Akzo Nobel Coatings Inc. – Powder Coatings
3 Commerce Drive
Reading, PA 19607
Tel 610-775-6640

Technical data sheet

Date	: 11/8/2012
Product name	: **Interpon ACE 1000**
Product code	: **JK030QF (Formerly 30-6142)**
Color	: **Ag Green – Interpon ACE 1000**
Product Description	: **Interpon ACE 1000** 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 agriculatural and construction equipment and components. **Interpon ACE 1000** coatings posses outstanding over bake resistance and excellent mechanical properties and provide significantly improved gloss retention and resistance to color change.

Powder properties

Type	: Polyester TGIC
Particle size	: Suitable for electrostatic spray
High Gloss (60°)	: ≥ 80%
Orange Peel	: 6 min (ACT ref. Panels)
Specific gravity	: 1.26 +/-0.05 g/cm³
Coverage at 1.0 mil	: 152.61 sq.ft/lb/mil
Storage conditions	: Dry cool conditions (<80°F, <25°C)
Shelf life	: 12 months, typical
Cure Schedule	: 15-30 minutes at 355° 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

Substrate	: Cold Rolled Steel
Pretreatment	: Iron Phosphate (B1000) or Zinc Phosphate (B952)
Cure schedule	: 15 minutes at 375°F (190°C) (object temperature)
Film Thickness	: 2.0-3.0 mils
Testing condition	: 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

Elongation – Conical Mandrel	: ≤ 3 mm	ASTM D522
Adhesion	: 5B	ASTM D3359
Hardness (Gouge)	: ≥ H	ASTM D3363
Impact Resistance	: ≥ 40 Direct / ≥ 20 Reverse (in*lb)	ASTM D2794

Chemical tests

Salt spray	: DTM: 240 hours min; average creepback after scraping: < 3.0 mm	ASTM B117
Cyclical Corrosion	: DTM: 20 cycles/40 cycles if over ACE Primer Average creepback after scraping: <5.0 mm	SAE J2334
Florida Exposure (12 mo.)	: Gloss Retention (60°): ≥ 50% Color Change (ΔE): < 4 max	ASTM D1014
Humidity Resistance	: No rust, no blisters, no gloss reduction after 1,000 hours	ASTM D2247
Chemical Resistance	: Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.	ASTM D870
Stability at Elevated temperatures	: 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 1000 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 1000 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.

Safety Precautions

Please consult the Safety Datasheet (SDS).

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.