

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D2525 STF

Product Description

Interpon D2525 STF is a series of advanced durability powder coatings specifically formulated to meet AAMA2604 and to act as a basis for the heat-transfer decoration process (Sublimation Transfer Film) on architectural aluminium extrusions and components. **Interpon D2525 STF** powder coatings are available in a selected range of textured matt colours including popular wood tones.

Interpon D2525 STF used in combination with the sublimation transfer process offers an excellent alternative to wood or other materials, reproducing their appearance but without many of their specific architectural restrictions.

Powder Properties*

Chemical type	Polyester
Particle size	Suitable for electrostatic spray
Specific gravity	1.2 - 1.7 depending on colours
Storage	Dry cool conditions (below 30°C)
Shelf Life	18 months
Sales code	Y-Series
Stoving Schedule	8 mins at 190°C (Object temperature) 5 mins at 200°C 4 mins at 210°C

Film properties

Mechanical and chemical tests carried out on Chromated aluminium panels. All tests are performed on panels coated with 60 to 80 microns of a gloss finish powder coating stoved for 10 minutes at 200°C (metal temperature). Interpon D2525 STF powder coatings are designed to meet the requirements of AAMA2604.

Mechanical Tests*

Dry Adhesion	AAMA2604 Clause 7.4	Pass - no removal of film
Impact resistance	AAMA2604 Clause 7.5	Pass - no tape removal of film from substrate following 0.1" deformation
Dry Film hardness	ISO2815 (Buchholz)	Pass
Abrasion resistance	AAMA2604 Clause 7.6	Pass - abrasion co-efficient > 20

Chemical Durability Tests*

Salt Spray	AAMA2604 Clause 7.8.2 ASTM B117 at 35°C D1654	Pass at 3000 hrs - no corrosion more than 1.0-2.0 mm from scribe Minimum blister rating 8
Constant Humidity Resistance	AAMA2604 Clause 7.8.1 ASTM D2247, ASTM D714	Pass at 3000 hrs – blister formation less than "few" size no 8.
Permeability	AS3715 Section 2.5.11	Pass
Sulphur Dioxide	ISO3231 (Kesternich)	Pass - no blistering, loss of gloss or discolouration.
Chemical Resistance	Generally good resistance to acids, alkalis and oils at normal temperatures	
Exterior durability	5 years Florida exposure AAMA 2604	Excellent performance, Colour change Delta E less than 5, gloss retention >30%. Chalking –none in excess of no.8 ASTM D4214 - D659.
Colour stability at elevated temperatures	Excellent for continuous exposure up to 120°C.	

Pre-treatment

For optimum coating performance the following pre-treatment is recommended prior to the application of **Interpon D2525 STF**. The pre-treatment should be used in accordance with the supplier's recommendations.

A. Aluminium	Multistage chrome chromate, chrome phosphate or chrome ⁶ -free
B. Galvanised Steel	Multistage zinc phosphate or chromate
C. Steel	Multistage zinc or iron phosphate

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Application

Interpon D2525 STF powder coatings can be applied by manual or automatic electrostatic spray equipment. Unused or over-sprayed powder coating can be reclaimed and recycled through the coating system.

Interpon D2525 STF powder coatings have a low pigment loading and are therefore semi-transparent. The appearance of the coating (especially colour) can vary with film thickness, substrate type and pre-treatment. 80-100µm film thickness is recommended to achieve a balance of colour consistency and finished appearance. Due to the high resin content **Interpon D2525 STF** powder coatings can be difficult to apply in high humidity situations. Optimal application conditions are achieved when relative humidity is less than 80%.

Additional Information

Product performance warranties are available with the Interpon D2525 range through accredited applicators. For further information on the available warranties and the applicable terms and conditions, please contact your local AkzoNobel sales office.

AkzoNobel Pty Limited has a policy not to use lead or other heavy metal based pigments in our range of powder coatings. As a result of this policy, the use of bright and deep colours such as Yellows, Oranges and Reds are not recommended for severe outdoor exposure where long-term colour fastness is required. These products can be sourced from the Interpon TC General Industrial range.

Interpon D2525 STF powder coatings as supplied by AkzoNobel contain no organic solvents and can contribute toward satisfying the IEQ credits in the following Green Star® rating tools:

IEQ11 Office Interiors v1.1	IEQ8 Education v1
IEQ13 Office Design v2	IEQ8 Retail Centre v1
IEQ13 Office As-Built v2	IEQ8 Healthcare v1
IEQ8 Multi Unit Residential v1	IEQ8 Industrial v1



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Note: Products are not reviewed or certified under the Green Star® rating system. Green Star® credit requirements cover the performance of materials in aggregate, not the performance of individual products or brands. For more information on Green Star®, visit www.gbca.org.au.

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 AkzoNobel has provided to its customer. If for any reason a copy of the relevant health and safety data sheet is not immediately available the user should contact AkzoNobel to obtain a copy before using the product. Minimum safety precautions in dealing with all powder coatings are as follows. All dusts are respiratory irritants. Therefore, inhalation of the dust or of the vapors resulting from the cure should be avoided. Take steps to prevent skin contact, but should contact occur, wash skin with soap and water. In case of eye contact flush immediately with clean water and seek medical advice. Dust clouds of any finely divided organic material can be ignited with an electric spark or open flame. Dust and powder should not be allowed to build up on surfaces or ledges. Dust collection equipment should be used which has provision for adequate explosion release. All equipment should be electrically earthed to prevent build up of static. Users are recommended to follow the guidelines laid down in AS3754:1990, "Safe Application of Powder Coatings by Electrostatic Spraying".

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 fulfill 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.

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* Typical minimum specifications. Performance may vary slightly between individual products.

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AkzoNobel Coatings Ltd
686 Rosebank Road
Auckland 1007
New Zealand
Ph: 0800 150 527
Fax: 0800 809 679
Email: salesnz@interpon.com
Web: www.interpon.co.nz

AkzoNobel Pty Limited
51 McIntyre Road
Sunshine Victoria 3020
Australia
Ph: 1800 630 516
Fax: 1800 650 786
Email: salesoz@interpon.com
Web: www.interpon.com.au