

# INFRALIT PE 8431-10

## Polyester powder

INFRALIT PE 8431-10 is a TGIC-free powder coating based on solid polyester resin. At elevated temperature the powder will melt, cure and form the final paint film.



Suitable for product coating within the metal industry for objects that require a weather resistant coating that will not yellow on exposure to heat or ultraviolet light. Examples of use are e.g. constructions that are permanently outdoors.

INFRALIT PE 8431-10 forms a mechanically and chemically resistant paint film that has good anticorrosive properties and that will retain its gloss also in outdoor conditions. When used in accordance with coating system K122 INFRALIT PE 8431-10 meets the requirements for camouflage technical properties of the Finnish Defence Force that are included in specification of requirements M 064, version 2.0.

## TECHNICAL DATA

<b>Certificates, approvals and classification</b>	Finnish Defence Force
<b>Fields of application</b>	Steel constructions, Transportation equipment, Machinery
<b>Recommended substrate</b>	Aluminium, Steel, Zinc
<b>Binder</b>	Polyester
<b>Solids</b>	100%
<b>Practical spreading rate</b>	6 - 10 m <sup>2</sup> /kg depending on the film thickness.
<b>Film thickness</b>	The recommended film thickness is 80 - 120 µm.  The optimal film thickness must be defined case-specifically by test applications. In some cases the film thickness might exceed the previously mentioned maximum value.
<b>Colours</b>	AN11, dark green AN22, light green AN33, brown AN44, black
<b>Gloss (60°)</b>	Full-matt
<b>Density</b>	Approx. 1.6 kg/dm <sup>3</sup> depending on colour.

**Storage**

The storage life is minimum 18 months in dry and cool conditions when the temperature during storage and transportation is max. +25°C.

Take special care during high temperature seasons. Avoid storing close to heat sources and heaters in trucks and storages. Don't store in direct sunlight. The recommended expiry date of the powder coating that has been stored according to the instructions is shown on the package label.

**Packaging**

15 kg or 20 kg according to the density of the powder.

**DIRECTION FOR USE****Surface preparation**

STEEL SURFACES without chemical preparation:  
See COATING SYSTEM K122.

STEEL SURFACES with chemical preparation:  
See COATING SYSTEM K122.

ALUMINIUM SURFACES with chemical preparation:  
See COATING SYSTEM K122

**Application method**

Tribo charging spray, Corona charging spray

**Curing time**

15 min/210°C (substrate temperature)

Curing time indicates the time needed for the curing of the coating.

Curing parameters and oven type may effect the colour and gloss of the coating.

The temperature of the powder coating has to reach the temperature inside the paint shop before the package is opened. The application properties may be deteriorated, if the temperature of the powder is lower than this.

**HEALTH AND SAFETY****Safety and precaution measures**

See safety data sheet.

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 explosion limit of typical powder coatings is between 20 g/m<sup>3</sup> and 80 g/m<sup>3</sup> (CEPE, Safe Powder Coating Guideline 8th Edition, 2020). 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. 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. Spray painters should wear dust masks and protective gloves. Any spatter of powder on the skin should be washed off with water and soap.

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