

Interpon 610

Product Description: **Interpon 610** is a series of polyester based powder coatings, formulated without the use of TGIC, designed for the exterior environment, offering excellent light and weather resistance from a single coat finish on a variety of substrates.

Interpon 610 powders are available in a wide range of colours in gloss, satin, matt, aluminium and textured effects and can be custom matched to the user's requirements.

Powder Properties:	Chemical type	Polyester
	Particle size	Suitable for electrostatic spray
	Specific gravity	1.2-1.7 g/cm ³ depending on colour
	Storage	Dry cool conditions below 25°C
	Shelf life	12 months
	Sales Code	M-series
	Stoving schedule^(a)	15 minutes at 190°C
	(object temperature)	10 minutes at 200°C 8 minutes at 210°C

(a) For high reactivity (HR) powders see overleaf

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. Actual product performance will depend upon the circumstances under which the product is used.

Substrate	Mechanical tests: Gold Seal polished steel Chemical & durability tests: Gold Seal lightweight
Pretreatment	Zinc phosphate
Film Thickness	50 microns
Stoving	5 minutes at 200°C (object temperature)

Mechanical Tests:	Adhesion	BS EN ISO2409 (2mm Crosshatch)	Gt 0
	Erichsen Cupping	ISO1520	Pass >7mm
	Hardness	BS EN ISO 1518 (2000gms)	Pass - no penetration to substrate
	Impact	BS3900-E3	Pass 2.5mm direct and reverse
	Flexibility	ISO6860 (Conical Mandrel)	Pass 3mm

Chemical and Durability Tests:	Salt Spray	ISO7253 (250 hours)	Pass - no corrosion creep more than 2mm from scribe
	Cyclic Humidity	BS3900-F2 (1000 hours)	Pass - no blistering or loss of gloss
	Distilled Water Immersion	BS3900-F7 (240 hours)	Pass - no blistering or loss of gloss
	Exterior Durability		Excellent - no chalking, slight loss of gloss after 12 months continuous exposure but no film breakdown or reduction in protective properties
	Chemical Resistance		Generally good resistance to acids, alkalis and oils at normal temperatures

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

Aluminium substrates may require a chromate conversion coating.

Application: **Interpon 610** powders can be applied by manual or automatic electrostatic spray equipment. It is recommended that powder film thickness be between 60-110 microns. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.

Additional Information: **Interpon 610** powders are available in bright aluminium finishes which are susceptible to scratching and finger marking. Protection by use of a clear polyester top coat is recommended when the coated article is to be subjected to physical damage or outdoor environments. Unprotected bright metallic finishes are prone to darkening in an outdoor environment. The top coat should ideally be applied within 2 hours of the metallic coating and gloves should be worn when handling the metallic coated articles. For further details on the use of metallic powder coatings please contact Akzo Nobel.

Interpon 610HR (High Reactivity) powders are also available in selected grades for use where a lower stoving temperature or shorter curing schedule is required.

Sales code: N-Series

Stoving schedule: 15 minutes at 160°C
(object temperature) 8 minutes at 180°C

Shelf life: 12 months

For further details on powder properties and film performance of **Interpon 610HR** please contact Akzo Nobel.

Safety Precautions: When using do not eat, drink or smoke. Do not breathe the dust. In case of insufficient ventilation wear suitable respiratory equipment. For further information please refer to the specific product Material Safety Data Sheet (MSDS).

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.
