

Product Data Sheet

AkzoNobel Powder Coatings

Interpon D1036 STF Matt

Product Description

Interpon D1036 STF Matt is a range of powder coatings expressly formulated as a base for successive heat-transfer decoration.

Interpon D1036 STF Matt has been specifically formulated without the use of TGIC. As part of the Interpon D series of architectural powders, Interpon D1036 STF Matt gives excellent exterior durability and colour retention and conforms to the requirements of all the major European architectural finishing standards. All Interpon D1036 STF Matt 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): P-0826 (Spain): P-0906

Qualideco Licence Number (Italy): PS-002 Decorative films: Memphis/Colormenphis Film; Miroglio/Decotrans Alu; Decoral System/Heat Transfer film Decoral System.

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| Powder Properties | Chemical type | Polyester | |
| | Appearance | Smooth Matt | |
| | 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 (1993) | Pass 2.5 joules reverse & direct (20 in lb) |

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| | 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 | No blistering, creep<1mm (1000 hrs) |
| | Sulphur Dioxide | ISO 3231 | Pass 30 cycles– no blistering, loss of gloss or discoloration |
| | Permeability | Pressure Cooker EN12206-5.10 | Pass 1 hour no blistering |
| | 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) ISO11507:1997 QUV B 313 (300 hrs) | ≥50% Gloss retention ≥50% Gloss retention |
| | South Florida | ISO 2810 (1 year) | ≥50% Gloss retention. Color retention in accordance with GSB Standard/ Qualicoat class 1. Chalking – none in excess of minimum in ASTM D659:1980 |
| 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 Matt . 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 Matt 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 Matt 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.

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| 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 <i>Interpon D series Cleaning and Maintenance Guidelines</i> available from AkzoNobel. |
| Safety Precautions | Please consult the relevant Material Safety Data Sheet (MSDS) available from AkzoNobel. |
| Disclaimer | <p>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.</p> <p>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.</p> <p>Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel</p> |

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