

# Product Data Sheet

## AkzoNobel Powder Coatings Interpon ACE 2010 YE006I Yellow Gloss Smooth

### Product Description

**Interpon ACE 2010** is a series of superior UV and weather resistant TGIC-free polyester powder coatings designed for exterior exposure and for use as a decorative and/or functional coating for agricultural and construction equipment and components. These coatings also provide significantly improved gloss retention and resistance to color change and possess outstanding transfer efficiency and faraday cage penetration.

### Powder Properties

<b>Chemical type</b>	Polyester super-durable (TGIC-free)
<b>Area of usage</b>	Exterior parts for agricultural machinery or construction equipment
<b>Particle Size</b>	Custom manufactured
<b>Appearance</b>	Smooth, glossy
<b>Colour</b>	Yellow
<b>Gloss (60°)</b>	≥ 90 GU
<b>Density (g/cm<sup>3</sup>)</b>	1,4 ± 0,1
<b>Stoving schedule</b>	15-30 minutes at 180°C, 10-25 minutes at 190°C, 8-20 minutes at 200°C (time at object temperature)
<b>Recommended DFT</b>	DTM: 70µm min - 110µm max; On Primer: 50µm min - 90µm max; On e-coat 45µm min - 90µm max Failure to observe the correct curing and DFT conditions may cause a difference in color, gloss and the deterioration of the coating properties
<b>Application</b>	Electrostatic
<b>Storage Stability</b>	Under dry, cool (<25°C) conditions, at least 12 months from production date.

### Test Conditions

The results 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>	Cold Rolled Steel
<b>Pretreatment</b>	Iron phosphate pretreated panels (ACT Bonderite <sup>o</sup> 1070 DIW Panels)
<b>Film Thickness</b>	76-90 µm
<b>Cure Schedule</b>	15 minutes at 190°C

### Mechanical Tests

<b>Elongation</b>	ASTM-D522 (conical mandrel)	No crack at max elongation
<b>Adhesion</b>	ASTM-D3359 (2 mm crosscut)	5B
<b>Hardness</b>	ASTM D3363 (Gouge)	3H

### Corrosion and Chemical Tests

<b>Cyclic Corrosion</b>	SAE J2334	40 days corrosion creep ≤ 3,5 mm from scribe
<b>Chemical resistance</b>		Good resistance to DI water, diesel fuel and engine oil

### Durability Tests

<b>Exterior durability</b>	SAE J2527	2000h, excellent color and gloss retention performance
<b>Color stability at elevated temperature</b>		Good

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## Pretreatment

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.

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## Application

**Interpon ACE 2010 YE006I** 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.

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## 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.

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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. 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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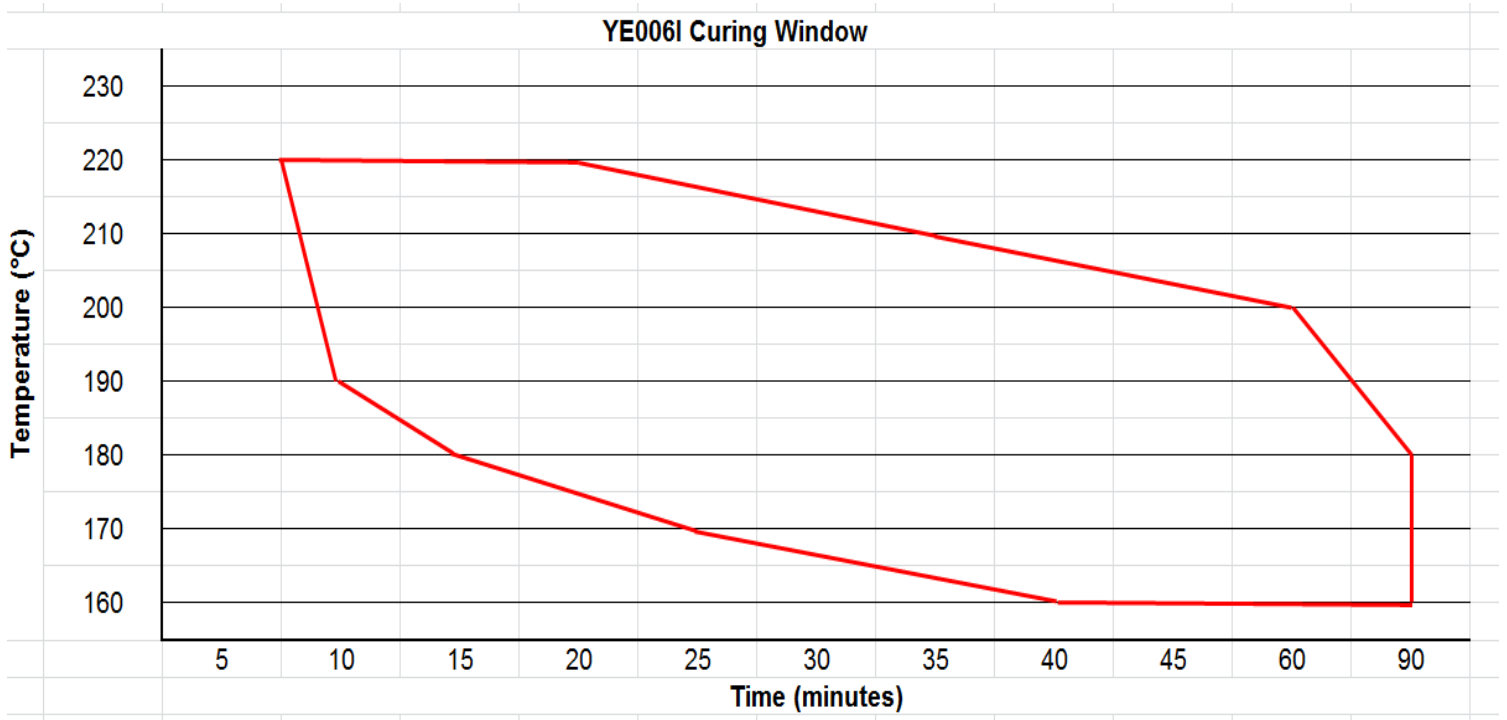
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