AkzoNobel Powder Coatings
3 Commerce Drive
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Product Data Sheet

AkzoNobel Powder Coatings

Interpon D2000 Stone Effect Collection
YX313QF
Dark Gray Natural Concrete

Product Description	**Interpon D2000** is a range of high-durability powder coatings specially formulatedm for architectural aluminum components. **Interpon D2000** conforms to the performance of the AAMA2604-22 specification and exhibits superior exterior durability and color retention.		
Powder Properties	**Chemical type**	Polyester TGIC Free	
	Appearance	Texture	
	Gloss level (Gardner 60°)	4 - 7	
	Recommended Film thickness	2.4 – 3.2 mils.	
	Specific gravity	1.43 +/-0.05 g/cm³	
	Coverage @ 1.0 mil	134.47 sq.ft/lb/mil	
	Storage	Maximum 75°F	
	Shelf life	12 months	
	Curing schedule (at object temperature)	20-50 minutes at 356°F 15-35 minutes at 375°F 10-25 minutes at 392°F 8-15 minutes at 410°F	
Mechanical Tests	**Dry Adhesion**	AAMA 2604-22 8.4.1	Pass – no removal of film
	Impact Resistance	AAMA 2604-22 8.5	Pass – no tape removal of film to substrate following 0.1” deformation
	Dry Film Hardness	AAMA 2604-22 8.3 ASTM 3363	Pass F – no rupture of film
	Abrasion Resistance	AAMA 2604-22 8.6	Pass – abrasion coefficent value >20
Environmental and Durability Tests	**Salt Spray**	AAMA 2604-22 8.8 ASTM B117	Pass at 3,000 hrs – no corrosion greater than 1/32”–1/16” from scribe, min. blister rating 8
	Wet Adhesion	AAMA 2604-22 8.4	Pass – no blisters
	Boiling Water	AAMA 2604-22 8.4	Pass – no blisters or film removal
	Constant Humidity Resistance	AAMA 2604-22 8.8.1 ASTM D2247 ASTM 4585	Pass at 3,000 hrs – blister formation less than “few” size no. 8
	Muriatic Acid Test	AAMA 2604-22 8.7.1	Pass – no blisters; No change in appearance
	Mortar Test	AAMA 2604-22 8.7.2	Pass – no blisters, adhesion loss or visual change
	Detergent Resistance	AAMA 2604-22 8.7.4	Pass – no blisters, adhesion loss or visual change

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	Exterior Durability	AAMA 2604-22 8.9 ASTM G7 ASTM D4214	Excellent performance after 5 yrs Florida Exposure; Color Change DE <5 (Hunter); Gloss retention >30%; Chalking not in excess of #8
	Color Stability		Good at Elevated Temperatures

Test Conditions	Testing has been determined under laboratory conditions using the following application properties and is for guidance only.	
	Substrate	Aluminum
	Pretreatment	Chromate
	Film thickness	2.4 – 3.2 mils
	Cure schedule	15 minutes at 400°F
	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 before applying **Interpon D2000**. Aluminum components must receive a full multi-stage chromate conversion coating or suitable chrome-free pretreatment to clean and condition the substrate. Detailed advice should be sought from the pretreatment supplier.
Application	**Interpon D2000** can be applied by manual or automatic electrostatic spray equipment. It is recommended that for consistent application and appearance, product be fluidized during application. For solid shades, the unused powder can be reclaimed using suitable equipment and recycled through the coating system. For mixed colors and certain special finishes, advice must be sought from the manufacturer as to the suitability, or otherwise, of the product for recycling. For all mixed color/special effect systems, advice must be sought as to the correct mixing ratio for virgin/reclaim powder. For the application of the D-Series Architectural Products, the required Dry Film Thickness (DFT) is 2.4 – 4.5 mils, with no measurements below 1.8 mils.
Additional Information	Stone Effect multi-components require good control of your application equipment and spray method.Fluidization is very important as well as using the same kv, micro amp gun settings. It is also important to maintain the same gun to part distance to ensure consistency of the final coating. It is not recommended that reclaim method be used as appearance can change.
Key Product Attributes	
Safety Precautions	Please consult the Safety Datasheet (SDS).
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. 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. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel

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