

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon 610 MZ622I Sulfur

<b>Product Description</b>	<b>Interpon 610</b> 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.		
<b>Powder Properties</b>	<b>Chemical type</b>	Polyester	
	<b>Aspect</b>	Smooth gloss	
	<b>Color</b>	Gold toned clear	
	<b>Gloss</b>	>90 units	
	<b>Recommended Film Thickness (µm)</b>	60 - 80 µm	
	<b>Density (g/cm<sup>3</sup>)</b>	1,22 g/cm <sup>3</sup>	
	<b>Application</b>	Electrostatic	
	<b>Storage</b>	Under dry, cool (≤ 30°C) conditions	
	<b>Shelf life</b>	At least 24 months from production date	
	<b>Curing schedule</b>	At 190°C: min 15 min – max 26 min At 200°C: min 10 min – max 20 min At 210°C: min 8 min – max 16 min	
<b>Test Conditions</b>	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.		
	<b>Substrate</b>	Steel	
	<b>Pretreatment</b>	Zinc phosphate	
	<b>Film Thickness</b>	70 microns	
	<b>Curing Schedule</b>	15 minutes at 200°C (Object Temperature)	
<b>Mechanical Tests</b>	<b>Bending test (Cylindrical Mandrel)</b>	ISO 1519	Pass 6mm
	<b>Adhesion</b>	ISO 2409 (2mm crosshatch)	Class 0
	<b>Erichsen Cupping</b>	ISO 1520	Pass 6 mm
	<b>Impact</b>	ISO 6272	1kg 0.5m
<b>Chemical and durability tests</b>	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.		
	<b>Constant Humidity</b>	ISO 6270	1000 hr pass*

	<b>Artificial Weathering</b>	QUV B 313 (200 hours)	≥ 50% Gloss retention								
	<b>Neutral Salt Spray</b>	ISO 7253 (250 hours)	pass*								
*Note: test only relates to corrosion resistance											
<b>Pretreatment</b>	<p>Aluminium, steel or Zintec surfaces must be clean and free from grease. Iron phosphate and light weight zinc phosphating of ferrous metals improves corrosion resistance.</p> <p>Aluminium surfaces may require a suitable chromate conversion, chrome free pretreatment or flash anodizing for certain applications.</p> <p>Galvanized steel may require zinc or chromate conversion or sweep blasting. Detailed advice should be sought from the pretreatment supplier</p>										
<b>Application</b>	<p><b>Sulfur</b> can be applied by corona electrostatic or tribostatic equipment. <b>Sulfur</b> is a tinted clearcoat and can be used directly on surfaces or to overcoat a powder base color. Reproduction of the finish and shade varies in accordance with the underlying surfaces, the type of undercoat and the applied film thickness of the <b>Sulfur</b>.</p> <p>Edge effects may be visible. To ensure good final results the surface to be coated must be as uniform as possible. When using Sulfur as a topcoat application to the base coat should be done immediately on the same site.</p> <p>The maximum allowable period between coats is 2 hours. For gas oven curing, please check if color is acceptable.</p> <p>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 the color card.</p> <table border="1" data-bbox="496 1321 1460 1480"> <tr> <td data-bbox="496 1321 794 1395"><b>Recommended film thickness</b></td> <td colspan="3" data-bbox="794 1321 1460 1395">60-80 µm A good protection is linked with the recommended film thickness.</td> </tr> <tr> <td data-bbox="496 1395 794 1480"><b>Recycling</b></td> <td colspan="3" data-bbox="794 1395 1460 1480">Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 80% new powder should be used.</td> </tr> </table>			<b>Recommended film thickness</b>	60-80 µm A good protection is linked with the recommended film thickness.			<b>Recycling</b>	Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 80% new powder should be used.		
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<b>Post Application</b>	<b>Contact with Chemical Agents</b>	Contact, even for 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.
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<b>Safety Precautions</b>	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 customers.
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<b>Disclaimer</b>	<p><b>IMPORTANT NOTE:</b> 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 fulfil 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.</p>
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Interpon Redox Plus - Issue #5

Last Revision Date: 24.04.2019

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