

Product Data Sheet

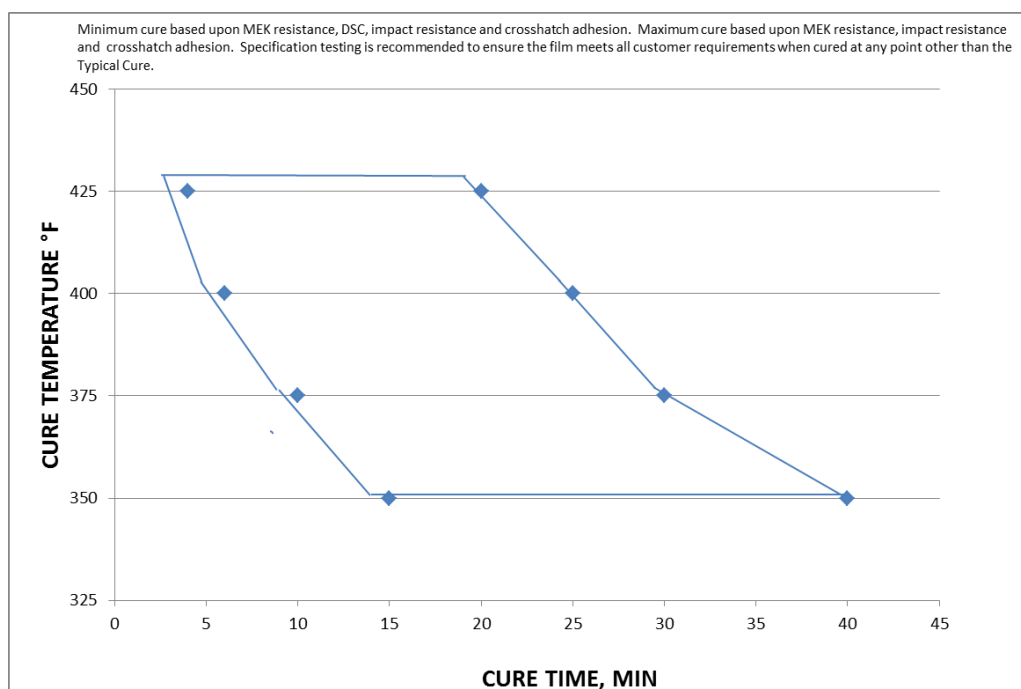
AkzoNobel Powder Coatings

Interpon ACE Primer Plus JE103QF (Formerly 30-21032) Yellow Primer

Product Description	Interpon ACE Primer Plus is a series of coatings designed for use as a basecoat primer over pretreated color 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	Chemical type	Polyester TGIC	
	Gloss level (Gardner 60°)	60 - 70	
	Recommended Film Thickness	1.5 mils min – 2.5 mils max	
	Specific gravity	1.70 +/-0.05 g/cm ³	
	Coverage @ 1.0 mil	113 sq.ft/lb/mil	
	Storage	Dry cool conditions (for example - <80°F, <25°C and <50% RH and not above 95°F, 35°C). Wet storage conditions to be avoided.	
	Shelf life	12 months, typical	
	Curing schedule (at object temperature)	15 minutes at 375°F (190°C)	
Mechanical Tests	Elongation – Conical Mandrel	ASTM D522	≤ 3 mm
	Adhesion	ASTM D3359	5B
	Hardness (Gauge)	ASTM D3363	≥ 2H
	Impact Resistance	ASTM D2794	≥ 140 Direct / ≥ 140 Reverse (in*lb)
Chemical and Durability Tests	Cyclical Corrosion	SAE J2334	Good resistance to 40 cycles test. When topcoated it could provide longer testing resistance.
	Chemical Resistance	ASTM D870	Good immersion resistance to water, diesel fuel, engine oil, gasoline & engine coolant.
Test Conditions	The results shown are based on mechanical and chemical tests (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) or Zinc Phosphate (B952)	
	Film thickness	1.5 – 2.0 mils	
	Cure schedule	15 minutes at 375°F (180°C) (object temperature)	

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 Primer Plus 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 Primer Plus powder is an economical and environmental friendly coating. Comparing to common indoor use powder coating, it provides good adhesion and anti-corrosion performance as a primer when topcoat is applied. However, performance is still influenced by substrate and pretreatment type and film thickness uniformity. The topcoat should be ideally applied with 2 hours so that dust and contamination cannot deposit on the primer coating. For further details on the use of primer powder coating please contact AkzoNobel.

Approximate Cure Window for JE103QF (30-21032) Yellow



Safety Precautions	Please consult the Safety Datasheet (SDS).
Disclaimer	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 fulfil 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. 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.

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