AkzoNobel Powder Coatings
3 Commerce Drive
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Tel 610-685-7600

Product Data Sheet

AkzoNobel Powder Coatings

Interpon ACE 600 HT
WN304QF (Formerly 99-71003)
Black

Product Description	**Interpon ACE 600 HT** is a series of silicone based powder coatings developed for the agricultural and construction equipment market. These coatings provide corrosion protection and appearance integrity on components such as exhaust manifolds and mufflers that require extreme high heat temperatures up to 600°C (1,112°F) over blasted carbon steel and 510°C (950°F) over aluminized steel. **Interpon ACE 600 HT** is competitive with many established liquid coating technologies in even the most demanding of applications where heat resistance is required.		
Powder Properties	**Chemical type**	Silicone Polyester	
	Gloss level (Gardner 60°)	10 - 20 units	
	Recommended Film thickness	2.0 - 3.5mil (50 - 89µm)	
	Maximum Film Thickness	3.9 mils (100µm)	
	Specific gravity	1.99 g/cm^3	
	Coverage @ 1.0 mil	97.0 sq.ft/lb/mil (20.0 sq.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)	– 15 minutes at 450° F – 10 minutes at 475° F – 8 minutes at 500° F Failure to observe the correct curing conditions and DFT may cause a difference in color, gloss, and the deterioration of the coating properties.	
Mechanical Tests	**Adhesion**	ASTM D3359	≥4B
	Hardness (Gouge)	ASTM D3363	≥ 5H
	Impact Resistance	ASTM D2794	≥ 100 Direct (in*lb)
Environmental and Durability Tests	**Salt Spray**	ASTM B117	336 hours min; average creepback after scraping: <3.0 mm
	Cyclical Corrosion	SAE J2334	20 cycles – pass, no blisters and corrosion. Average creepback after scraping: ≤1.0mm
	Humidity Resistance	ASTM D2247	No rust, no blisters, no gloss reduction after 336 hours
	Thermal Exposure (510°C, 950°F) – 4 hrs - Aluminized Steel (600°C, 1,112°F) – 4 hrs - Blasted Carbon Steel		Pass – Very slight fading
	Thermal Exposure w/Water Quench		No cracking or adhesion loss

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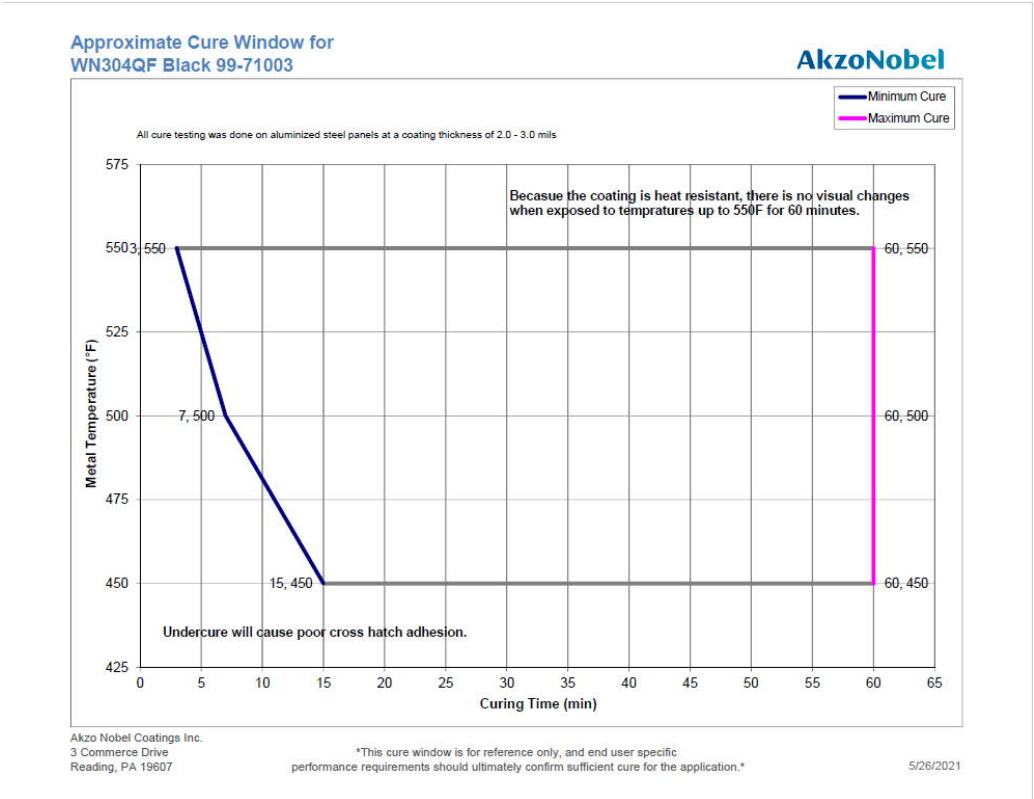
Test Conditions	Testing has been determined under laboratory conditions using the following application properties and is for guidance only.	
	Substrate	Aluminized Steel and Blasted Carbon Steel
	Pretreatment	Blasted surface for carbon steel only
	Film thickness	2.0 - 3.5mil (50 - 89µm)
	Cure schedule	15 minutes at 450°F (232°C) (object temperature).
	Actual film performance will depend on the individiual circumstances in which the product is used.	
Pre-treatment	A multi-stage clean only process is recommended for optimum performance. Sandblasting improves adhesion and performance. Pretreatment system should be tested to verify performance.	
Application	**Interpon ACE 600 HT** 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	WN304QF (Formerly 99-71003) has final approval for 1E2397A High Temperature Black Topcoat on Aluminized Steel (510°C).	



Maximum and minimum cure determine via MEK resistance and crosshatch adhesion (ASTM D3359).

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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.

Disclaimer

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

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