

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D2525 Structura Flex

Product Description

Interpon D2525 Structura Flex, 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 Flex** surpasses the performance of leading architectural powders. Interpon D2525 Structura Flex being superior to **Interpon D2525 Structura**, meets mechanical performance requirements of Qualicoat Class 1. It offers significantly higher gloss retention and resistance to color 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 durability requirements of GSB Master, Qualicoat Class 2, EN 12206 (formerly BS6496), EN13438 (formerly BS6497:1984) and AAMA 2604 while meeting Qualicoat Class 1 flexibility requirements. Some colors may not be available in **Interpon D2525 Structura Flex**.

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 License number: P-0643 (France), P-0877 (Italy), P-1252 (Turkey), P-1441 (Czech Republic) under the brand name Interpon D2525 Texture
GSB License number: 183e (gloss 10)

Powder Properties

Chemical type	Polyester TGIC Free
Appearance	Fine Texture
Gloss level (EN ISO 2813 (60°))	3-7 gloss units
Recommended Film Thickness (µm)	70-90 µm
Density (g/cm³)	1.2-1.90 g/cm ³ depending on color and effect
Application	Suitable for electrostatic spray
Storage	Dry, cool conditions (open boxes must be resealed)
Shelf life	24 months below 30°C
Curing schedule (object temperature)	15-35 minutes at 180°C 12-25 minutes at 190°C 10-20 minutes at 200°C

Test Conditions

The results shown below are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only. Actual product performance will depend upon the circumstances under which the product is used.

Substrate	Aluminum (0.5-0.8 mm Al Mg1)
Pretreatment	Chrome free Qualicoat/GSB approved pretreatment

	Film Thickness	70-90 µm (ISO 2360)	
	Curing Schedule	15 minutes at 200° C (object temperature)	
Mechanical Tests	Adhesion	ISO 2409 (2mm crosshatch)	Class 0
	Flexibility	ISO 1519 (cylindrical Mandrel)	Pass 5mm
	Hardness	ISO 2815	>80
	Erichsen Cupping	ISO 1520	≥ 5mm
	Impact	ISO 6272-2	Pass 2.5 Joules (direct & reverse)
Environmental and Durability Tests	The results shown are based on tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for advice only, actual performance depends upon the circumstances under which the product is used.		
	Acetic Acid Salt Spray (1000 hours)	ISO 9227	<16 mm ² corrosion/10cm
	Constant Humidity (1000 hours)	ISO 6270	No blistering creep <1mm
	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 h) ISO11507:1997 QUV B 313 (600 h)	>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
	Pretreatment	<p>For maximum protection it is essential to pretreat components prior to the application of Interpon D2525 Structura Flex.</p> <p>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.</p> <p>Interpon D2525 Structura Flex 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.</p>	
Application	Interpon D2525 Structura Flex 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 Structura Flex 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 color and gloss

Recycling	Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% virgin powder should be used.
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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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<http://www.interpon.com/contact-us/>

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