DATA SHEET 1091
4 03.10.2017

INFRALIT EP/PE 8087-18

Epoxy/Polyester Powder

PAINT TYPE

INFRALIT EP/PE 8087-18 is a powder coatings based on a mixture of solid epoxy and polyester binders. At elevated temperatures the powder will melt, cure and form the final paint film.

USAGE

INFRALIT EP/PE 8087-18 is suitable for coating metal industry products, such as lighting fixtures, apparatuses, wire gratings and refrigerating fixtures.

SPECIAL PROPERTIES

INFRALIT EP/PE 8087-18 Epoxy/Polyester Powder forms a film with mechanical and chemical resistance and good anticorrosive properties which are almost equal to those of epoxies.
On outdoor exposure INFRALIT EP/PE 8087-18 Epoxy/Polyester Powder has a tendency towards matting down (chalking) similar to that of pure epoxies. On the other hand, its tendency to yellow on overbaking and exposure to heat and ultraviolet light is minor as compared with epoxy powders.

Among special properties of INFRALIT EP/PE 8087-18 is improved levelling. It is particularly suitable for coating thinner paint films than normal.

APPROVALS

Group M1 in Emission Classification of building materials.
IMO FTPC Part 5 - Test for Surface Flammability and IMO FTPC Part 2 - Smoke and toxicity test.

TECHNICAL DATA

Spraying	Normally by corona charging spray. The suitability for application by tribo charging spray must be discussed with the paint manufacturer.
Colours	By agreement.
Gloss grades	Matt
Solids	100%
Specific gravity	Abt. 1,4 - 1,7 kg/dm³ depending on colour
Spreading rate	10 - 28 m²/kg depending on the film thickness
Film thickness	Directive film thickness 25 - 60 µm.
Curing time	15 min/180°C (metal temperature) 10 min/200°C (metal temperature)
Packages	20 kg
Storage	In dry and cool conditions.

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 is about 70 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.

PTO

DIRECTION FOR USE

Surface preparation

COLD-ROLLED SURFACES: Degrease by trichloroethylene vapour bath or alkali wash. Zinc phosphating is also required if the workpiece is destined for outdoor exposure or will be subjected to exceptional strain indoors.

ALUMINIUM SURFACES: Degrease by e.g. alkali wash. Surfaces to be exposed to severe atmospheric conditions should also be chromated.

HOT-DIP-GALVANIZED AND ZINC-ELECTROPLATED SURFACES: Remove grease and white rust by e.g. alkali wash. Depending on exposure conditions, zinc phosphating or chromating is also required.

FILM PROPERTIES

Substrate cold-rolled steel, curing time 15 min/180°C:

Physical properties

Flexibility (Erichsen, ISO 1520)	7 mm
Impact resistance (Erichsen, SFS EN ISO 6272)	
- direct	40 kgcm
- reverse	40 kgcm
Pendulum hardness (König, SFS 3642)	180 s
Flexibility (SFS ISO 6860)	passes
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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