

Product Datasheet



AkzoNobel

BU Powder Coatings
Superior Performance Primer
Interpon® ACE Primer Plus
EL19HI – Dawn Gray color

Product Description

Interpon® ACE Primer Plus 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 Plus** uses anticorrosive pigments to provide a steel passivation effect to protect the substrate. When used in combination with any Interpon® ACE topcoat, **Interpon® ACE Primer Plus** provides a superior 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

Particle size	Suitable for electrostatic spray
Chemical type	Epoxy-Polyester Hybrid
Gloss (60°)	70% ± 5%
Density	1.88 ± 0.01 g/cm ³
Storage	Dry cool conditions (for example preferred <25°C and RH<50% and not above 35°C). Wet storage conditions to be avoided
Shelf life	12 months
Recommended DFT	35µm min - 50µm max
Cure Schedule	10-20 minutes at 160°C; 7-14 min. at 180°C; 5-10 min. at 200°C; 3-6 min. at 220°C max (object temperature)

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.

Substrate:	Cold Rolled Steel
Pretreatment:	Iron Phosphate pretreated panels (ACT Bonderite® 1070 DIW Panels)
Film Thickness:	38-45 µm
Cure Schedule:	10 minutes at 180°C (object temperature)

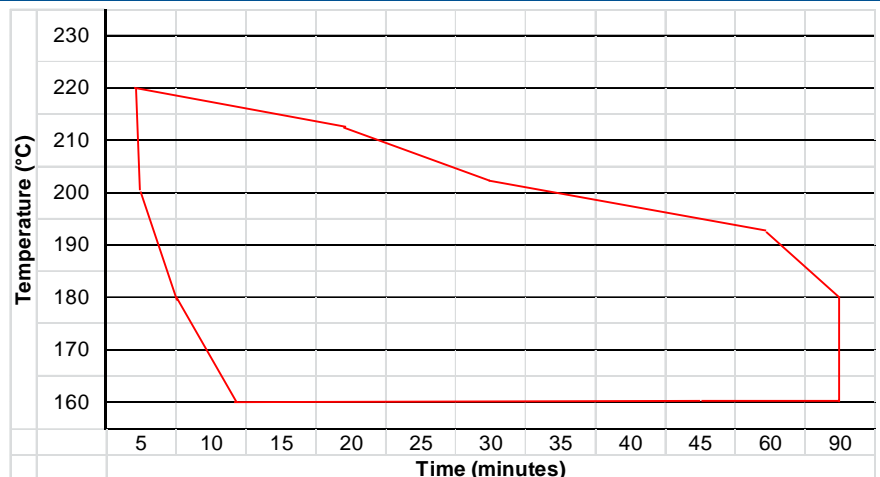
Mechanical Tests

Adhesion	ASTM D3359	4B
Hardness	ASTM-D3363 (Gouge)	2H
Elongation - Conical Mandrel	ASTM D522	24%

Chemical and Durability Tests

Cyclical Corrosion	SAE J2334	Good resistance to 40 cycles test. When topcoated it could provide longer testing resistance.
Chemical Resistance		Good resistance to water, diesel fuel, engine oil, gasoline and engine coolant.

Curing Window



AkzoNobel Powder Coatings GmbH. Tel: +49 2932 6299 0 Fax: +49 29326299 40 www.interpon.com
 Copyright ©2010 AkzoNobel Powder Coatings Ltd.
 Interpon is a registered trademark of AkzoNobel

Interpon ACE Primer Plus – EL19HI – Issue 1
 Issued 31/10/15





BU Powder Coatings
Superior Performance Primer
Interpon® ACE Primer Plus
EL19HI – Dawn Gray color

Pretreatment

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 Primer Plus, EL19HI, powder 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.

Additional Information

Interpon® ACE Primer Plus, EL19HI, 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.

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.

***Disclaimer.** The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this 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. Whilst we endeavor to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*