

Technical Datasheet

INTERPON D1036 GLOSS

Standard durable polyester powder coatings



Product description

Interpon D1036 Gloss is a range of powder coatings intended for use on architectural aluminium and galvanized steel. Interpon D1036 Gloss has been specifically formulated without the use of TGIC.

As part of the **Interpon D1036** series of architectural powders, Interpon D1036 Gloss gives excellent exterior durability and colour retention and conforms to the requirements of all the major European architectural finishing standards.

All Interpon D1036 Gloss powders are lead-free and meet the requirements of GSB Florida 1, Qualicoat Class 1, EN12206, and EN13438 (formerly BS6496 & BS6497), and AAMA 2603.

Approvals

Qualicoat Approval	P-0773 (IT)
	P-0991 (TR)
	P-0495 (ES)
	P-0352 (UK)
	P-0647 (CZ)
	P-0363 (DE)
	P-0747 (EG)
	P-0934 (RU)
	P-0143 (FR)
GSB Approval	101k (gloss 85)
Resistance to Fire Approval	Classification: A2,s1,d0 with film thickness up to 120 µm (generic polyester D1036, D2525) according to EN13501-1

Powder properties

	Typical value
Chemical Type	Polyester
Appearance	Smooth Gloss
Density	1.2 - 1.9 g/cm ³ , depending on colour
Gloss (60°)	80 - 90 GU
Shelf life	24 months below 30 °C 12 months below 35 °C
Storage Conditions	Under dry, cool ($\leq 30^{\circ}\text{C}$) conditions (open boxes must be resealed)
Curing schedule	20 - 40 min at 170°C 10 - 20 min at 180°C 8 - 16 min at 200°C (object temperature)

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Pre-treatment

For maximum protection it is essential to pretreat components prior to the application of the powdercoating. 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. Galvanised steel requires surface preparation by either multi-stage pretreatment using either zinc phosphate or chromate conversion or controlled sweep blasting. Depending on the type of galvanizing, degassing or use of anti-bubbling additives may be required – follow the procedural advice of the pretreatment supplier. The products may also be used on cast or mild steel. For outdoor use Interpon Redox PZ anti-corrosive primer over a correctly prepared substrate is recommended.

Application

Powders can be applied by manual or automatic electrostatic spray equipment. This product should be applied at minimum 60µm. All powders can show small color differences from batch to batch, this is normal and unavoidable. 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. Products with different codes should not be mixed even if same colour and gloss. Different substrates (aluminium, steel, galvanized steel...), use of primer, and big changes in film thickness may give a different aspect. 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. For more information, it is suggested to read the Metallic Applications Guidelines. Clearcoats including tinted clearcoats cannot be applied directly on primers. Only fully opaque shades are suitable for application over primer.

Application Method	Electrostatic
Recycling	<p>A constant ratio between virgin and recycled powders should be fixed by the coater in order to achieve a consistent effect following the AkzoNobel rules.</p> <p>Please consult AkzoNobel for further details as to the correct mixing ratio for virgin/reclaim powder.</p> <p>For solid shades, unused powder can be reclaimed</p> <p>Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% virgin powder should be used.</p>

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.

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Test conditions

The results are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only

Testing has been determined under laboratory conditions using the following application properties and is for guidance only.

Pre-treatment	Chrome free Qualicoat/GSB approved pretreatment
Substrate	Aluminum (0.5-0.8 mm Al Mg1)
Curing schedule	15 min at 180°C (object temperature)
Film Thickness	60 - 80µm, ISO 2360

Mechanical tests

	Typical value	Method/standard
Adhesion	Class 0	ISO 2409 (2 mm Crosshatch)
Erichsen cupping	Pass 5 mm	ISO 1520
Flexibility	Pass 5 mm	ISO 1519
Hardness	>80	ISO 2815 (Buchholz hardness)
Impact resistance	Pass 2,5 Joules reverse & direct (20 in lb)	ISO 6272-2 (d/r)

Chemical and durability tests

	Typical value	Method/standard
Chemical Resistance	Generally good resistance to acid, alkalis and oil at room temperatures.	
Sulphur Dioxide Resistance	Pass 24 cycles– no blistering, loss of gloss or discoloration	ISO 22479

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Environmental and durability tests

	Typical value	Method/standard
Accelerated weathering	≥50% Gloss retention, 1000 h	ISO16474-2
	≥50% Gloss retention, 300 h	ISO 16474-3 QUV B 313 (GSB)
Acetic acid salt spray	No blistering in excess of 2 (S2) according to ISO 4628-2. Infiltration <16 mm ² /10 cm, length of any single infiltration shall not exceed 3 mm., 1000 h	ISO 9227
Humidity	No blistering in excess of 2 (S2) according to ISO 4628-2; the maximum infiltration at the cross is 1 mm, 1000 h	ISO 6270-2 CH (Constant humidity)
Exterior durability	Chalking – none in excess of minimum in ASTM D4214	ISO 2810
	≥50% gloss retention, Colour retention accords with GSB/Qualicoat 1 year(s)	
	No checking, cracking or loss of adhesion after tape pull and only slight chalking and fading after 1 year of Florida exposure	
Mortar resistance	No effect after 24 hours	EN 12206-1
Wet adhesion	No sign of detachment or blistering. Cross-cut value 0. Qualicoat/GSB Colour change is acceptable.	

Maintenance

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

Safety Precautions

This product is intended for use only by professional applicators in industrial environments and should not be used without reference to the relevant health and safety data sheet which Akzo Nobel has provided to its customers.

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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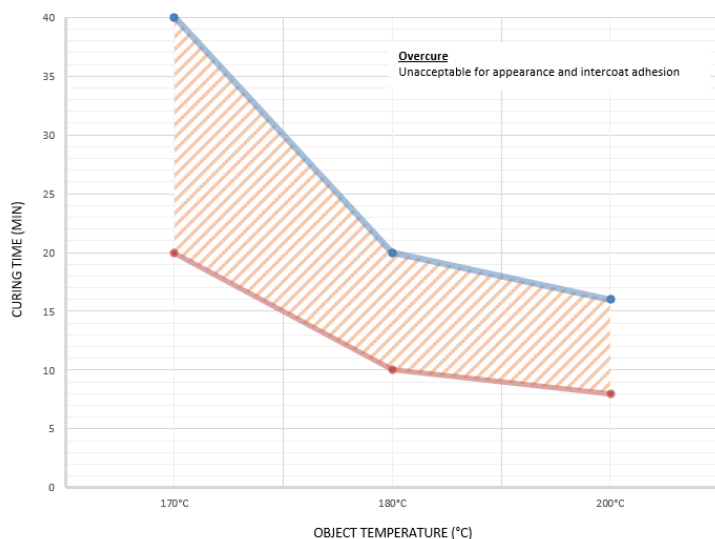
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Appendix

Curing window



Disclaimer:

The data contained in this Curing Window graph is obtained from laboratory coating trials under ideal curing conditions, and using perfectly prepared uncoated testing panels; consequently the curing window needs to be regarded as indicative only. To ensure the correct curing is achieved, specific thermal and performance checks should be

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