

Technical Datasheet

INTERPON D1036 STF TEXTURE



Standard durable polyester powder coatings suitable for heat-transfer decoration

Product description

Interpon D1036 STF Texture is a range of powder coatings expressly formulated as a base for successive heat-transfer decoration. **Interpon D1036 STF Texture** has been specifically formulated without the use of TGIC.

As part of the Interpon D series of architectural powders, **Interpon D1036 STF Texture** gives excellent exterior durability and colour retention and conforms to the requirements of all the major European architectural finishing standards. All Interpon D1036 STF Texture powders are lead-free and conform to the requirements of Qualicoat Class 1, EN12206, and EN13438 (formerly BS6496 & BS6497), and AAMA 2603.

The exterior durability of the decorated coating film (powder coating base + paper/film) is highly dependent on the exterior durability of the decorating papers/films inks; and not only on the powder coating base. To make sure that the decorated coating film has a good exterior durability it is recommended to put the decorated coating film through homologation tests.

Approvals

Qualicoat Approval	DP-0841 (IT) DP-1752 (RU)
Qualideco License	Italy: PS-002 Decorative films: Memphis, Sublitex, Decoral, I.DEK, CFM
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 – TGIC Free
Appearance	Fine Texture
Density	1.2 - 1.9 g/cm ³ , depending on colour
Gloss (60°)	0 - 30 GU
Recommended film thickness	80 - 100µm
Shelf life	24 months below 30 °C 12 months below 35 °C
Storage Conditions	(open boxes must be resealed) Dry, cool conditions
Curing schedule	15 - 30 min at 190°C 10 - 20 min at 200°C 8 - 12 min at 210°C (object temperature)

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.

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

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Application

Powders can be applied by manual or automatic electrostatic spray equipment. This product should be applied at minimum 80µm. All powders can show small color differences from batch to batch, this is normal and unavoidable. Products with different codes should not be mixed even if same colour and gloss. 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 solid shades, unused powder can be reclaimed. Clearcoats including tinted clearcoats cannot be applied directly on primers. Only fully opaque shades are suitable for application over primer.

Application Method	Electrostatic
Recycling	Please consult AkzoNobel for further details as to the correct mixing ratio for virgin/reclaim powder. For solid shades, unused powder can be reclaimed Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% virgin powder should be used.

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.

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	10 min at 200°C (object temperature)
Film Thickness	70 - 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)

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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

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 ≥50% gloss retention, Colour retention accords with GSB/Qualicoat 1 year(s)	ISO 2810
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.

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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.

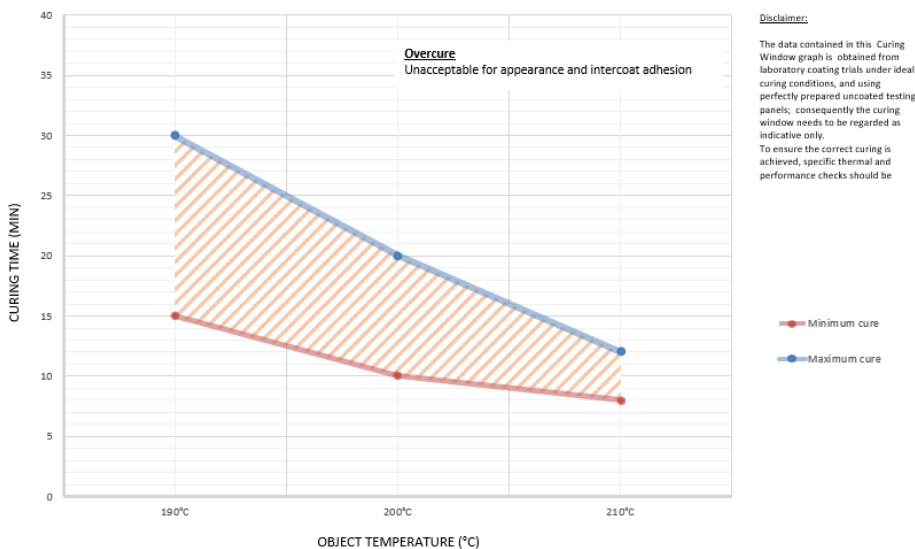
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Appendix

Curing window

Interpon D1036 STF Texture - curing window



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