

Product Data Sheet

AkzoNobel Powder Coatings

Interpon 610 MK253F

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.

MK253F is a NATO green infra-red reflective coating conforming to a variety of military norms (see Additional section).

Powder Properties

Chemical type	Polyester TGIC-free
Particle Size	Suitable for electrostatic spray
Specific gravity	1.4-1.5 g/cm ³ depending on colour
Storage	Dry cool conditions below 25°C
Shelf life	12 months
Stoving schedule (object temperature)	15 - 30 minutes at 190°C 10 - 20 minutes at 200°C 8 -16 minutes at 210°C

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	Gold Seal polished steel
Pretreatment	Gold Seal lightweight Zinc Phosphate
Film Thickness	50 - 70 microns
Stoving Schedule (object temperature)	10 minutes at 200°C

Mechanical Tests

Flexibility (Conical Mandrel)	ISO 6860	Pass 4mm
Adhesion (2mm Crosshatch)	ISO 2409	Gt0
Erichsen Cupping	ISO 1520	Pass 6mm
Hardness	ISO2815 (4000gms)	Pass - no penetration to substrate
Impact (direct/reverse)	ISO 6272	25kgcm/25kgcm

Chemical and Durability Tests

Salt Spray (250 hours)	ISO 7253	No corrosion creep >2mm from scribe. Class 0. No change of visual appearance
Cyclic Humidity (1000 hours)	BS3900-F2	No corrosion creep >2mm from scribe. Class 0. No change of visual appearance
Distilled Water Immersion (240 hours)	BS3900-F7	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	

Interpon 610

Pre-treatment	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. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.
Additional	MK253F conforms to the following norms. <ul style="list-style-type: none">- BS 381C-285 (colour)- GAM-C 24X5 (colour)- GAM-C Annexe III 25B (colour)- GAM-C Annexe iii 36B (Infra-red reflectance)- DEF STAN 00-23 (Infra-red reflectance)- DEF STAN 80-122
Safety Precautions	Please consult the Material Safety Datasheet (MSDS)
Disclaimer	<p>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.</p> <p>Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.</p> <p>Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel</p>

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Interpon 610 MK253F – Issue 6
Issued: 29.09.15 Revision Date: 29.09.17

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