

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon 610

#### MA237GF PFP MX BIANCO 9003CA 30G

#### 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.

Interpon 610 powders are available in a wide range of colours in gloss, satin, matt, metallic and textured effects and can be custom matched to the user's requirements.

#### Powder Properties

<b>Chemical type</b>	Polyester – TGIC Free
<b>Particle Size</b>	Suitable for electrostatic spray
<b>Specific gravity</b>	1.20-1.90 g/cm <sup>3</sup> ±0.03 (Please consult CoA of product)
<b>Storage</b>	Dry cool conditions below 30°C (open boxes must be resealed)
<b>Shelf life</b>	24 months
<b>Stoving schedule</b> (object temperature)	15 minutes at 180°C 10 minutes at 190°C 8 minutes at 200°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.

<b>Substrate</b>	Gold Seal polished steel
<b>Pretreatment</b>	Gold Seal lightweight Zinc Phosphate
<b>Film Thickness</b>	50 microns
<b>Cure Schedule</b> (object temperature)	10 minutes at 200°C

#### Mechanical Tests

<b>Flexibility</b>	ISO 6860 (Conical Mandrel)	Pass 3 mm
<b>Adhesion</b>	ISO 2409 (2mm Crosshatch)	Gt 0
<b>Erichsen Cupping</b>	ISO 1520	Pass 7 mm
<b>Hardness</b>	ISO 1518 (2000g)	Pass - no penetration to substrate
<b>Impact</b>	ISO 6272	50 kgcm

#### Chemical and Durability Tests

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

<b>Salt Spray</b>	ISO 9227 (250 hours)	Pass - no corrosion creep more than 2mm from scribe
<b>Cyclic Humidity</b>	ISO 6270-1 (1000 hours)	Pass - no blistering or loss of gloss
<b>Distilled Water Immersion</b>	ISO 2812 (240 hours)	Pass - no blistering or loss of gloss
<b>Exterior Durability</b>	Excellent – non chalking, slight loss of gloss after 12 months continuous exposure but no film breakdown or reduction in protective properties	
<b>Chemical Resistance</b>	Generally excellent resistance to most acids, alkalis and oils at normal Temperatures.	

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**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.

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**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.

All powders can show small color differences from batch to batch, this is normal and unavoidable. While AkzoNobel take every precaution to minimize visible differences, this cannot be guaranteed. 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.

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. A constant ratio between virgin and recycled powders should be fixed by the coater in order to achieve a consistent effect. For more details it is suggested to read the "Metallic Application Guideline".

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

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

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**Additional Information**

Interpon 610HR (High Reactivity) powders are also available in selected grades for use where a lower oven temperature or shorter curing time is required.

<b>Stoving schedule</b>	15 minutes at 160°C
(object temperature)	8 minutes at 180°C
<b>Storage</b>	Dry cool conditions below 30°C
<b>Shelf life</b>	24 months

For further details on powder properties and film performance of Interpon 610HR please contact AkzoNobel.

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**Safety Precautions**

Please consult the Material Safety Datasheet (MSDS)

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**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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