

INFRALIT PE 8311-21**Polyester Powder**

PAINT TYPE	INFRALIT PE 8311-21 is a polyester powder coating based on polyester resin. Due to its special hardener the powder is free of TGIC. At elevated temperatures the powder melts, cures and forms a uniform paint film.
USAGE	INFRALIT PE PE 8311-21 is suitable for objects which require a weather-resistant coating, especially for coating of aluminium objects.
SPECIAL PROPERTIES	INFRALIT PE PE 8311-21 forms a mechanically and chemically resistant paint film that has good anticorrosive properties. The surface has good gloss retention even in outdoor conditions. INFRALIT PE 8311-21 is suitable only for corona charging spray. Variant's structure (texture) is lower and the gloss is higher than in most of the PE 8311 series' variants.

TECHNICAL DATA

Colours	By agreement.
Gloss 60°	10 - 25
Spreading rate	6 - 10 m ² /kg depending on the film thickness
Film thickness	The recommended film thickness is 60 - 100 µm.
Curing time	Recommendation: 15 min/190°C (metal temperature) Minimum: 15 min/180°C (metal temperature) Maximum: 7 min/220°C (metal temperature)
Storage	Minimum 12 months 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 for polyester powder is about 80 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 STEEL: Degreasing and zinc phosphating.

ALUMINIUM: Degreasing and chromating.

FILM PROPERTIES

Substrate chromated aluminium (100 x 300 x 0.6 mm). Stoving 15 min/190°C:

Physical properties

Flexibility (Erichsen, ISO 1520)

over 6 mm

Impact resistance (ISO 6272)

- direct

above 45 kgcm

- reverse

less than 5 mm

Flexibility (ISO 1519)

GT 0

Adhesion (cross-cut test, EN ISO 2409)

2H - 3H

Pencil hardness (ISO 15184)

The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages www.teknos.com.



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