

Interpon 610 PF

Product Data Sheet

Product Description: **Interpon 610 PF** is a series of TGIC Free Polyester based powder coatings designed for post forming after powder coating. It is designed to have good flexibility for bending and forming. These products are designed for the exterior environment, offering excellent long term light and weather resistance form a single coat finish on a variety of substrates.

Powder properties*:	Chemical type	Polyester
	Particle size	Suitable for electrostatic spray
	Specific gravity	1.4 - 1.7 depending on colours
	Storage	Dry cool conditions (below) 25°C
	Shelf Life	18 months
	Sales code	M-Series
	Stoving Schedule	10 mins at 190°C or 8 mins at 200°C or 5 mins at 210°C (Object temperature)

Film properties: Mechanical, chemical and durability tests carried out on chromate conversion coated aluminium panels.
All tests are performed on panels coated with 50 -70 microns of a gloss finish powder coating stoved for 10 minutes at 200°C (metal temperature).

Mechanical tests*:	Flexibility	(Bend Test) AS1580 402.1	Pass 6mm
	Adhesion	(2mm Crosshatch) AS1580 408.4	Classification 1 maximum
	Erichsen Cupping	BS3900-E4	Pass > 6mm
	Pencil Hardness	AS1580 405.1	F - minimum
	Reverse Impact Resistance	AS3715 Appendix 2.5.8	Pass 2.5Nm

Chemical and Durability Tests*:	Salt Spray	AS3715 Section 2.5.10	Pass 1000 hours - no corrosion creep more than 2mm from scribe
	Humidity Resistance	AS3715 Section 2.5.7	Pass 1000 hrs - no blistering or loss of adhesion
	Distilled water immersion	BS3900-F7 at 40°C	Pass - no blistering or loss of gloss after 240 hours
	Exterior durability (1 year Allunga exposure at 45° North)	AS4506 – 2005	Pass
	Colour stability	Excellent for continuous exposure up to 120°C.	

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Pretreatment: For optimum coating performance the following pretreatments are recommended prior to the application of **Interpon 610 PF**. The pretreatment should be used in accordance with the suppliers' recommendations.

- A. Aluminium: Multistage Chrome chromate or chrome phosphate
B. Galvanised Steel: Multistage zinc phosphate or chromate
C. Steel: Multistage zinc or iron phosphate

Application: **Interpon 610 PF** powder coatings can be applied by manual or automatic electrostatic spray equipment. Unused powder coating can be reclaimed and recycled through the coating system.

Additional Information: **Guidelines for Post Forming**
Post forming operations should be performed within one (1) month of powder coating. Any extrusion needed to be bent or formed after this time period should be re-evaluated for suitability for post forming. Re-stoving a powder coated extrusion piece in a powder coating oven can often restore bending and flexibility properties. In cold conditions, it is recommended that the extrusion to be post-formed be preheated to approximately 40°C to improve its bending properties. The recommended film thickness for post forming on the significant surface is 50 - 70 microns and no greater than 90 microns on the leading edge. Higher film thicknesses will result in poorer post forming flexibility.

Akzo Nobel Pty Limited has a policy not to use lead or other heavy metal based pigments in our range of powder coatings.

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 Akzo Nobel 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 Akzo Nobel 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 vapours 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: Unless otherwise agreed by us in writing, any contract to purchase products referred to in this brochure and any advice which we give in connection with the supply of products are subject to our standard conditions of sale. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

*Typical minimum specifications. Performance may vary slightly between individual products

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