Interpon®
Powder Coatings

Interpon 610 XL

Product Data Sheet

Product Description:

Interpon 610 XL is a series of TGIC Free Polyester based powder coatings specially formulated to meet the rigorous demands of the street furniture market. It is designed to be sprayed on pretreated galvanised steel and aluminium.
Interpon 610 XL has been formulated to be applied over porous substrates and normally eliminates the need to degas prior to powder coating.
Interpon 610 XL gives good long term exterior durability and colour retention and is available in a limited range of colours and in gloss, satin and matt finishes.

Powder properties*:

Chemical type	Polyester
Particle size	Suitable for electrostatic spray
Specific gravity	1.2 - 1.7 depending on colours
Storage	Dry cool conditions (below) 30°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 zinc phosphated galvanised steel panels.
All tests are performed on panels coated with 50 to 70 microns of a gloss finish powder stoved for 10 minutes at 200°C (metal temperature).
Reduced gloss finishes may show lower values for mechanical performance.

Mechanical tests*:

Flexibility	(Bend Test) AS1580 402.1	Pass 6mm
Adhesion	(2mm Crosshatch) AS1580 408.4	Classification 1 maximum
Erichsen Cupping	BS3900-E4	Pass > 3mm
Pencil Hardness	AS1580 405.1	F - minimum
Reverse Impact resistance	AS3715 Section 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 at 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)	Excellent – pass AS3715 after 12 months continuous exposure with no film breakdown or reduction in protective qualities	
Colour stability at elevated temp.	Excellent for continuous exposure up to 120°C.	
Solvent/Chemical Resistance:	Generally good resistance to acids, alkalis and oils at normal temperatures.	

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Pretreatment:

For optimum coating performance, galvanised steel and aluminium require a multistage pretreatment including either zinc phosphate or chromate. For particularly porous substrates, degassing at 5-10°C in excess of cure temperature prior to powder application is recommended.

Application:

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

Additional Information:

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

Interpon 610 XL is designed to produce a factory finish on;

Fencing and gates
Lighting Columns
Pedestrian Guardrails
Traffic Signposts
Large Base Posts
Other Galvanised Steel Street Furniture

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 the AS3754:1990, “Safe Application of Powder Coatings by Electrostatic Spraying”.

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

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