

## Technical data sheet

<b>Date</b>	: 9/20/2012
<b>Product name</b>	: <b>Interpon ACE 2010</b>
<b>Product code</b>	: <b>YJ000QF</b>
<b>Color</b>	: <b>NH Blue – Interpon ACE 2010</b>
<b>Product Description</b>	: <b>Interpon ACE 2010</b> 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 specifications, <b>Interpon ACE 2010</b> coatings provide significantly improved gloss retention and resistance to color change. Additionally, these coatings possess outstanding transfer efficiency and faraday cage penetration.

### Powder properties

<b>Type</b>	: Polyester TGIC Free
<b>Particle size</b>	: Suitable for electrostatic spray
<b>High Gloss (60°)</b>	: $\geq 80\%$
<b>Orange Peel</b>	: 6 min (ACT ref. Panels)
<b>Specific gravity</b>	: 1.26+/-0.05 g/cm <sup>3</sup>
<b>Coverage at 1.0 mil</b>	: 152.6 sq.ft/lb/mil
<b>Storage conditions</b>	: Dry cool conditions (<80°F, <25°C)
<b>Shelf life</b>	: 12 months, typical
<b>Cure Schedule</b>	: 15-30 minutes at 350° F (180° C) 10-25 minutes at 375° F (190° C) 8-20 minutes at 390° F (200° C)

Failure to observe the correct curing conditions may cause difference in color, gloss and the deterioration of the coating properties.

### Test Conditions

<b>Substrate</b>	: Cold Rolled Steel
<b>Pretreatment</b>	: Iron Phosphate (B1000) or Zinc Phosphate (B952)
<b>Cure schedule</b>	: 20 minutes at 350°F (190°C) (object temperature)
<b>Film Thickness</b>	: 2.0-3.0 mils
<b>Testing condition</b>	: The results shown above 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.

### Mechanical tests

<b>Elongation – Conical Mandrel</b>	: $\leq 3$ mm	ASTM D522
<b>Adhesion</b>	: 5B	ASTM D3359
<b>Hardness (Gouge)</b>	: $\geq H$	ASTM D3363
<b>Impact Resistance</b>	: $\geq 40$ Direct / $\geq 20$ Reverse (in*lb)	ASTM D2794

## Chemical tests

<b>Salt spray</b>	: DTM: 240 hours min; average creepback after scraping: < 3.0 mm	ASTM B117
<b>Cyclical Corrosion</b>	: DTM: 20 cycles/40 cycles if over ACE Primer Average creepback after scraping: <5.0 mm	SAE J2334
<b>Florida Exposure (24 mo.)</b>	: Gloss Retention (60°): $\geq 65\%$ Color Change ( $\Delta E$ ): < 4 max	ASTM D1014
<b>Humidity Resistance</b>	: No rust, no blisters, no gloss reduction after 1,000 hours	ASTM D2247
<b>Chemical Resistance</b>	: Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.	ASTM D870
<b>Stability at Elevated temperatures</b>	: No significant change in color or gloss after 100% overbake.	

## Substrate 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 2010** 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 2010** 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.

## 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

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