

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon D2525 Structura

#### Product Description

**Interpon D2525 Structura**, part of the Interpon D2525 Texture range, is a series of ultra-durable powder coatings with a sand-blasted aspect, specifically formulated without TGIC. It is intended for use on architectural aluminium and galvanized steel. Providing new levels of weathering resistance **Interpon D2525 Structura** 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 Structura** 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 Structura**.

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-0643 (France), P-0877 (Italy), P-1252 (Turkey), P-1441 (Czech Republic) under the brand name Interpon D2525 Texture

**GSB Licence number:** 183e (gloss 10)

<b>Powder Properties</b>	<b>Chemical type</b>	Polyester	
	<b>Appearance</b>	Fine Texture	
	<b>Gloss level</b>	3-7 gloss units	
	<b>Particle Size</b>	Suitable for electrostatic spray	
	<b>Specific gravity</b>	1.2-1.9g/cm <sup>3</sup> depending on colour.	
	<b>Storage</b>	Dry, cool conditions (open boxes must be resealed)	
	<b>Shelf life</b>	24 months below 30°C peak temperature 12 months below 35°C peak temperature	
	<b>Curing schedule</b> (at object temperature)	15-35 minutes at 180°C 12-25 minutes at 190°C 10-20 minutes at 200°C	
<b>Mechanical Tests</b>	<b>Flexibility</b>	ISO 1519 (cylindrical Mandrel)	Pass Qualicoat class 2 requirements
	<b>Adhesion</b>	ISO 2409 (2mm Crosshatch)	Pass Gt0
	<b>Erichsen cupping</b>	ISO1520	Pass Qualicoat class 2 requirements
	<b>Impact resistance</b>	ISO 6272	Pass Qualicoat class 2 requirements
	<b>Hardness</b>	ISO 2815	> 80

	<b>Slip Resistance</b>	BS7976-2.2002+A1.2013	PTV $\geq$ 40 (Dry) and 36 (Wet) (Low slip potential)
<b>Environmental and Durability Tests</b>	<b>Acetic Acid Salt Spray</b>	ISO 9227	<16 mm <sup>2</sup> corrosion/10cm (1000 hrs)
	<b>Constant Humidity</b>	ISO 6270	No blistering, creep <1mm (1000 hrs)
	<b>Sulphur Dioxide</b>	ISO 3231	Pass 30 cycles– no blistering, loss of gloss or discoloration
	<b>Permeability</b>	Pressure Cooker EN12206-2004	Pass 1 hour, no blistering
	<b>Chemical Resistance</b>		Generally good resistance to acid, alkalis and oils at normal temperatures.
	<b>Mortar Resistance</b>	EN12206-2004	No effect after 24 hours
	<b>Accelerated Weathering</b>	ISO16474-2 (1000 hrs) ISO11507:1997 QUV B 313 (600 hrs)	>90% Gloss retention >50% Gloss retention
	<b>Exterior Durability</b>	ISO 2810	Meets qualicoat class 2 requirements after 3 years Florida Meets AAMA 2604-13 requirements after 5 years Florida

<b>Test Conditions</b>	Testing has been determined under laboratory conditions using the following application properties and is for guidance only.		
	<b>Substrate</b>	Aluminum (0.5-0.8 mm Al Mg1)	
	<b>Pretreatment</b>	Chrome free Qualicoat/GSB approved pretreatment	
	<b>Film thickness</b>	70-90 microns (ISO 2360)	
	<b>Cure schedule</b>	10 minutes at 200° C (object temperature)	
	Actual film performance will depend on the individual circumstances in which the product is used.		

<b>Pre-treatment</b>	For maximum protection it is essential to pretreat components prior to the application of <b>Interpon D2525 Structura</b> . 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.  <b>Interpon D2525 Structura</b> products may also be used on cast or mild steel. For outdoor use <b>Interpon Redox PZ</b> anti-corrosive primer over a correctly prepared substrate is recommended
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<b>Application</b>	<b>Interpon D2525 Structura</b> 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.  <b>Interpon D2525 Structura</b> powders should be applied at minimum 60 $\mu$ m.  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
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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.

<b>Post Application</b>	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.
<b>Maintenance</b>	For specific advice on Cleaning and Maintenance, please consult the <i>Interpon D series Cleaning and Maintenance Guidelines</i> available from AkzoNobel.
<b>Safety Precautions</b>	Text as per local regulations
<b>Disclaimer</b>	<p><b>IMPORTANT NOTE:</b> 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.</p> <p>Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.</p> <p>Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel</p>

<http://www.interpon.com/contact-us/>

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