

Technical Datasheet

Interpon 610

MN250F

Exterior durable polyester powder coatings



Product description

Interpon 610 is a range of polyester TGIC Free powder coatings designed for exterior exposure with good weather resistance from just one application. The coatings sustain a longer lifespan and are available in a wide range of colors and finishes which allow your product to shine.

Interpon 610 offers not only beautiful aesthetics but also a performance to match. It is ideally suited to a broad range of outdoor applications including outdoor furniture, playground equipment, signs, fencing, vending machines and general metal finishing. Can also be used for indoor application if required.

Approvals

Resistance to Fire Approval A2,s1,d0 with film thickness up to 120 µm (generic polyester 600) according to EN13501-1

Powder properties

	Typical value
Chemical Type	Polyester – TGIC Free
Color	Black 205 (Velours)
Density	1.45 - 1.65 g/cm ³
Gloss	1 - 5 GU
Recommended film thickness	60 - 90µm
Shelf life	24 months below 30 °C 12 months below 35 °C
Storage Conditions	Under dry, cool ($\leq 30^{\circ}\text{C}$) conditions (open boxes must be resealed)
Curing schedule	13 - 18 min at 190°C 10 - 14 min at 200°C (Object Temperature)

Pre-treatment

Galvanised steel requires surface preparation by either multi-stage pretreatment using either zinc phosphate or chromate conversion or controlled sweep blasting. Depending on the type of galvanizing, degassing or use of anti-bubbling additives may be required – follow the procedural advice of the pretreatment supplier.

Iron phosphate and particularly Zinc phosphating of ferrous metals improves corrosion resistance. Aluminium substrates may require a chromate conversion coating.

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Application

Powders can be applied by manual or automatic electrostatic spray equipment.

All powders can show small color differences from batch to batch, this is normal and unavoidable.

Bonded products have better application properties than blended products (more stable) but attention should still be paid to line settings in order to avoid "marble effect" and changes in aspect after recycling.

Products with different codes should not be mixed even if same colour and gloss.

Different substrates (aluminium, steel, galvanized steel...), use of primer, and big changes in film thickness may give a different aspect.

Applicators and fabricators are advised to use a single batch for parts that will be assembled together. Differences are more likely with special effect powders.

A good protection is linked with the recommended film thickness.

It is recommended that for consistent application and appearance product be fluidized during application.

Application Method	Electrostatic
Recycling	Please consult AkzoNobel for further details as to the correct mixing ratio for virgin/reclaim powder. For solid shades, unused powder can be reclaimed Unused powder can be reclaimed using suitable equipment and recycled through the coating system, but a minimum of 70% virgin powder should be used.

Post application

For specific advice on the suitability of post coating processes such as bending or the use of sealants, adhesives, thermal break, cleaning etc. Please consult AkzoNobel.

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.

Test conditions

The results are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only

Testing has been determined under laboratory conditions using the following application properties and is for guidance only.

Pre-treatment	Zinc Phosphate
Substrate	Polished steel
Curing schedule	10 min at 200°C
Film Thickness	60 - 70µm

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Mechanical tests

	Typical value	Method/standard
Adhesion	Class 0	ISO 2409 (2 mm Crosshatch)
Erichsen cupping	Pass 5 mm	ISO 1520
Flexibility	Pass10mm	ISO 1519
Hardness	Pass - no penetration to substrate	ISO 1518-1 (2000g)
Impact resistance	≥50 kg.cm	ISO 6272-2 (d/r)

Chemical and durability tests

Whilst maintaining the general protective and anti-corrosive properties of powder coatings, aluminum and copper/bronze metallic finishes, when submitted to the listed tests, may rapidly show a loss of metallic aspect. 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.

	Typical value	Method/standard
Chemical Resistance	Generally good resistance to acid, alkalis and oil at room temperatures.	
Salt spray test	Pass, no corrosion creep more than 3 mm from scribe, 500 h	ISO 9227

Environmental and durability tests

	Typical value	Method/standard
Humidity	Pass - no blistering or loss of gloss, 1000 h	ISO 6270-2 CH (Constant humidity)
Exterior durability	Suitable for outdoor use	

Maintenance

For specific advice on Cleaning and Maintenance, please follow Powder Coatings: Cleaning & Maintenance of Surfaces for Industrial use available from AkzoNobel.

Repair

Surface preparation	Sanding + Air cleaning Any damage of the coating system must be repaired as soon as possible.
Application	For repairs a PU (2K or 1K) liquid paint is recommended.

Additional Information

For application on Buildings we recommend using our Interpon D series.

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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 customers.

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 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.

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