

# Interpon D1094 STF

The information given in this datasheet is generic for the range **Interpon D1094 STF**. Specific products within the range can vary from the generic. For these products individual product datasheets are available

**Product Description:** **Interpon D1094 STF** is a range of powder coatings expressly formulated as a base for a successive heat-transfer decoration. Smooth and fine structured finishes are available.  
**Interpon D1094 STF** has been specifically formulated without the use of TGIC.  
 All **Interpon D1094 STF** powders are formulated to meet fully the requirements of EN 12206 (formerly BS6496), BS6497:1984 and Qualicoat.

<b>Powder Properties:</b>	<b>Chemical type</b>	Polyester
	<b>Gloss</b>	25±5
	<b>Particle Size</b>	Suitable for electrostatic spray
	<b>Specific gravity</b>	1.3-1.7 g/cm <sup>3</sup> depending on colour
	<b>Storage</b>	Dry cool conditions
	<b>Shelf life</b>	18 months below 30°C peak temperature
		12 months below 35°C peak temperature
	<b>Sales Code</b>	R-series
	<b>Stoving schedule</b> (object temperature)	15-30 minutes at 190°C
		10-20minutes at 200°C
8-12 minutes at 210°C		

**Test Conditions:** The results shown below are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only. The tests have been carried out on the undecorated base. Actual product performance will depend upon the circumstances under which the product is used and the type of decoration applied.

<b>Substrate</b>	Aluminium
<b>Pretreatment</b>	Chromate
<b>Film Thickness</b>	60 microns
<b>Stoving</b>	10 minutes at 200°C (object temperature)

<b>Mechanical Tests:</b>	<b>Adhesion</b>	ISO2409 (2mm Crosshatch)	Gt 0
	<b>Erichsen Cupping</b>	ISO1520	Pass >7mm
	<b>Hardness</b>	ISO2815 (4000gms)	Pass - no penetration to substrate
	<b>Impact</b>	ASTM 2794	Pass 2.5 joules direct and reverse
	<b>Flexibility</b>	SO1519 (Conical Mandrel)	Pass 3mm

<b>Chemical Tests:</b>	<b>Salt Spray</b>	ISO7253	Pass at 1000 hours - no corrosion area more than 2mm from scribe.
	<b>Acetic Acid Salt Spray</b>	ISO9227	Pass at 1000 hours - <16mm <sup>2</sup> corrosion/10cm
	<b>Cyclic Humidity</b>	DIN50017	Pass at 1000 hours - no blistering or loss of gloss
	<b>Sulphur Dioxide</b>	ISO3231 (Kesternich)	Pass 30 cycles - no blistering, creep <1mm from scribe
	<b>Permeability</b>	Pressure Cooker EN12206-1:2004 Part 5.10	Pass - no defects after 1 hour (2 hours boiling water)

**Chemical Resistance** Generally good resistance to acids, alkalis and oils at normal temperatures

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<b>Weathering Tests:</b>	<b>Exterior Durability</b>	ISO2810 12 months Florida 5°S	Excellent performance. Slight even loss of gloss; no checking, cracking or flaking. Chalking - none in excess of minimum in ASTM D659:1980
	<b>Colour Stability at elevated temperatures</b>		Good
	<b>Accelerated Weathering Test</b>	Suntest Original-Hanau-Quartzlampen DIN53231	50% Gloss retention after 1000 hours

**Pretreatment:** For maximum protection it is essential to pretreat architectural components prior to the application of **Interpon D1094 STF**. Aluminium components should receive a full multi-stage chromate conversion coating or a suitable chrome-free pretreatment to clean and condition the substrate. Detailed advice should be sought from the pretreatment supplier.

Galvanised steel also requires multi-stage pretreatment using either zinc phosphate or chromate conversion. Degassing of galvanised steel prior to powder application is considered mandatory - follow the procedural advice of the pretreatment supplier.

**Application:** **Interpon D1094 STF** can be applied by manual or automatic electrostatic spray equipment. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.

**Safety Precautions:** Please consult the Material Safety Datasheet (MSDS) PC010

**Disclaimer:** The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this 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. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.