

Product Data Sheet

AkzoNobel Powder Coatings

Interpon ACE 1000LE KN000QF (FORMERLY 30-71038) BLACK – INTERPON ACE 1000 LE

Product Description	<p>Interpon ACE 1000 LE is a series of high durability polyester TGIC 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 1000 LE coatings offer the benefit of curing with lower oven temperature settings or increasing line speeds to improve throughput under normal temperature settings. These coatings also possess outstanding over bake resistance and excellent mechanical properties and provide significantly improved gloss retention and resistance to color change.</p>		
Powder Properties	Chemical type	Polyester TGIC	
	Appearance/Orange Peel	Smooth - 6 min (ACT ref. Panels)	
	Gloss level (Gardner 20°)	≥ 90.0 UN	
	Gloss level (Gardner 60°)	≥ 80.0 UN	
	Recommended Film thickness	2.0 – 2.5 MILS	
	Specific gravity	1.22 +/-0.05 g/cm ³	
	Coverage @ 1.0 mil	158 sq.ft/lb/mil	
	Storage	Dry cool conditions (<80°F, <25°C)	
	Shelf life	12 months	
	Curing schedule (at object temperature)	15 minutes at 325°F 15-30 minutes at 300° F 10-20 minutes at 350° F	
Mechanical Tests	Elongation – Conical Mandrel	ASTM D522	≤ 3 mm
	Adhesion	ASTM D3359	5B
	Hardness (Gouge)	ASTM D3363	≥ H
	Impact Resistance	ASTM D2794	≥ 40 Direct / ≥ 20 Reverse (in*lb)
Environmental and Durability Tests	Salt Spray	ASTM B117	DTM: 240 hours min; average creepback after scraping: <3.0 mm
	Cyclical Corrosion	SAE J2334	DTM: 20 cycles/40 cycles if over ACE Primer. Average creepback after scraping: <5.0 mm
	Florida Exposure (12 mo.)	ASTM D1014	Gloss Retention (60°): ≥ 50% Color Change (ΔE): < 4 max
	Humidity Resistance	ASTM D2247	No rust, no blisters, no gloss reduction after 1,000 hours
	Chemical Resistance	ASTM D870	Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.
	Stability at Elevated Temperatures		No significant change in color or gloss after 100% overbake.
	Exterior Durability		Yes

Test Conditions	Testing has been determined under laboratory conditions using the following application properties and is for guidance only.
Substrate	Cold Rolled Steel
Pretreatment	Iron Phosphate (B1000) or Zinc Phosphate (B952)
Film thickness	2.4 – 3.6 mils
Cure schedule	20 minutes at 350°F
	Actual film performance will depend on the individual circumstances in which the product is used.
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 1000LE 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 1000LE high 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.
Key Product Attributes	
Safety Precautions	Please consult the Safety Datasheet (SDS).
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 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.</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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