



INFRALIT PE 8350-77

INFRALIT DECO polyester powder

PAINT TYPE	INFRALIT PE 8350-77 is a TGIC-free polyester powder based on polyester resin. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT PE 8350-77 is suitable for objects which require a weather-resistant coating, especially for coating of aluminium objects.
SPECIAL PROPERTIES	<p>INFRALIT PE 8350-77 forms a mechanically and chemically resistant paint film which has good corrosion resistance and good colour stability and gloss retention also in outdoor conditions.</p> <p>All basic RAL-K1 Classic solid colours available in three different bonded metallic effects. Detailed information in the INFRALIT DECO brochure.</p>
APPROVALS	<p>GSB material licence. Registration number 145b. Qualicoat material licence number P-0412, Cat. 3, Cl. 1. Marine Equipment Approval (Module D) (96/98/EC and 2013/52/EU) number VTT-C-11275-15-14. Group M1 in Emission Classification of building materials. EN 45545-2:2013+A1:2015 Fire protection on railway vehicles. Requirement sets R1, R7, R10 & R17 - Hazard levels HL1, HL2 & HL3.</p>
TECHNICAL DATA	
Colours	<p>Standard shades according to RAL-CLASSIC Colour Card available in three different bonded metallic effects: Coarse aluminium (C) Fine aluminium (F) Pearlescent (P)</p> <p>Detailed information in the INFRALIT DECO brochure.</p> <p>DECO colour samples have been painted with electrostatic hand spraying. The appearance of the metal effect may vary according to the spraying technique.</p>
Gloss 60°	65 - 85. The gloss of single shades may differ from the mentioned value.
Spreading rate	6 - 10 m ² /kg depending on the film thickness
Film thickness	Recommended film thickness is 80 - 100 µm.
Curing time	<p>Curing time indicates the time needed for the curing of the paint. Curing parameters and oven type may effect the colour and gloss of the paint.</p> <p>10 - 25 min/180°C (metal temperature). 9 - 15 min/190°C (metal temperature). 7 - 12 min/200°C (metal temperature).</p> <p>The temperature of the powder coating has to reach the temperature inside the paint shop before the package is opened. The application properties may be deteriorated, if the temperature of the powder is lower than this.</p>

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.

DIRECTION FOR USE**Surface preparation**

COLD-ROLLED STEEL: Degreasing and zinc phosphating or alternatively a suitable conversion treatment.

ALUMINIUM: Degreasing and chromating or alternatively a suitable conversion treatment.

FILM PROPERTIES

Substrate chromated aluminium (100 x 300 x 0.6 mm). Stoving 15 min/190°C, film thickness 60 - 70 µm. Testing 1 h after stoving:

Physical properties

Flexibility (Erichsen, ISO 1520)	over 6 mm
Impact resistance (ASTM D 2794; 15.9 mm diameter)	
- direct	more than 40 lbin (45 kgcm)
- reverse	more than 40 lbin (45 kgcm)
Flexibility (ISO 1519)	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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