

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon ACE 510 ML877D

<b>Product Description</b>	<p><b>Interpon ACE 510</b> is a series of standard durable polyester TGIC-Free powder coatings designed for exterior exposure and for use as a decorative and/or functional coating for agricultural and construction equipment and components. <b>Interpon ACE 510</b> coatings provide exceptional protective qualities, possess outstanding transfer efficiency and faraday cage penetration, and are available in a wide range of color and gloss levels.</p>		
<b>Powder Properties</b>	<b>Chemical type</b>	Polyester TGIC-Free	
	<b>Area of usage</b>	Components for air compressors	
	<b>Appearance</b>	Smooth	
	<b>Gloss level (60°)</b>	35 ± 5 GU	
	<b>Colour</b>	Atlas Copco Dark Grey B as sample	
	<b>Recommended Film Thickness (µm)</b>	60 - 80 µm	
	<b>Density (g/cm<sup>3</sup>)</b>	1.59 ± 0.05	
	<b>Application</b>	Tribo and electrostatic	
	<b>Storage</b>	Under dry, cool (<25°C) conditions	
	<b>Shelf life</b>	At least 12 months from production date	
	<b>Curing schedule</b> (at object temperature)	15 min at 180°C	
<b>Mechanical Tests</b>	<b>Adhesion</b>	DIN EN ISO 2409	Gt 0
	<b>Impact resistance</b>	ASTM D 2794	> 20 ip (reverse)
<b>Environmental and Durability Tests</b>	<b>Neutral Salt Spray</b>	DIN EN ISO 9227	240 h Corrosion creep < 2 mm from scribe
	<b>Humidity</b>	DIN EN ISO 6270-2	240 h no blistering or loss of gloss
	<b>Artificial Testing</b>	QUV-B Test > 50% gloss retention after 200 h	
<b>Test Conditions</b>	Testing has been determined under laboratory conditions using the following application properties and is for guidance only.		
	<b>Substrate</b>	Steel panels, Aluminium	
	<b>Pretreatment</b>	Bonder (LH) iron phosphate, Bonder (722) yellow chromate	
	<b>Film thickness</b>	60 µm	
	<b>Cure schedule</b>	15 minutes at 180°C	
Actual film performance will depend on the individual circumstances in which the product is used.			

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<b>Pre-treatment</b>	Steel surfaces to be coated must be clean and free from grease. For maximum protection it is essential to pre-treat components prior to the application of <b>Interpon ACE 510</b> . Iron Phosphate and Zinc Phosphate of ferrous metals improve corrosion resistance. Aluminium parts require a chromate or chromate-free conversion pre-treatment.
<b>Application</b>	<b>Interpon ACE 510</b> powders can be applied by manual or automatic electrostatic spray equipment. It is recommended that for consistent application and appearance product be fluidized during application. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.
<b>Safety Precautions</b>	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.
<b>Disclaimer</b>	<p><b>IMPORTANT NOTE:</b> 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.</p> <p>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.</p> <p>Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel</p>

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Author: E.T.Kok