**DATA SHEET 1859**
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# INFRALIT EP/PE 8087-30

## Epoxy/Polyester Primer

**PAINT TYPE**

INFRALIT EP/PE 8087-30 is a powder coating 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 8087-30 Epoxy/Polyester Powder is suitable as one layer paint for coating metal industry products, such as lighting fixtures, apparatuses, wire gratings and refrigerating fixtures.

**SPECIAL PROPERTIES**

INFRALIT EP/PE 8087-30 Epoxy/Polyester Powder forms a film with mechanical and chemical resistance and good anticorrosive properties. On outdoor exposure Epoxy/Polyester Powders have 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.

NFRALIT EP/PE 8087-30 is also suitable for use as a primer under another INFRALIT powder coating. A paint system of two coats provides a thicker protective layer and facilitates the coating of sharp edges. System is also suitable for outdoor objects which are exposed to UV light when a suitable weather resistant INFRALIT powder coating is chosen as a top coat.

**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**

Powder coating is designed for application by corona charging spray. Functionality by tribo charging spray must be ensured on every coating line by test application.

**Colours**

RAL-7001
Other colours by agreement.

**Gloss grades**

Matt

**Solids**

100%

**Specific gravity**

Abt. 1,60 - 1,70 kg/dm³

**Spreading rate**

4 - 15 m²/kg depending on the film thickness

**Film thickness**

When painting with two coat system the optimal film thicknesses should be defined case-specifically by test paintings. A suitable basis is abt. 70 µm for each paint coat.

**Curing time**

10 min/180°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 or a suitable conversion treatment 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. Chromating or a suitable conversion treatment is also required if the workpiece is destined for outdoor exposure or will be subjected to exceptional strain.

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 or a suitable conversion treatment is also required.

HOT-ROLLED SURFACES: Blast-clean to preparation grade Sa 2½ (ISO 8501-1). The profile of the blast-cleaned surface has to be at least medium rough. See standard ISO 8503-2.

## FILM PROPERTIES

Substrate 0.8 mm thick cold-rolled steel, film thickness 65 µm, curing time 10 min/180°C:

**Typical values**

| | |
|---|---|
| Flexibility (Erichsen, ISO 1520) | over 7 mm |
| Impact resistance (Erichsen, SFS EN ISO 6272) | |
| - direct | above 40 kgcm |
| - reverse | above 40 kgcm |
| Flexibility (ISO 1519) | less than 5 mm |
| Adhesion (cross-cut test, EN ISO 2409) | GT 0 |

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