

**Collection Elements
Magnesium**

Interpon 610

MX288E

The information given in this datasheet refers to the product **Magnesium** and should not be construed as referring to other products with in the same range.

Product Description: **Magnesium Interpon 610** is part of Collection Elements specially developed for industrial design.

Interpon 610 is a series of polyester resin based thermo-setting powder coatings, without TGIC. The **Interpon 610** resin system is warning label free.

Polyester powder coatings have good U.V. and weathering resistance.

Offering good mechanical strength and good weathering resistance, this class of polyester powder coatings is used both for interior decorating, metal furniture, shop design, ... and for coating parts for outside exposure, lights, garden and street furniture, etc.

Powder Properties:

Chemical type	Polyester
Density	1.33
Storage	Dry cool conditions
Shelf life	18 months at 30°C 12 months at 35°C
Stoving schedule (object temperature)	at 180°C : min 15 mn - max 26 mn at 200°C : min 10 mn - max 20 mn at 210°C : min 7 mn - max 14 mn

Coating :

Aspect Matt grey metallic, subtle green-gold undertones

Test conditions

The results shown are based on tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for advice only, actual performance depends upon the circumstances under which the product is used.

Substrate	0.5 mm steel
Pre-treatment	Zinc phosphate
Film thickness ISO2360	60 microns
Stoving	15 minutes at 200°C (object temperature)

Mechanical tests

Flexibility	ISO 1519	6 mm
Adhesion	ISO 2409	Gt0
Impact	ISO 6272-1	1 kg 0.5 m
Erichsen Cupping	ISO 1520	> 6 mm

Chemical and durability test

Salt spray	ISO 7253	250 hr pass
Constant humidity	ISO 6270	1000 hr pass
Artificial weathering	QUV B 313 200 hours	>50% Gloss retention
Chemical resistance	See Post Application	

Industrial application conditions :

Pre-treatment

Aluminium, steel or Zintec surfaces must be clean and free from grease. Iron phosphate and lightweight zinc phosphating of ferrous metals improves corrosion resistance.

Aluminium surfaces may require a suitable chromate conversion, chrome free pre-treatment or flash anodising for certain applications.

Galvanised steel may require zinc or chromate conversion or sweep blasting.

Detailed advice should be sought from the pre-treatment supplier

Recommended film thickness

60 – 80 microns

A good effect is linked with the recommended thickness.

Application

Magnesium can be applied by corona electrostatic or tribostatic equipment.

However the aspect obtained by tribostatic equipment may vary when compared to electrostatic application and/or our colour card.

In all application processes the aspect obtained is subject to variation, depending on the method of application (type of gun, nozzle, pot etc) and the shape/type of component.

We recommend that the actual application parameters are adapted and adjusted depending on the type of component and with each powder batch in order to give a finish in accordance with our colour card.

The following procedure is given as a guideline when using these finishes :

We recommend the use of flat jet spray nozzles.

To ensure powder homogeneity empty the boxes totally into the tray or feed hopper.

Only one spray run and one batch of powder should be used for components which are to be used in the same project.

For manual application it is essential to ensure that an even film thickness is applied and in all instances sinusoidal gun movements should be avoided.

Recycling

Possible up to 30% of reclaimed powder. Panels should be sprayed to ensure continuity of finish.

Post application :

Contact with Chemical Agents

Contact, even of a short duration with certain household products and chemicals, can cause irreversible changes in the gloss and appearance. We recommend that a test is carried out on a non-visible area before using these types of products on this coating.

Safety Precautions:

Please consult the Material Safety Datasheet (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.