Product Data Sheet

AkzoNobel Powder Coatings

Interpon ACE 2010 LE
YE051F

Product Description

Interpon ACE 2010 LE is a series of superior UV and weather resistant TGIC-free polyester powder coatings designed for exterior exposure and for use as a decorative and/or functional coating for agricultural and construction equipment and components. Tested against the most severe specifications, **Interpon ACE 2010 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 provide significantly improved gloss retention and resistance to color change and possess outstanding transfer efficiency and faraday cage penetration.

Powder Properties

Chemical type	Polyester super-durable (TGIC-free)
Area of usage	Exterior parts for agricultural machinery or construction equipment
Particle Size	Custom manufactured
Appearance	Smooth, glossy
Colour	Bright Yellow CNH
Gloss (60°)	≥ 90 to ≤ 95 GU
Density (g/cm^3)	1,40 ± 0,1
Stoving schedule	25 minutes at 160°C (time at object temperature) For further info about curing window please contact Akzo Nobel
Application	Electrostatic
Storage Stability	Under dry, cool (<25°C) conditions, at least 6 months from production date.

Test Conditions

The results 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 (B1000)
Film Thickness	70-90 µm
Cure Schedule	25 minutes at 160°C

Mechanical Tests

Adhesion	ASTM 3359	≥ 4B
Hardness	ASTM D3363	≥ 2H
Hardness Persoz	ASTM D4366 met.B	≥ 250
Impact	ASTM D2794	≥ 40 kg cm (reverse)
Elongation	ASTM D522 met.A	Max. elongation, no cracks or adhesion loss beyond 5mm from mandrel end

Corrosion and Chemical Tests

Salt Spray (1000 h)	ASTM B117 ASTM D1654, proc. A Method 2	Scribed, Rating 7
Cyclical Corrosion (5 Cycles)	CNH MTM0106 ASTM D1654, proc. A Method 2	Rating 9 min.

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Corrosion and Chemical Tests	**Humidity** (600 h) (complete finish system)	ASTM D1735 ASTM D523 ASTM D1729 ASTM D714	10 min recovery Gloss Retention: 60° = 95% minimum 20° = 95% minimum No visual color change
	Chemical Resistance (Exposure time, minimum)	CNH MTM0108	Gasoline = 1.0 h Diesel Fuel = 1.0 h Antifreeze (50:50) = 6 h Grease = 24 h Motor Oil = 24 h Diesel Engine Oil = 24 h Pesticide/Herbicide = TBD
Exterior Durability	**Florida Exposure** (24 months)	ASTM D1014	Gloss Retention: 60° = 75% minimum 20° = 45% minimum ΔE* = 5.0 change, max.

Additional information

Interpon ACE 2010 LE super 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.

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 2010 LE 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.

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

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