

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon ACE 2010 YJ000QF NH Blue

|                                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                       |                                                                                         |
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| <b>Product Description</b>                | 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. Tested against the most severe specification, Interpon ACE 2010 coatings provide significantly improved gloss retention and resistance to color change. Additionally, these coatings possess outstanding transfer efficiency and faraday cage penetration. |                                                                                                                                                                       |                                                                                         |
| <b>Powder Properties</b>                  | <b>Chemical type</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Polyester TGIC-Free                                                                                                                                                   |                                                                                         |
|                                           | <b>Appearance/Orange Peel</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Smooth - 6 min (ACT ref. Panels)                                                                                                                                      |                                                                                         |
|                                           | <b>Gloss level (Gardner 20°)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 80 +                                                                                                                                                                  |                                                                                         |
|                                           | <b>Gloss level (Gardner 60°)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 90 +                                                                                                                                                                  |                                                                                         |
|                                           | <b>Recommended Film thickness</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 2.0 – 2.5mil                                                                                                                                                          |                                                                                         |
|                                           | <b>Specific gravity</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 1.25 +/-0.05 g/cm <sup>3</sup>                                                                                                                                        |                                                                                         |
|                                           | <b>Coverage @ 1.0 mil</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 153.8 sq.ft/lb/mil                                                                                                                                                    |                                                                                         |
|                                           | <b>Storage</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Dry cool conditions (<80°F, <25°C)                                                                                                                                    |                                                                                         |
|                                           | <b>Shelf life</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 12 months                                                                                                                                                             |                                                                                         |
| <b>Mechanical Tests</b>                   | <b>Curing schedule</b><br>(at object temperature)                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <ul style="list-style-type: none"> <li>- 15-30 minutes at 350°F (180°C)</li> <li>- 10-25 minutes at 375°F (190°C)</li> <li>- 8-20 minutes at 390°F (200°C)</li> </ul> |                                                                                         |
|                                           | <b>Elongation – Conical Mandrel</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | ASTM D522                                                                                                                                                             | ≤ 3 mm                                                                                  |
|                                           | <b>Adhesion</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | ASTM D3359                                                                                                                                                            | 5B                                                                                      |
|                                           | <b>Hardness (Gouge)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | ASTM D3363                                                                                                                                                            | ≥ H                                                                                     |
|                                           | <b>Impact Resistance</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | ASTM D2794                                                                                                                                                            | ≥ 40 Direct / ≥ 20 Reverse (in*lb)                                                      |
| <b>Environmental and Durability Tests</b> | <b>Salt Spray</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | ASTM B117                                                                                                                                                             | DTM: 240 hours min; average creepback after scraping: <3.0 mm                           |
|                                           | <b>Cyclical Corrosion</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | SAE J2334                                                                                                                                                             | DTM: 20 cycles/40 cycles if over ACE Primer. Average creepback after scraping: <5.0 mm  |
|                                           | <b>Florida Exposure (24 mo.)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | ASTM D1014                                                                                                                                                            | Gloss Retention (60°): ≥ 65%<br>Color Change (ΔE): < 4 max                              |
|                                           | <b>Humidity Resistance</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | ASTM D2247                                                                                                                                                            | No rust, no blisters, no gloss reduction after 1,000 hours                              |
|                                           | <b>Chemical Resistance</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | ASTM D870                                                                                                                                                             | Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant. |
|                                           | <b>Stability at Elevated Temperatures</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                       | No significant change in color or gloss after 100% overbake.                            |
|                                           | <b>Exterior Durability</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                       | Yes                                                                                     |
| <b>Test Conditions</b>                    | Testing has been determined under laboratory conditions using the following application properties and is for guidance only.                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                       |                                                                                         |

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|-------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|
|                               | <b>Substrate</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Cold Rolled Steel                               |
|                               | <b>Pretreatment</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Iron Phosphate (B1000) or Zinc Phosphate (B952) |
|                               | <b>Film thickness</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 2.4 – 3.6 mils                                  |
|                               | <b>Cure schedule</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 20 minutes at 350°F                             |
|                               | Actual film performance will depend on the individual circumstances in which the product is used.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                 |
| <b>Pre-treatment</b>          | 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                 |
| <b>Application</b>            | <b>Interpon ACE 2010</b> 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                 |
| <b>Additional Information</b> | <b>Interpon ACE 2010</b> 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                 |
| <b>Safety Precautions</b>     | Please consult the Safety Datasheet (SDS).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                 |
| <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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