

# INFRALIT SI 8009-05

## Zinc silicone powder



INFRALIT SI 8009-05 is a powder coating based on solid silicone resin. The silicone resin gives the powder a very good resistance to heat. At elevated temperature the powder will melt, cure and form the final paint film. INFRALIT SI 8009-05 contains also metallic zinc, which gives the powder good anticorrosive properties.

INFRALIT SI 8009-05 is mainly suitable for use on steel surfaces blast-cleaned to preparation grade Sa 2½, when the constructions will be exposed to severely corrosive environments and high temperatures. In order to achieve good protection against corrosion INFRALIT SI 8009-05 needs to be overcoated with INFRALIT SI 8009-02 powder coating or comparable heat-resisting paint. The powder also has good weather resistance properties and can therefore be used both indoors and outdoors.

INFRALIT SI 8009-05 forms a heat resistant paint film that has good anticorrosive properties. INFRALIT SI 8009-05 can be used at temperatures up to 600°C. Due to the special property of this product the mechanical properties are not on a par with those of conventional powders. With this product we recommend using a fluidization hopper.

Especially when INFRALIT SI 8009-05 zinc silicone powder is used as a primer in painting system P242b, the paint film needs to be completely cured. If the powder is not cured completely adhesion between primer and top coat may be diminished.

## TECHNICAL DATA

<b>Fields of application</b>	Fireplace, Machinery, Sauna
<b>Recommended substrate</b>	Steel, Zinc
<b>Binder</b>	Silicone
<b>Solids</b>	100 %
<b>Practical spreading rate</b>	6 - 9 m <sup>2</sup> /kg depending on the film thickness.
<b>Film thickness</b>	50 - 80 µm above the peaks of the surface profile.  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>	Dark grey.
<b>Gloss (60°)</b>	Matt
<b>Density</b>	Approx. 2.1 kg/dm <sup>3</sup>

<b>Storage</b>	<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>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.</p>
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<b>Packaging</b>	20 kg.
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**DIRECTION FOR USE**

<b>Surface preparation</b>	<p>STEEL SURFACES: Remove grease and dirt. Blast-clean at least to grade Sa 2½ (ISO 8501-1). The surface profile at least medium (G) ISO 8503-2. Remove the dust.</p> <p>INFRALIT SI 8009-05 can be used with other paints or alone if the grey colour can be accepted. When used alone, the recommended minimum film thickness is 70 µm.</p>
<b>Application method</b>	Corona charging spray
<b>Curing time</b>	<p>30 min/200°C (substrate temperature)</p> <p>Curing time indicates the time needed for the curing of the coating.</p> <p>Curing parameters and oven type may effect the colour and gloss of the coating.</p> <p>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.</p>

**HEALTH AND SAFETY**

<b>Safety and precaution measures</b>	<p>See safety data sheet.</p> <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 explosion limit of typical powder coatings is between 20 g/m³ and 80 g/m³ (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.</p>
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FILM PROPERTIES

Typical values	Substrate steel plates Sa 2 ½, curing 30 min/+200 °C, film thickness 60 - 70 µm. Testing 1 h after curing:
Cross-cut test ISO 2409	GT0
Cross-cut test ISO 2409 100h/500 °C	GT0
Cross-cut test ISO 2409 100h/600 °C	GT1

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