



# INFRALIT PE 8445

## Polyester Powder

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<b>PAINT TYPE</b>	INFRALIT PE 8445 is a polyester powder coating. At elevated temperatures the powder melts, cures and forms the final paint film.
<b>USAGE</b>	INFRALIT PE 8445 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. machines and constructions that are permanently outdoors.
<b>SPECIAL PROPERTIES</b>	INFRALIT PE 8445 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 8445 is suitable for both tribo charging and corona charging sprays.
<b>Colours</b>	By agreement.
<b>Gloss grades</b>	60° = 60 - 95
<b>Solids</b>	100%
<b>Specific gravity</b>	Abt. 1,25 - 1,70 kg/dm <sup>3</sup> depending on colour
<b>Spreading rate</b>	6 - 10 m <sup>2</sup> /kg depending on the film thickness
<b>Film thickness</b>	Recommended film thickness is 60 - 120 µm.
<b>Curing time</b>	10 min/180°C (metal temperature).
<b>Packages</b>	20 kg
<b>Storage</b>	In dry and cool conditions.

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<b>SAFETY PRECAUTIONS</b>	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 80 g/m <sup>3</sup> (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.
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**DIRECTION FOR USE****Surface preparation**

COLD-ROLLED SURFACES: Degrease by trichloroethylene vapour bath or alkali wash. Zinc phosphating or a suitable conversion treatment 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 or alternatively treated with a suitable conversion treatment.

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 or a suitable conversion treatment is also required.

**FILM PROPERTIES**

Substrate 0.6 mm chromated aluminium, stoving 10 min/180°C, film thickness 70 µm. Tested 1 hour after curing:

**Typical values**

Flexibility (Erichsen, ISO 1520)	over 6 mm
Impact resistance (Erichsen, SFS EN ISO 6272)	
- direct	above 40 kgcm
- reverse	above 40 kgcm
Flexibility (ISO 1519 0.6 mm Al)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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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](http://www.teknos.com).

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