

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D1036 STF Texture

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.

Qualicoat Licence number (Italy): DP-0841, (Russia): DP-1752

Qualideco Licence Number (Italy): PS-002 Decorative films: Memphis, Sublitex, Decoral, I.DEK, CFM

Powder Properties	Chemical type	Polyester	
	Appearance	Fine Texture	
	Gloss level	0-30 gloss units	
	Particle Size distribution	Suitable for electrostatic spray	
	Recommended Film Thickness	80 – 100µm	
	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)	15-30 minutes at 190°C 10-20 minutes at 200°C 8-12 minutes at 210°C	
Mechanical Tests	Flexibility	ISO 1519 (cylindrical Mandrel)	Pass 5mm
	Adhesion	ISO 2409 (2mm Crosshatch)	Pass Gt0
	Erichsen cupping	ISO1520	Pass 5mm
	Impact resistance	ISO 6272-2	Pass 2.5 joules reverse & direct (20 in lb)
	Hardness	ISO 2815	> 80

Environmental and Durability Tests	Acetic Acid Salt Spray	ISO 9227	<16 mm ² corrosion/10cm (1000 hrs)
	Constant Humidity	ISO 6270-2	No blistering, creep <1mm (1000 hours)
	Sulphur Dioxide	ISO22479	Pass 24 cycles – no blistering, gloss loss or discoloration
	Permeability	EN12206-1 Par. 5.10	Pressure Cooker – pass 1 hour no defects
	Chemical Resistance		Generally good resistance to acid, alkalis and oils at normal temperatures.
	Mortar Resistance	EN12206-1	No effect after 24 hours
	Accelerated Weathering Test	ISO16474-2 (1000 hrs) ISO11507 QUV B 313 (300 hrs)	≥50% Gloss retention ≥50% Gloss retention
	Exterior durability		≥50% gloss retention, Colour retention accords with GSB/Qualicoat Chalking – none in excess of minimum in ASTM D4214-07
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	70-80 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 D1036 STF Texture . 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.		
Application	Interpon D1036 STF Texture 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 D1036 STF Texture powders should be applied at minimum 80µm. All powders can show small colour 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

Please consult the relevant Material Safety Data Sheet (MSDS) available from AkzoNobel.

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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