

Product Data Sheet

AkzoNobel Powder Coatings

Interpon ACE 2000 QN102QF (Formerly 30-7452A) Medium Gloss Black U1578-3

Product Description	<p>Interpon ACE 2000 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, Interpon ACE 2000 coatings provide significantly improved gloss retention and resistance to color change.</p>		
Powder Properties	Chemical type	Polyester TGIC	
	Appearance/Orange Peel	Smooth - 6 min (ACT ref. Panels)	
	Gloss level (Gardner 60°)	≥ 55 - ≤ 65 units	
	Recommended Film thickness	Topcoat over Primer: 2.0 min – 3.0mil max (50 – 76 μm)	
	Maximum Topcoat/Primer System Film Thickness	3.9 mil (100μm)	
	Specific gravity	1.48 +/-0.05 g/cm ³	
	Coverage @ 1.0 mil	130 sq.ft/lb/mil (27sq.m/kg/25μm)	
	Storage	Dry cool conditions (for example preferred (<80°F, <25°C and RH<50% and not above 95°F, 35°C). Wet storage conditions to be avoided.	
	Shelf life	12 months	
Curing schedule (at object temperature)	<ul style="list-style-type: none"> – 45 minutes at 350° F – 15 minutes at 375° F – 8 minutes at 400° F <p>Failure to observe the correct curing conditions and DFT may cause a difference in color, gloss, and the deterioration of the coating properties.</p>		
Mechanical Tests	Elongation – Conical Mandrel	ASTM D522	≤ 3 mm
	Adhesion	ASTM D3359	5B
	Hardness (Gouge)	ASTM D3363	≥ H
	Impact Resistance	ASTM D2794	≥ 40 Direct / ≥ 20 Reverse (in*lb)
Environmental and Durability Tests	Salt Spray	ASTM B117	DTM: 240 hours min; average creepback after scraping: <3.0 mm
	Cyclical Corrosion	SAE J2334	40 cycles over ACE Primer. Average creepback after scraping: <5.0 mm
	Florida Exposure (24 mo.)	ASTM D1014	Gloss Retention (60°): ≥ 65% Color Change (ΔE): < 4 max
	Humidity Resistance	ASTM D2247	No rust, no blisters, no gloss reduction after 1,000 hours
	Chemical Resistance	ASTM D870	Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.
	Stability at Elevated Temperatures	No significant change in color or	

	gloss after 100% overbake.
Exterior Durability	Yes

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

Substrate	Cold Rolled Steel
Pretreatment	Iron Phosphate (B1070)
Topcoat/Primer System Film Thickness	2.8 – 3.6 mils
Cure schedule	15 minutes at 375°F

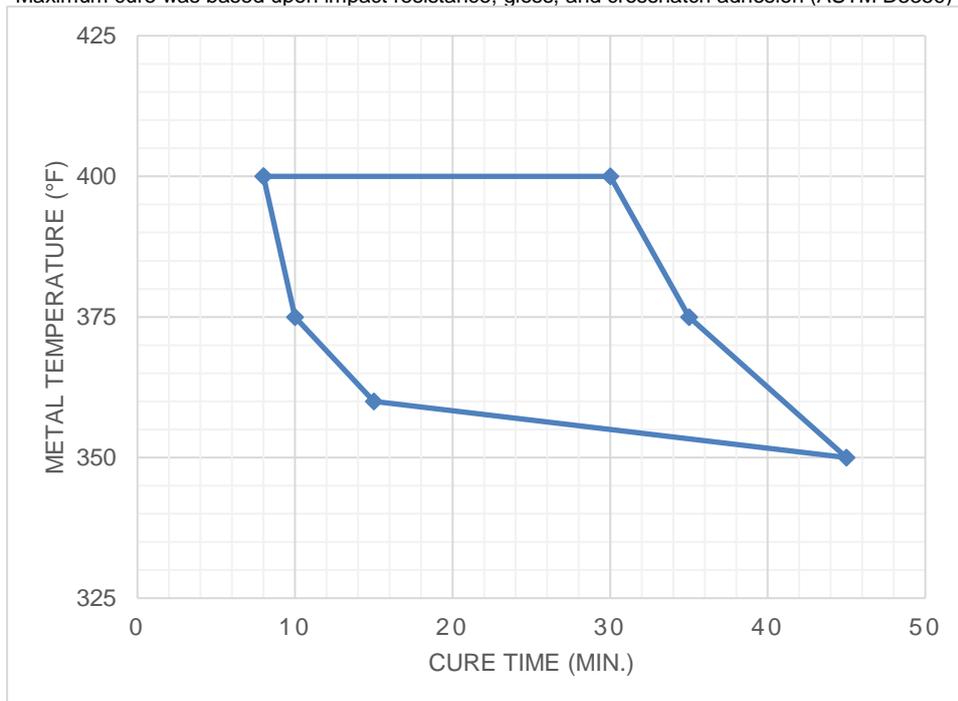
Actual film performance will depend on the individual circumstances in which the product is used.

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.

*Maximum cure was based upon impact resistance, gloss, and crosshatch adhesion (ASTM D3359)



* Minimum cure was based upon MEK resistance, impact resistance, gloss, and crosshatch adhesion (ASTM D3359)

**Safety
Precautions**

Please consult the Safety Datasheet (SDS).

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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