

INFRALIT PE 8339

Polyester Powder

PAINT TYPE	INFRALIT PE 8339 polyester powder is based on polyester resin and due to its special hardener it is free of TGIC. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT PE 8339 is suitable for objects which require a weather-resistant coating, especially for coating of aluminium objects.
SPECIAL PROPERTIES	<p>INFRALIT PE 8339 forms a mechanically and chemically resistant paint film which has good corrosion resistance and good colour stability and gloss retention also in outdoor conditions.</p> <p>INFRALIT PE 8339-00 is the general variant suitable for both corona and tribo spraying. Variant PE 8339-02 is suitable for corona only.</p> <p>PE 8339-09 is a variant containing pearlescent pigment and suitable for corona only.</p> <p>PE 8339-31 is a variant designed especially for gas ovens and has enhanced protection against yellowing.</p>
APPROVALS	<p>Qualicoat approval number P-0513, Cat. 3, Cl. 1.</p> <p>NFPA 130:2020 Standard for Fixed Guideway Transit and Passenger Rail Systems, Chapter 8 - Vehicles</p> <p>- ASTM E 162:2016 Standard Test Method for Surface Flammability of Materials Using a Radiant Heat Energy Source</p> <p>- ASTM E 662:2017 Standard Test Method for Specific Optical Density of Smoke Generated by Solid Materials</p>
TECHNICAL DATA	
Spraying	<p>PE 8339-09 is a metallic or pearlescent colour designed for corona charging spray.</p> <p>PE 8339-13 is a metallic or pearlescent colour designed for tribo charging spray.</p>
Colours	By agreement.
Gloss 60°	81 - 99. The measured gloss of metal and pearlescent shades may differ from the mentioned value.
Spreading rate	6 - 10 m ² /kg depending on the film thickness
Film thickness	The recommended film thickness is 60 - 100 µm.
Curing time	<p>10 - 25 min/180°C (metal temperature).</p> <p>7 - 12 min/200°C (metal temperature).</p>
Storage	<p>The storage life is minimum 18 months in dry and cool conditions when the temperature during storage and transportation is max. 25°C.</p> <p>The recommended expiry date of the powder coating that has been stored according to the instructions is shown on the package label.</p>
SAFETY PRECAUTIONS	<p>The powder itself is non-flammable, but with air it can form an explosive mixture that in presence of adequate ignition energy ignites. The lower explosive limit for polyester powder is about 80 g/m³ (Bundesanstalt für Materialprüfung). Ventilation of the spray booth should be adjusted so that the concentration of powder in the air is less than 50% of the lower explosive limit value. On calculation of the powder concentration in the spray booth, the powder deposited on the workpiece is not taken into account.</p> <p>In order to avoid the discharge of powder from the booth into adjacent working spaces, the speed of air flow in the apertures of the booth must not fall below 0.5 m/s.</p> <p>Spray painters should wear dust masks and protective gloves. Any spatter of powder on the skin should be washed off with water and soap.</p>

DIRECTION FOR USE
Surface preparation

COLD-ROLLED STEEL: Degreasing and zinc phosphating.

ALUMINIUM: Degreasing and chromating or alternatively a suitable conversion treatment.

FILM PROPERTIES

Substrate chromated aluminium (100 x 300 x 0,6 mm). Stoving 10 min/180°C, film thickness 60 - 70 µm. Testing 1 h after stoving:

Typical values

Flexibility (Erichsen, ISO 1520)	over 6 mm
Impact resistance (ASTM D 2794; 15.9 mm diameter)	
- direct	more than 40 lbin (45 kgcm)
- reverse	more than 40 lbin (45 kgcm)
Flexibility (ISO 1519)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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