

INFRALIT PE 8430

Polyester Powder

PAINT TYPE	INFRALIT PE 8430 polyester powder is based on polyester resin and due to its special hardener it is free of TGIC. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT PE 8430 is suitable for product coating within the metal industry for objects that require a weather resistant coating that will not yellow on exposure to heat or ultraviolet light. Examples of use are e.g. constructions that are permanently outdoors. The suitability of metallic colours of polyester powders for outdoor use is to be discussed with the paint manufacturer.
SPECIAL PROPERTIES	INFRALIT PE 8430 polyester powder forms a mechanically and chemically resistant paint film that has good anticorrosive properties. The surface has good gloss retention even in outdoor conditions. Variant 8430-20 is flexible and designed for post forming after powder coating.

TECHNICAL DATA

Spraying	Variant PE...-00 is suitable for both tribo charging and corona charging sprays. Variants...-02, ...-09 and ...-40 only for corona charging sprays. Variant PE...-03 only for certain special sprays (Corona Disk).
Colours	By agreement.
Gloss grades	PE 8430-00: matt
Solids	100%
Specific gravity	Abt. 1,25 - 1,70 kg/dm ³ depending on colour
Spreading rate	8 - 10 m ² /kg depending on the film thickness
Film thickness	The recommended film thickness is 60 - 80 µm. When the film thickness exceeds 120 µm, water that evaporates in the curing process may form holes and bubbles in the paint film.
Curing time	10 min/190°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 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 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.

FILM PROPERTIES

Substrate cold-rolled steel, curing time 10 min/190°C:

Typical values

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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