

INFRALIT PE 8316-05

Zinc Polyester Powder

PAINT TYPE	INFRALIT PE 8316-05 is a powder coating based on polyester resin containing metallic zinc, which has very good anticorrosive properties. Due to its new special hardener the powder is free of TGIC. At elevated temperatures the powder melts, cures and forms a uniform paint film.
USAGE	INFRALIT PE 8316-05 is mainly suitable for use on steel surfaces blast-cleaned to preparation grade Sa 2½, when the constructions will be exposed to severely corrosive environments. The product is designed mainly for use as a primer.
SPECIAL PROPERTIES	<p>INFRALIT PE 8316-05 forms a mechanically resistant paint film that has good anticorrosive properties. The surface can be overcoated with INFRALIT powder coating or some other suitable paint.</p> <p>Teknos sales department should be contacted if the intention is only to melt the primer before applying the top coat.</p> <p>Overbaking of INFRALIT PE 8316-05 powder coating must be avoided when overcoating. If the stoving temperature of the primer is higher than 205°C, the adhesion between the coats may be diminished. We recommend that intercoat adhesion is checked when direct fired gas oven is used in two layer painting.</p>

TECHNICAL DATA

Spraying	The product is suitable only for corona charging spray.
Colours	Dark grey
Gloss grades	Semigloss
Solids	100%
Specific gravity	2,7 kg/dm ³
Spreading rate	abt. 6 m ² /kg depending on the film thickness
Film thickness	Min. 60 µm above the peaks of the surface profile Max. 140 µm above the peaks of the surface profile
Curing time	10 min/200°C (metal temperature) 15 min/190°C (metal temperature).
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. Ventilation of the spray booth should be adjusted so that the highest concentration of powder in the air is 10 g/m³. 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.

Welding is to be avoided due to the zinc content of the powder.

DIRECTION FOR USE**Surface preparation**

STEEL SURFACES: Remove grease and dirt. Thereafter the surfaces are blast-cleaned at least to preparation grade Sa 2½ (ISO 8501-1). The surface profile has to be at least medium coarse (G) SFS - ISO 8503-2. Remove the dust.

When INFRALIT PE 8316-05 is used as a primer under other INFRALIT polyester powders, it is recommended that the surface is first sanded with a fine sandpaper to get the best possible adhesion between layers. INFRALIT PE 8316-05 can also be used alone if the grey colour can be accepted. The recommended minimum film thickness is then 80 µm.

FILM PROPERTIES

Substrate cold-rolled steel, curing time 15 min/190°C:

Typical values

Flexibility (Erichsen, ISO 1520)	7 mm
Impact resistance (Erichsen, SFS EN ISO 6272)	
- direct	40 kgcm
- reverse	40 kgcm
Flexibility (SFS ISO 6860)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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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