

**Interpon**  
powder coatings  
**EVERY COLOR IS GREEN**



**Interpon® ACE**  
for Agricultural and Construction Equipment



# Interpon® ACE Powder Coatings

Setting new standards of quality and performance to safeguard your investments.



## A Premier Line of Powder Coatings

AkzoNobel Powder Coatings has developed a premier line of powder coatings designed specifically for the unique demands of the **Agricultural and Construction Equipment (ACE)** market.

With the extreme climatic differences across the world, machinery and equipment can be exposed to environments with a vast range of temperatures and humidity, with varying degrees of sunlight intensity and salinity. With these kinds of uncompromising forces, it is essential to have a powder coating finish that can meet rigorous performance demands under all conditions – one that customers will have the confidence in to remain strong and undamaged over time.

To this end, we developed the **Interpon® ACE MasterSpec** specification.

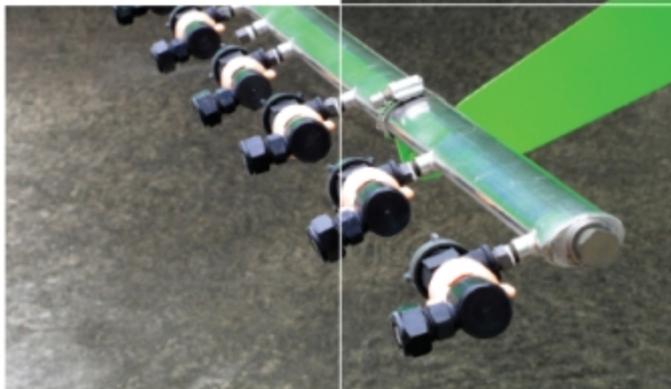
## Quality Assured by Interpon® ACE MasterSpec

The unique **Interpon® ACE MasterSpec** guarantee serves to certify and ensure the high quality of our products for the ACE market. Products marked with the **Interpon® ACE MasterSpec** logo have a proven track record against the most stringent specifications within the global ACE market.

Supported by long term product development, the **Interpon® ACE 1000 and 2000 series** comply with even the most rigorous and demanding OEM criteria while maintaining a high quality finish.

## Specially Formulated For

- ▶ Construction Equipment
- ▶ Agricultural Equipment
- ▶ Material Handling Equipment
- ▶ Forestry Equipment
- ▶ Mining Equipment



**MasterSPEC**  
APPROVED

# Interpon® ACE Product Range

Comprises three top coat classes 500, 1000 and 2000, two primer qualities and a special high temperature resistant topcoat.



Product	Chemistry	Weathering	Baking Temperature	Quality
Interpon® ACE 500	Polyester TGIC	Standard	180 - 200°C 355 - 390°F	Standard Durability
Interpon® ACE 1000	Polyester TGIC	High	180 - 200°C 355 - 390°F	High Durability
Interpon® ACE 2000	Polyester TGIC	Super	180 - 200°C 355 - 390°F	Super Durable
Interpon® ACE 1000 LE	Polyester TGIC Low Baking	High	150 - 180°C 300 - 350°F	Low Baking
Interpon® ACE 2000 ULE	Polyester TGIC Ultra Low Baking	Super	120 - 140°C 250 - 285°F	Ultra Low Baking
Interpon® ACE 510	Polyester TGIC free	Standard	180 - 200°C 355 - 390°F	Standard Durability
Interpon® ACE 1010	Polyester TGIC free	High	180 - 200°C 355 - 390°F	High Durability
Interpon® ACE 2010	Polyester TGIC free	Super	180 - 200°C 355 - 390°F	Super Durable
Interpon® ACE 1010 LE	Polyester TGI free Low Baking	High	150 - 180°C 300 - 350°F	Low Baking
Interpon® ACE 600 HT	Silicone based HT Topcoat ≤ 510°C	Standard	230°C 450°F	High Temperature Resistant
Interpon® ACE Primer	Epoxy Hybrid or Epoxy	N.A.	180 - 200°C 355 - 390°F	High Corrosion Protection
Interpon® ACE Primer Plus	Various Available	N.A.	180 - 200°C 355 - 390°F	Superior Corrosion Protection





## Extensive Product and Color Range

The **Interpon® ACE** series features an extensive product and color collection comprised of a stock range as well as matches to global agricultural and construction equipment manufacturers, regional OEM's and their tier coaters.

Many products are held in stock and available for immediate delivery; other colors can be made to order. Our products can be formulated to meet all performance demands with excellent consistency and a great choice of colors.

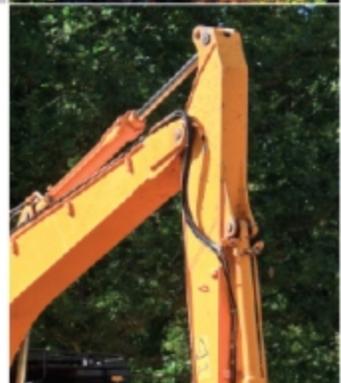
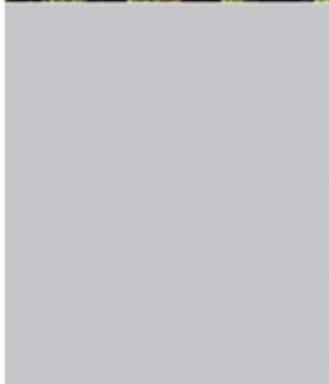
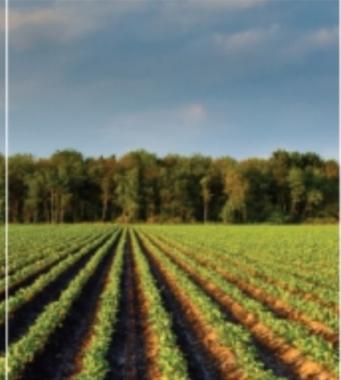
All **Interpon® ACE** products deliver proven performance, value and environmentally responsible solutions to satisfy our and your customers' needs. Combined with straightforward application, we make it easy for you to choose a product to suit your requirements.

## Approvals

With global approvals from all leading OEM's and the continued thirst for innovative solutions to simplify complex customer problems, AkzoNobel Powder Coatings and especially the **Interpon®** brand are quickly becoming the global ACE market standard.

## Appearance that Lasts

**Interpon® ACE** Powder Coatings define durability with products that combine superior corrosion resistance, enhanced weatherability and a high quality finish.



# Interpon® ACE Systems

Anticorrosion Properties.



## Corrosion Performance

Corrosion performance is dependent upon the substrate and surface preparation/pre-treatment: **Interpon® ACE** primers are available to meet customer corrosion protection requirements in combination with standard substrate pre-treatment (non-passivated Iron Phosphate) and any **Interpon® ACE** topcoat.



	ACE Topcoat Direct to Metal		ACE Topcoat on ACE Primer		ACE Topcoat on ACE Primer Plus	
	NSS	CCT	NSS	CCT	NSS	CCT
	240 hours	20 cycles	1000 hours	40 cycles	1200 hours	40 cycles
Rust (ASTM D610)	≥ 9	≥ 9	≥ 9	≥ 9	≥ 9	≥ 9
Blister (ASTM D714)	10	10	10	10	10	10
Scribe mm	≤ 3	≤ 5	≤ 3	≤ 5	≤ 3	≤ 3

Anticorrosion properties have been studied with standard recognized test methods like Natural Salt Spray (NSS according to ASTM B117) and Cyclical Corrosion (CCT according to SAE J2334)

## Mechanical Requirements

All **Interpon® ACE** products have been formulated to meet the highly demanding ACE market expectations in mechanical requirements such as adhesion, hardness, flexibility mandrel (bend) and impact resistance.

## Chemical Resistance

The **Interpon® ACE** product range is designed to resist attack from common chemical agents such as unleaded gasoline, diesel fuel, lubricant oil, hydraulic fluids, alkali and acid solutions.



# Interpon® ACE Performance Properties

Products in our Interpon® ACE range display excellent performance, even in challenging conditions. The Interpon® ACE MasterSpec guarantees lasting performance, exceptional mechanical properties and visual characteristics.

**MasterSPEC**  
APPROVED

Test	Test Method	ACE 1000	ACE 2000
<b>Lasting Performance</b>			
Salt Spray Resistance	ASTM B117	Mean Creep from Scribe [mm]: $\leq 3$ after: <ul style="list-style-type: none"> <li>• 240 hours if applied to DTM</li> <li>• 1000 hours if applied on Interpon® ACE Primer</li> <li>• 1200 hours if applied on Interpon® ACE Primer Plus</li> </ul>	Mean Creep from Scribe [mm]: $\leq 3$ after: <ul style="list-style-type: none"> <li>• 240 hours if applied to DTM</li> <li>• 1000 hours if applied on Interpon® ACE Primer</li> <li>• 1200 hours if applied on Interpon® ACE Primer Plus</li> </ul>
Cyclical Corrosion	SAE J2334	Mean Creep Total Scribe [mm]: $\leq 5$ after: <ul style="list-style-type: none"> <li>• 20 cycles if applied DTM</li> <li>• 40 cycles if applied on Interpon® Ace Primer</li> </ul> Mean Creep Total [mm]: $\leq 3$ after: <ul style="list-style-type: none"> <li>• 40 cycles if applied on Interpon® ACE Primer Plus</li> </ul>	Mean Creep Total Scribe [mm]: $\leq 5$ after: <ul style="list-style-type: none"> <li>• 20 cycles if applied DTM</li> <li>• 40 cycles if applied on Interpon® Ace Primer</li> </ul> Mean Creep Total [mm]: $\leq 3$ after: <ul style="list-style-type: none"> <li>• 40 cycles if applied on Interpon® ACE Primer Plus</li> </ul>
Humidity Resistance	ASTM D2247	No rust, no blisters after 1000 hours	No rust, no blisters after 1000 hours
Florida Exposure	ASTM D1014	After 12 months: Gloss Retention $\geq 50\%$ (60°) and: <ul style="list-style-type: none"> <li>• Bright shades <math>\Delta E &lt; 4</math></li> <li>• Colored shades <math>\Delta E &lt; 3</math></li> <li>• Other shades <math>\Delta E &lt; 3</math></li> </ul>	After 24 months: Gloss Retention $\geq 50\%$ (60°) and: <ul style="list-style-type: none"> <li>• Bright shades <math>\Delta E &lt; 4</math></li> <li>• Colored shades <math>\Delta E &lt; 3</math></li> <li>• Other shades <math>\Delta E &lt; 3</math></li> </ul>
<b>Mechanical Properties</b>			
Gouge Pencil Hardness	ASTM D3363	$\geq H$	$\geq H$
Adhesion	ASTM D3359	5B	5B
Impact Resistance	ASTM D2794	Direct [lb*in]: $\geq 40$ (50 kg.cm) Reverse [lb*in]: $\geq 20$ (25 kg.cm)	Direct [lb*in]: $\geq 40$ (50 kg.cm) Reverse [lb*in]: $\geq 20$ (25 kg.cm)
Conical Mandrel	ASTM D522	$\leq 3$ mm	$\leq 3$ mm
<b>Visual Characteristics</b>			
Specular Gloss	ASTM D523	High Gloss (60°): $\geq 80\%$ Satin (60°): $\geq 40$ to $\leq 70\%$ Low Gloss (60°): $< 40\%$	High Gloss (60°): $\geq 80\%$ Satin (60°): $\geq 40$ to $\leq 70\%$ Low Gloss (60°): $< 40\%$
Orange Peel	ACT Reference Panels	$\geq 6$ if applied DTM $\geq 5$ if applied on Interpon® ACE Primer	$\geq 6$ if applied DTM $\geq 5$ if applied on Interpon® ACE Primer
Resistance to Overbaking	ASTM D2454	No significant change in color and gloss	No significant change in color and gloss

The Interpon® ACE product range passes ASTM D870 for immersion resistance to Water, Diesel Fuel and Engine Oil and shows superior spot resistance to Unleaded Gasoline and Engine Coolant



## Environmental Benefits

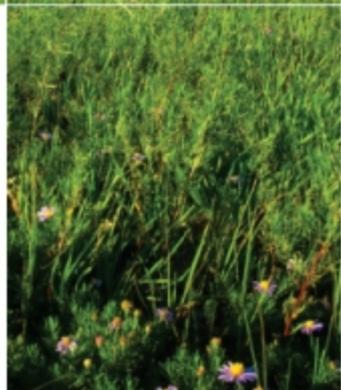
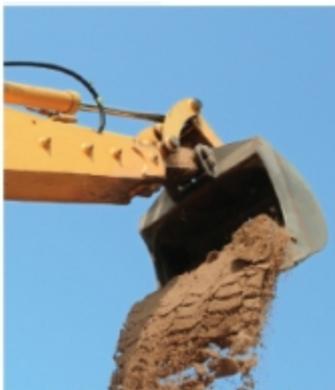
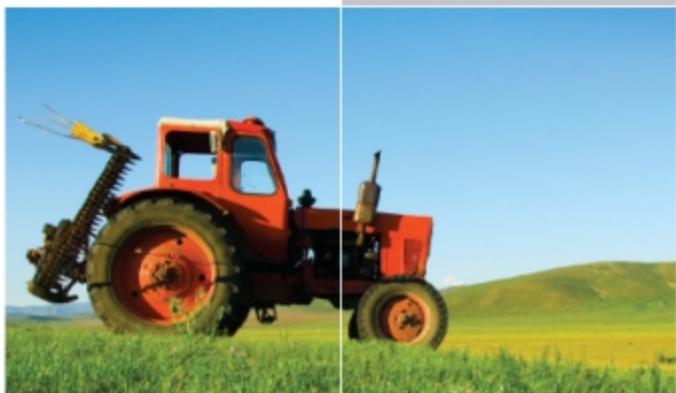
The **Interpon® ACE** range is always evolving. Our extensive R&D efforts for both products and processes are driven by sustainability, energy efficiency and customer specifications. For example, as energy costs soar across the world, AkzoNobel Powder Coatings enlists technology to assist our customers in keeping coating costs under control.

**Ultra Low-E™** can cure up to 60°C lower than standard products (180°C - 200°C), resulting in significant energy and productivity savings, while maintaining the smooth coating appearance that ACE OEM's demand.

## Heavy Metals

All **Interpon® ACE** products are formulated without the use of hazardous heavy metals including:

- ▶ LEAD
- ▶ CHROME VI
- ▶ ARSENIC
- ▶ CADMIUM
- ▶ MERCURY





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AkzoNobel Powder Coatings has broad global reach with skilled local execution. With the core range of **Interpon® ACE** products available worldwide, we deliver products with superior performance and consistent product quality to serve our customers, regardless of where they are located on the globe.

**Interpon®**  
powder coatings

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