

INFRALIT EP/PE 8130

Epoxy/Polyester Powder

PAINT TYPE	INFRALIT EP/PE 8130 Epoxy/Polyester Powder is based on epoxy and polyester resin, which at elevated temperatures will melt, cure and form the final paint film.
USAGE	INFRALIT EP/PE 8130 is suitable for use in metal industry e.g. for painting light fittings, apparatuses, latticework, refrigeration equipment etc.
SPECIAL PROPERTIES	The mechanical and chemical resistance and the anti-corrosive properties of INFRALIT EP/PE 8130 are almost equal to those of epoxies. On outdoor exposure like epoxy/polyester powders in general, has tendency towards matting (chalking) similar to that of pure epoxies. On the other hand the tendency of INFRALIT EP/PE 8130 to yellow on overbaking and exposure to ultraviolet light is slighter than with epoxy powders.
APPROVALS	IMO FTPC Part 5 - Test for Surface Flammability and IMO FTPC Part 2 - Smoke and toxicity test
TECHNICAL DATA	
Spraying	Suitable for both tribo charging and corona charging sprays.
Colours	By agreement.
Gloss grades	Available in matt and 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.
Curing time	Variants 8130-00, -02, -06 and -07: 10 min/180°C (metal temperature) Variants 8130-04 and -10: 10 min/200°C (metal temperature) Variant 8130-01: 10 min/160°C (metal temperature)
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/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

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.

HOT-ROLLED SURFACES: Blast-clean to preparation grade Sa 2½ (ISO 8501-1).

The profile of the blast-cleaned surface must be at least medium (G). See standard ISO 8503-2.

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)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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