

Product Data Sheet

AkzoNobel Powder Coatings

Interpon ACE 1010 OE500D

Product Description	<p>Interpon ACE 1010 is a series of high durability 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. Interpon ACE 1010 coatings provide significantly improved gloss retention and resistance to color change and possess outstanding transfer efficiency and faraday cage penetration.</p>		
Powder Properties	Chemical type	Polyester TGIC-Free	
	Area of usage	Exterior parts for agricultural machinery or construction equipment	
	Appearance	Smooth	
	Gloss level (60°)	81 ± 3 GU	
	Colour	YELLOW VCE 5001	
	Recommended Film Thickness (µm)	60 - 80 µm	
	Density (g/cm³)	1.60 ± 0.05	
	Application	Electrostatic	
	Storage	Under dry, cool (<25°C) conditions	
	Shelf life	At least 12 months from production date	
	Curing schedule (at object temperature)	15 min at 190°C 10 min at 200°C 8 min at 210°C	
Mechanical Tests	Adhesion	ISO 2409	Gt 0
	Impact resistance	ISO 6272	20 lb (reverse and direct)
	Erichsen Cupping	ISO 1520	Pass 7 mm
	Flexibility	ISO 6860	Pass 3 mm (Conical mandrel)
Environmental and Durability Tests	Neutral Salt Spray	ISO 9227	250 h Corrosion creep < 2 mm from scribe.
	Humidity	ISO 6270-2	1000 h Corrosion creep < 2 mm from scribe. No change of visual appearance
	Exterior Durability	QUV-B test >50 % gloss retention after 200 h	
Test Conditions	<p>Testing has been determined under laboratory conditions using the following application properties and is for guidance only.</p>		
	Substrate	Steel, Aluminium	
	Pretreatment	Ironphosphate (Bonder LH), Yellow chromate	
	Film thickness	60 µm	
	Cure schedule	10 minutes at 200°C	
	<p>Actual film performance will depend on the individual circumstances in which the product is used.</p>		

Pre-treatment	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 Interpon ACE 1010 . Iron Phosphate and Zinc Phosphate of ferrous metals improve corrosion resistance. Aluminium parts require a chromate or chromate-free conversion pre-treatment.
Application	Interpon ACE 1010 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.
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.
Disclaimer	<p>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 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>

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

Copyright © 2021 Akzo Nobel Powder Coatings Ltd. Interpon is a registered trademark of AkzoNobel

Interpon ACE 1010 – OE500D - Issue #2

Last Revision Date: 03.08.2021

Author: E.T.Kok