

Product Data Sheet

AkzoNobel Powder Coatings

Interpon 610 PF

Product Description

Interpon 610 PF is a range of post formable powder coatings developed for applications which require a high degree of coating flexibility.

Interpon 610 PF is a series of polyester based environmental friendly system powder coatings designed for the exterior environment, offering very good light and weather resistance.

Interpon 610 PF is available in a range of colours and gloss.

Powder Properties

Chemical type	Polyester
Appearance	Depends on specific product
Particle Size	Suitable for electrostatic spray
Gloss	Depends on specific product
Specific gravity	1.3-1.7 g/cm ³ (depending on color)
Storage	Dry cool conditions below 30 °C
Shelf life	12 months (<25 °C)
Stoving schedule (object temperature)	15 minutes at 200°C Failure to observe the correct curing conditions may cause difference in colour, gloss and the deterioration of the coating properties.

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: 0.6mm degreased steel
Pretreatment	Chemical tests: 0.6mm Zn phoshated steel or chromated aluminum
Film Thickness	40-60 microns
Stoving Schedule	15minutes at 200°C (object temperature)

Mechanical Tests

Flexibility	ISO 1519	Pass 2mm
(Cylindrical Mandrel)	GB/T 6742	Pass 2mm
Adhesion	ASTM D3359	5B
	ISO 2409	Gt 0
	GB/T 9286	Gt 0
Erichsen Cupping	ISO 1520	Pass > 8mm
	GB/T 9753	Pass > 8mm
Impact (direct)	ASTM D2794	>=100kg·cm
	GB/T 1732	50kg·cm
Pencil hardness	ASTM D3363	>=B
(scratch)	GB/T 6739	>=B
T-bend Flexibility	ISO 17132	0T
	GB/T 13448	0T

Chemical and Durability Tests

Humidity	ISO 6270-1	Pass-1000 hours, no blistering or detachment
	GB/T 13893	Pass-1000 hours, no blistering or detachment
Exterior Durability		Excellent – no chalking, slight loss of gloss after 12 months continuous exposure but no film breakdown or

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	Chemical Resistance		reduction in protective properties Generally good resistance to most acids, alkalis and oils at ambient temperatures
Corrosion Tests	Neutral Salt Spray	ISO 9227	Pass-500 hours, infiltration length<2mm
		GB/T 10125	Pass-500 hours, infiltration length<2mm
Pre-treatment	Aluminum, steel or Zintec surfaces to be coated must be clean and free from grease. Iron phosphate and particularly lightweight zinc phosphate of ferrous metals improves corrosion resistance. Aluminum substrates may require a chromate conversion coating.		
Application	Interpon 610 PF powders can be applied by manual or automatic electrostatic spray equipment, however for consistency of finish automatic equipment is preferred. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.		
	Fluidizing air pressure	~0.7 bar	
	Transport air pressure	~0.7bar	
	Recommended voltage	40-90kV	
Damage Repair	Surface preparation	Sanding + Air cleaning	
	Application	Recoat : Lower Voltage	
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) available on request from your local AkzoNobel sales office.		
Disclaimer	IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data 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. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product.		
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