

INFRALIT PE 8540

Polyester Powder

PAINT TYPE	INFRALIT PE 8540 is a powder coating based on polyester resin. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT PE 8540 is suitable to use on steel and aluminium constructions indoors and outdoors.
SPECIAL PROPERTIES	INFRALIT PE 8540 forms a paint film which will not yellow and protects from UV-light. The surface has good gloss retention in outdoor conditions and will protect against corrosion. Variant -40: Superior flexibility, metallic & pearlescent shades Variant -41: Superior flexibility, solid shades Variant -42: Superior flexibility, textured surface
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TECHNICAL DATA	
Spraying	The powder is suitable for both tribo charging and corona charging sprays. Variant...-02 only for corona charging sprays.
Colours	Available in colours according to RAL, NCS or other colour cards.
Gloss 60°	Semigloss Many exceptions in this series. Check the gloss from the label.
Solids	100%
Specific gravity	n. 1,25 - 1,7 kg/dm ³ depending on colour
Spreading rate	6 - 10 m ² /kg depending on the film thickness
Film thickness	The recommended film thickness is 60 - 100 µm.
Curing time	10 min/180°C (metal temperature): variants -00, -02, -03, -05, -07, -40, -41, -42 10 min/160°C (metal temperature): variants -01, -04 Many exceptions in this series. Check the curing time from the label.
Packages	20 kg
Storage	Minimum 12 months in dry and cool conditions.
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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/m ³ (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.

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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