenance Guidelines* available from AkzoNobel.

Safety Precautions

Text as per local regulations

Disclaimer

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 fulfil 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.

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