

INFRALIT PE 8595-03

Polyester Powder

PAINT TYPE	INFRALIT PE 8595-03 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 8595-03 is suitable for product coating within the metal industry for objects that require a weather resistant coating that is resistant to yellowing on exposure to heat or ultraviolet light. Examples of use are e.g. constructions that are permanently outdoors.
SPECIAL PROPERTIES	INFRALIT PE 8595-03 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. The product have been developed for IR-curing.

TECHNICAL DATA

Spraying	The powders are suitable for corona charging and for tribo charging sprays.
Colours	By agreement.
Gloss grades	Semigloss
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.
Curing time	2 min/200°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.

PTO

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.

HOT-ROLLED SURFACES AND CASTINGS: Remove grease and dirt. Blast-clean at least to grade Sa 2½ (ISO 8501-1). The surface profile at least medium (G) ISO 8503-2 . Remove the dust.

ALUMINIUM SURFACES: Degrease by e.g. alkali wash. Surfaces to be exposed to severe atmospheric conditions should also be chromated.

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.
