

# INFRALIT PE 8640-00

## Low temperature curing polyester powder



INFRALIT PE 8640-00 is a TGIC-free powder coating based on solid high quality polyester resin. At elevated temperature the powder will melt, cure and form the final paint film.

INFRALIT PE 8640-00 is suitable for steel and aluminium constructions in objects where good weather resistance is required.

INFRALIT PE 8640-00 forms a mechanically and chemically resistant paint film which has good corrosion resistance and good colour stability and gloss retention also in outdoor conditions.

**APPROVALS:**

- NFPA 130:2020 Standard for Fixed Guideway Transit and Passenger Rail Systems, Chapter 8 - Vehicles
- ASTM E 162:2016 Standard Test Method for Surface Flammability of Materials Using a Radiant Heat Energy Source
- ASTM E 662:2017 Standard Test Method for Specific Optical Density of Smoke Generated by Solid Materials

### TECHNICAL DATA

Certificates, approvals and classification	ASTM E 662:2017, ASTM E 162:2016
Fields of application	Machinery, Steel constructions
Recommended substrate	Aluminium, Steel, Zinc
Binder	Polyester
Solids	100 %
Practical spreading rate	6 - 10 m <sup>2</sup> /kg depending on the film thickness.
Film thickness	The recommended film thickness is 60 - 100 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.
Colours	By agreement.
Gloss (60°)	65-99
Density	Approx. 1.25 - 1.80 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:** Remove grease and dirt. After that blast-cleaning at least to preparation grade Sa 2½ (ISO 8501-1) and/or a suitable chemical pretreatment.

**ALUMINIUM SURFACES:** Remove grease and dirt. After that chromating or alternatively a suitable chemical pretreatment.

**HOT-DIP-GALVANIZED AND ZINC-ELECTROPLATED SURFACES:** Remove grease, dirt and white rust by e.g. alkali wash. Depending on exposure conditions, chromating or alternatively a suitable chemical pretreatment is also required.

**Application method**

Tribo charging spray, Corona charging spray

**Curing time**

10 min/160°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.

FILM PROPERTIES

Typical values	Substrate 0.6 mm thick chromated aluminium, curing 10 min/+ 160°C, film thickness 70 µm. Testing 1 h after curing:
Cross-cut test ISO 2409	GT0
Cupping ISO 1520, mm	6.0
Impact resistance, ISO 6272-2, direct, kgcm	40.0
Impact resistance, ISO 6272-2, reverse, kgcm	40.0
Bend test (cylindrical mandrel) ISO 1519, mm	5.0

Teknos Group Oy Takkatie 3, P.O.Box 107 FI-00371 Helsinki, Finland Tel. +358 9 506 091

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage [www.teknos.com](http://www.teknos.com). All trademarks displayed on this document are the exclusive property of Teknos Group or its affiliated companies.