

## Technical data sheet

<b>Date</b>	: July 10, 2018
<b>Product name</b>	: <b>Interpon ACE 2000</b>
<b>Product code</b>	: <b>QN102QF (Formerly 30-7452A)</b>
<b>Color</b>	: <b>Medium Gloss Black U1578-1</b>
<b>Product Description</b>	: <b>Interpon ACE 2000</b> is a series of super-durable polyester TGIC powder coatings designed for exterior exposure and for use as a decorative and/or functional coating for agricultural and construction equipment and components. Tested against the most severe specifications, <b>Interpon ACE 2000</b> coatings provide significantly improved gloss retention and resistance to color change.

### Powder properties

<b>Type</b>	: Polyester TGIC
<b>Particle size</b>	: Suitable for electrostatic spray
<b>High Gloss (60°)</b>	: 55-65
<b>Orange Peel</b>	: 6 min (ACT ref. Panels)
<b>Specific gravity</b>	: 1.48 +/-0.05 g/cm <sup>3</sup>
<b>Coverage at 1.0 mil</b>	: 129.93 sq.ft/lb/mil
<b>Storage conditions</b>	: Dry cool conditions (<80°F, <25°C)
<b>Shelf life</b>	: 12 months, typical
<b>Cure Schedule</b>	: 15 minutes at 375° F (190° C)
<b>Film Thickness</b>	: 2.4-4.0 mils

Failure to observe the correct curing conditions may cause difference in color, gloss and the deterioration of the coating properties.

### Test Conditions

<b>Substrate</b>	: Cold Rolled Steel
<b>Pretreatment</b>	: Iron Phosphate (B1000) or Zinc Phosphate (B952)
<b>Cure schedule</b>	: 15 minutes at 375°F (180°C) (object temperature)
<b>Film Thickness</b>	: 2.9-3.5 mils
<b>Testing condition</b>	: The results shown above 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.

### Mechanical tests

<b>Elongation – Conical Mandrel</b>	: ≤ 3 mm	ASTM D522
<b>Flexibility</b>	: 1/8" Mandrel	ASTM D522-13
<b>Adhesion</b>	: 5B, 100%	ASTM D3359-09E2
<b>Pencil Hardness (Mar)</b>	: 3H min.	ASTM D3363-05
<b>Pencil Hardness (Gouge)</b>	: 6H min.	ASTM D3363-05
<b>Impact Resistance</b>	: 120 Direct / 120 Reverse (in/lb) min.	ASTM D2794--93

## Chemical tests

<b>Salt spray</b>	: DTM: 4,000 hours min; average creepback after scraping: < 7/32"	ASTM B117
<b>Cyclical Corrosion</b>	: DTM: 20 cycles/40 cycles if over ACE Primer Average creepback after scraping: <5.0 mm	SAE J2334
<b>Florida Exposure (24 mo.)</b>	: Gloss Retention (60°): ≥ 65% Color Change (ΔE): < 4 max	ASTM D1014
<b>Humidity Resistance</b>	: No rust, no blisters, no gloss reduction after 4,000+ hours	ASTM D2247
<b>Xenon Weathering (2,000 hr)</b>	: Gloss Retention (60°): ≥ 70% Color Change (ΔE): < 3.0 max	SAE J2527-04
<b>Chemical Resistance</b>	: Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.	ASTM D870
<b>Stability at Elevated temperatures</b> : No significant change in color or gloss after 100% overbake.		

## Substrate pre-treatment

Aluminum, steel or Zinc surfaces to be coated must be clean and free from grease. Iron phosphate and particularly lightweight zinc phosphating of ferrous metals improves corrosion resistance. Aluminum substrates may require a chromate or non-chromate conversion coating.

## Application

**Interpon ACE 2000** powders can be applied by manual or automatic electrostatic spray equipment. It is recommended that for consistent application and appearance the product be fluidized during application. Unused powder can be reclaimed using suitable equipment and recycled through the coating system. For more detailed information please contact an AkzoNobel technical service representative.

## Additional Information

**Interpon ACE 2000** super durability powder is an economical and environment friendly coating. Comparing to common outdoor use powder coating, it provides better anti-corrosion performance, color stability and gloss retention after exposure. In serious application environment, a primer is necessary. However, performance is still influenced by substrate & pretreatment type and film thickness uniformity.

This product is UL1332 "Coating, Organic, for Steel Enclosure-use Electrical Equipment – Component" recognized to UL Designation **U1578-1**. For UL1332 certification all requirements must be met as designated in File: DTOV2 MH13725. As such, following are the required application standards that must be met.

Cure Cycle (min)	Cure Window (°F)	Min. Film Thickness (mils)	Pre-Treatment(s) over			
			Cold Rolled Steel	Hot Rolled Steel	Galvanized Steel	Galvaneal Steel
15	375	1.7	3 Stage Iron Phosphate	No approval over this	7 Stage Zinc Phosphate	7 Stage Zinc Phosphate

20	425			substrate	G60, G40	A60, A40
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No other substrate or pre-treatment may be used in U1578-1 designation.

## Safety Precautions

Please consult the Safety Datasheet (SDS).

### FOR PROFESSIONAL USE ONLY

**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 Safety 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. 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.

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