

INFRALIT EP/PE 8121, 8122, 8125, 8126

Epoxy/Polyester Powder

PAINT TYPE	INFRALIT EP/PE 8121, 8122, 8125, 8126 powder coatings based on epoxy and polyester resin, which at elevated temperatures melts, cures and forms the final paint film.
USAGE	INFRALIT EP/PE 8121, 8122, 8125, 8126 Epoxy/Polyester Powders are suitable for coating metal industry products, such as lighting fixtures, apparatuses, wire gratings and refrigerating fixtures.
SPECIAL PROPERTIES	The mechanical and chemical resistance and the anticorrosive properties of INFRALIT EP/PE 8121, 8122, 8125, 8126 Epoxy/Polyester Powders are almost equal to those of epoxies. On outdoor exposure INFRALIT EP/PE 8121, 8122, 8125, 8126 Epoxy/Polyester Powders, like epoxy/polyester powders in general, has a tendency towards matting down (chalking) similar to that of pure epoxies. On the other hand, its tendency to yellow on over curing and exposure to ultraviolet light is minor as compared with epoxy powders.
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TECHNICAL DATA	
Spraying	Variant EP/PE...-00 is suitable for both tribo charging and for corona charging sprays. Variants...-02 and...-09 only for corona charging sprays.
Colours	By agreement.
Gloss grades	EP/PE 8121 - effect resembling sandpaper EP/PE 8122 - wavy structure EP/PE 8125 - gloss EP/PE 8126 - semigloss
Solids	100%
Specific gravity	Abt. 1,25 - 1,70 kg/dm ³ depending on colour
Spreading rate	4 - 15 m ² /kg depending on the film thickness
Film thickness	One application gives a film thickness of 40 - 150 µm. When painting with EP/PE 8122 powders the suitable film thickness is to be found by application tests individually for each powder. The film thickness is typically around 100 - 150 µm.
Curing time	15 min/160°C (metal temperature) or 10 min/180°C (metal temperature). or 8 min/190°C (metal temperature) When curing is done above 190°C, slight reduction of gloss and in light colours also yellowing may occur.
Packages	15 kg or 20 kg according to the specific gravity of the powder.
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/m ³ (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.
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DIRECTION FOR USE**Surface preparation**

COLD-ROLLED SURFACES: Degrease by trichloroethylene vapour bath or alkali wash. Zinc phosphating is also required if the workpiece 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/160°C:

Physical properties

Flexibility (Erichsen, ISO 1520)	over 7 mm
Impact resistance (ASTM D 2794; 15.9 mm diameter)	
- direct	more than 40 lbin (45 kgcm)
- reverse	more than 40 lbin (45 kgcm)
Pendulum hardness (König, SFS 3642)	180 s
Flexibility (ISO 1519)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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