

# Product Data Sheet

## AkzoNobel Powder Coatings

### High Performance Primer Interpon® ACE Primer

#### Product Description

Interpon® ACE Primer is a series of pure epoxy or epoxy-polyester coatings designed for use as a basecoat primer over pretreated cold or hot rolled steel substrates associated with agricultural and construction equipment and components. Interpon® ACE Primer, when used in combination with any Interpon® ACE topcoat, provides a high level of corrosion protection and good edge coverage. Superior physical properties and with excellent adhesion between substrate and topcoat assures that the coating integrity will be there when needed.

#### Powder Properties

<b>Particle size</b>	Suitable for electrostatic spray
<b>Chemical type</b>	Epoxy or Epoxy-Polyester
<b>Gloss (60°)</b>	45% – 85%
<b>Orange Peel</b>	6 min (ACT ref. Panels)
<b>Density</b>	1.2 – 1.8 g/cm <sup>3</sup> Depending on Color
<b>Storage</b>	Dry cool conditions (<80°F, <25°C)
<b>Shelf life</b>	12 months, typical
<b>Cure Schedule</b>	10 - 20 minutes at 350°F (180°C) (object temperature) 8 - 12 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

The results shown below 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 (B1000) or Zinc Phosphate (B952)
<b>Film Thickness</b>	40-90 µm
<b>Cure Schedule</b>	12 minutes at 390°F (200°C) (object temperature)

#### Mechanical Tests

	Method	Result
<b>Adhesion</b>	ASTM D3359	5B
<b>Hardness</b>	ASTM-D3363 (Gouge)	≥ F
<b>Impact Resistance</b>	ASTMD2794	≥ 40 Direct / ≥ 20 Reverse (in*lb)
<b>Elongation - Conical Mandrel</b>	ASTM D522	≤ 5 mm

#### Chemical and Durability Tests

<b>Salt Spray</b>	ASTM B117	336 hours min Average Creepback after Scraping: < 3.0 mm
<b>Cyclical Corrosion</b>	SAE J2334	20 cycles- pass, no blisters and corrosion Average Creepback after Scraping: <3.0 mm
<b>Humidity Resistance</b>	ASTM D2247	No rust, no blisters, no gloss reduction after 1000 hours
<b>Chemical Resistance</b>	ASTM D870	Good immersion resistance to water, diesel fuel, engine oil, gasoline, and engine coolant.

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### 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.

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### Application

Interpon® ACE Primer 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 AKZO NOBEL technical service people.

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### Additional Information

Interpon® ACE Primer powder is an economical and environment friendly coating. Comparing to common indoor use powder coating, it provides good adhesion and anti-corrosion performance as a primer when topcoat was applied. However, performance is still influenced by substrate & pretreatment type and film thickness uniformity. The top coat should be ideally applied within 2 hours, so that dust and contamination cannot deposit on the primer coating. Further details on the use of primer powder coating please contact Akzo Nobel.

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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 AkzoNobel has provided to its customer. If for any reason a copy of the relevant health and safety data sheet is not immediately available the user should contact AkzoNobel to obtain a copy before using the product. When using, do not eat, drink or smoke. All dusts are respiratory irritants. Therefore, inhalation of the dust or of the vapors resulting from the cure should be avoided. Take steps to prevent skin contact, but should contact occur, wash skin with soap and water. In case of eye contact flush immediately with clean water and seek medical advice. Dust clouds of any finely divided organic material can be ignited with an electric spark or open flame. Dust and powder should not be allowed to build up on surfaces or ledges. Dust collection equipment should be used which has provision for adequate explosion release. All equipment should be electrically earthed to prevent build up of static.

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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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