Technical Datasheet

Interpon 600 Low-E

KA005QF

Low cure polyester powder coatings

Product description

Interpon 600 Low-E is a range of 'low bake' powder coatings specially engineered for curing at lower temperatures, consuming less energy and accelerating production, directly supporting a company's drive towards a net zero carbon future. The coatings sustain a longer lifespan and are available in a wide range of colors and finishes which allow your product to shine. The Interpon 600 offers not only beautiful aesthetics but also a performance to match. It is ideally suited to a broad range of exterior applications including outdoor furniture, playground equipment, signs, fencing, vending machines and general metal finishing. Can also be used for indoor application if required.

The Interpon 600 Low-E range provides total flexibility to satisfy every need. It includes a range of finishes including smooth, fine and coarse textures to suit any application, as well as gloss levels from deep matt to high gloss. And with color and shades including metallics that meet the appropriate standards such as RAL, Pantone and NCS.

Powder properties

	Typical value
Chemical Type	Polyester – TGIC
Appearance	Smooth Gloss
Color	ULTIMATE WHITE
Density	1.58 - 1.68 g/cm³
Theoretical Coverage	117.97 ft²/lb at 1 mil DFT
Gloss (60°)	80 - 100 GU
Finish Effect	Solid
Recommended film thickness	1.8 - 2.2 mils
Shelf life	12 months
Storage Conditions	Under dry, cool (<27°C, 80°F) conditions (open boxes must be resealed)
Curing schedule	15 min at 325°F (162°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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Region (POW): NAM

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Application

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.
Clearcoats including tinted clearcoats cannot be applied directly on primers. Only fully opaque shades are suitable for application over primer.
Powders can be applied by manual or automatic electrostatic spray equipment.

Coarse texture finished should be applied at minimum 80µm.

Application Method	Electrostatic
Recycling	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

Actual product performance will depend upon the circumstances under which the product is used.
Testing has been determined under laboratory conditions using the following application properties and is for guidance only.

Pre-treatment	Zinc Phosphate (B1000) or Iron Phosphate (B952)
Substrate	Cold rolled steel (CRS)
Curing schedule	10 min at 325°F (162°C) (object temperature)
Film Thickness	2 - 3 mils

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Mechanical tests

	Typical value	Method/standard
Adhesion	5B	ASTM D3359
Flexibility	Pass 1/8”	ASTM-D522
Impact resistance	≥40 kg.cm	ASTM D 2794 (d)
Pencil hardness	≥H	ASTM D 3363

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 1/8” from scribe, 500 h	ASTM B117

Environmental and durability tests

	Typical value	Method/standard
Humidity	Pass - no blistering or loss of gloss, 1000 h	ASTM D2247
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	Damaged areas must be clean and free of grease or rust. Dry-sand the area with 600 grade paper down to the substrate. The area must be completely free of dust and cleaned with a non-aggressive solvent before proceeding. 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.

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Additional Information

For application on Buildings we recommend using our Interpon D series.
Coarse texture finished should be applied at minimum 80µm.

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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http://www.interpon.com/contact-us/

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