

INFRALIT EP 8054-02 AK10690700 and AK10690020 Epoxy Powder

PAINT TYPE	INFRALIT EP 8054-02 is a fine-grained powder coating based on epoxy resin. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT EP 8054-02 Epoxy Powder is used as primer when coating preheated steel pipes with polyolefines.
SPECIAL PROPERTIES	The resultant paint film has excellent mechanical properties, i.e. good abrasion and impact resistance and elasticity. It is not scratched easily and withstands action by acids, alkalis, greases and solvents. Its anticorrosive properties are also good.
TECHNICAL DATA	
Colours	Pipe grey
Gloss grades	Semigloss
Average particle size, D (v, 0.5) (laser diffraction method)	abt. 55 - 65 µm (ISO 8130-13)
Gel time	205°C / 22 - 33 s (CSA Z245.20-10) The gel time will fluctuate greatly depending on the method used, and it should be always checked by the user's own method.
Moisture content, mass loss	<0.6%
Specific gravity	abt. 1.35-1.45 kg/dm ³
Spreading rate	3 - 11 m ² /kg depending on the film thickness
Film thickness	Min. 60 µm above the peaks of the surface profile
Curing time	5 min/180°C (metal temperature)
Glass transition temperature of the cured film	95 - 105°C, DSC - CSA Z245.20-10
Glass transition temperature	Tg1 = 58 - 72 °C, DSC - CSA Z245.20-10 Tg2 = 95 - 105°C , DSC - CSA Z245.20-10 delta H = 23 - 53 J/g, DSC - CSA Z245.20-10
Glass transition temperature tolerance	-2°C to +3°C, DSC - CSA Z245.20-10
Packages	20 kg box or 700 kg big bag
Storage	In dry and cool conditions 6 - 12 months depending on the temperature (5 - 25°C).

SAFETY PRECAUTIONS

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 epoxy powder is about 60 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.

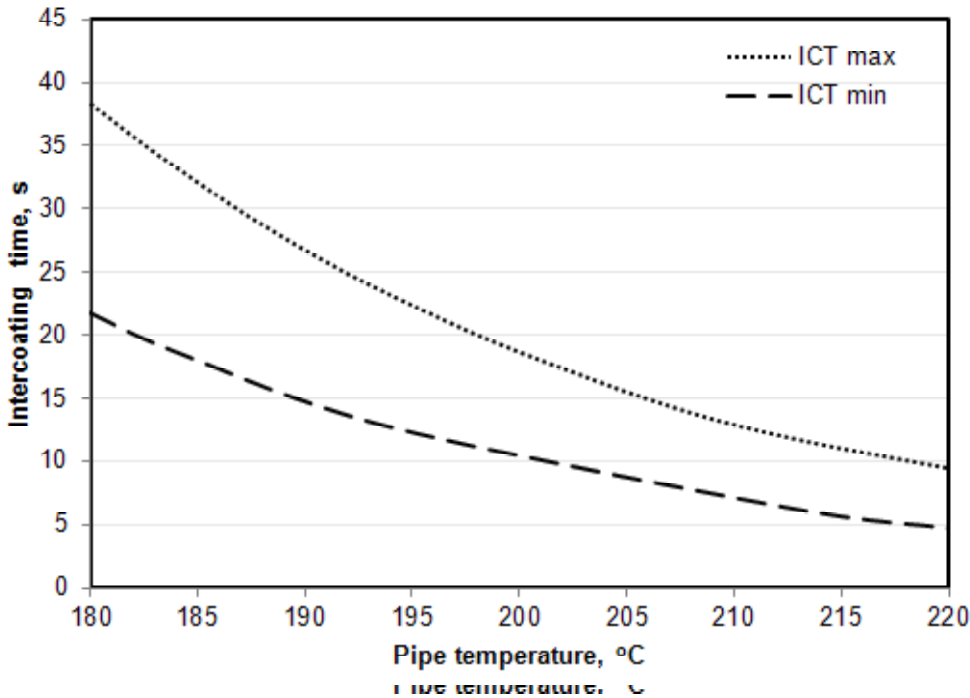
In order to avoid the discharge of powder from the booth into adjacent working spaces, the speed of air flow in the apertures of the booth must not fall below 0.5 m/s.

Spray painters should wear dust masks and protective gloves. Any spatter of powder on the skin should be washed off with water and soap.

DIRECTION FOR USE
Surface preparation and application

Remove grease and dirt. Blast-clean at least to grade Sa 2½ (ISO 8501-1). Preheat the blast-cleaned steel before application. Minimal temperature during preheating is +180°C.

APPLICATION WINDOW



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