

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D2525 Structura

Product Description	Interpon D2525 Structura , 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 typically exceeds the requirements of AAMA2604 and surpasses the performance of leading architectural powders. Interpon D2525 Structura offers significantly higher gloss retention and resistance to colour change combined with maximum film integrity to ensure long term cosmetic and functional protection.
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Powder Properties*	Chemical type	Polyester
	Appearance	Fine Texture
	Gloss level	3-7 gloss units
	Particle Size	Suitable for electrostatic spray
	Specific gravity	1.2-1.9g/cm ³ depending on colour.
	Storage	Dry, cool conditions, below 30°C (open boxes must be resealed)
	Shelf life	18 months
	Sales code	Y-Series
	Stoving schedule (Object temperature)	15 minutes at 190°C 10 minutes at 200°C 8 minutes 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).
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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 to substrate following 0.1" deformation
	Dry Film hardness	ISO2815 (Buchholz)	Pass
	Abrasion resistance	AAMA2604 Clause 7.6	Pass-abrasion coefficient >20

Chemical Durability Tests*	Salt Spray	AAMA2604 Clause 7.8.2 ASTM B117 at 35°C D1654	Pass at 3000 hrs – no corrosion >1-2 mm from scribe Minimum blister rating 8
	Constant Humidity	AAMA2604 Clause 7.8.1 ASTM D2247, ASTM D714	Pass at 3000 hrs – blister formation < "few" size no 8
	Permeability	AS3715 2002	Pass 1 hour, no blistering
	Chemical Resistance		Generally good resistance to acid, alkalis and oils at normal temperatures.

Exterior Durability	5 years Florida exposure AAMA 2604	Excellent performance, Colour change $\Delta E < 5$, gloss retention >30% Chalking - no > no.8 ASTM D4214 - D659
Colour stability at elevated temperatures		Excellent for continuous exposure up to 120°C

Pre-treatment For maximum protection it is essential to pretreat components prior to the application of **Interpon D2525 Structura**. 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.

Interpon D2525 Structura 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

Application **Interpon D2525 Structura** powders can be applied by manual or automatic electrostatic spray equipment. To ensure the highest consistency of metallic coatings the powder should always be applied from a fluidised hopper. Unused or over-sprayed powder coating can be reclaimed up to a maximum of 20% using suitable equipment and recycled through the coating system. Frequent, small additions of reclaim powder to the hopper are recommended. For mixed colours and certain special finishes, advice must be sought from Akzo Nobel as to the suitability or otherwise of the product for recycling.

Interpon D2525 Structura powders should be applied at minimum 60µm.

Products with different codes should not be mixed even if same colour and gloss.

Additional Information A 25-year film integrity / 15-year colour warranty is available to Interpon D Approved Applicators. For further information please contact your local Akzo Nobel sales office. Interpon D2525 Futura™ 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



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.

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 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 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.

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