

# INFRALIT POWDER COATINGS'

## storage and handling instructions

### Storing and transportation of powders

- Powders should be stored in cool and dry environment, max 25 °C. Take special care during high temperature seasons. Avoid storing close to heat sources i.e. heaters in trucks and storages. Don't store in direct sunlight.
- Take special care with low cure powders (highly reactive products) to be stored in a cool environment.
- Excess heat can cause sintering in the powder, leading to spraying problems and surface defects on the final coating.
- Don't load or store big product bags on top of each other.

### Handling of powder coatings

- The recommended (air) humidity during storage and handling of powder coatings is 40-60%.
- When storing the powder in low temperatures, before opening the package make sure the powder temperature is close to paint shop air temperature. This is to prevent powder absorbing moisture and therefore causing quality issues.
- The maximum recommended amount of recycled non-metallic powder coating to be mixed with fresh powder is 50%. If the spraying result seems inadequate, more fresh powder should be added. The optimum amount depends on used equipment and powder.
- Be careful when handling powders. The powder dust shouldn't contaminate production and the powder itself shouldn't be contaminated by foreign materials or other powders. Close the container/bag between uses to ensure this.
- Use personal protection, notice the labelling and follow the safe use instructions mentioned in the SDS.
- Powder that have been stored for a long time will be more packed compared to fresh powder because air between the powder particles escapes. Either use a fluidization vessel to incorporate air into the powder or mix the bag manually to ensure nice fluidization.
- Observe and follow the best before date on the label. The quality of the powder cannot be guaranteed if it's used after the best before date.

### Cleaning of spraying equipment

- Cleaning the spraying booth is recommend at least once during a work shift, depending on the temperature and humidity to avoid the moistured powder in the booth walls dropping on its own and causing lumps in the recycled and fresh materials mixing.
- Teknos product BE40400020 INFRALIT EP/PE 8081-98 CLEANING POWDER can be used to cleaning spraying guns and recycling equipment.