

**INFRALIT PE 8641****low temperature curing polyester powder**

PAINT TYPE	INFRALIT PE 8641 polyester powder is a TGIC free powder coating based on high quality polyester resin. At elevated temperatures the powder melts, cures and forms the final paint film.
USAGE	INFRALIT PE 8641 is suitable for steel and aluminium constructions in objects where good weather resistance is required.
SPECIAL PROPERTIES	INFRALIT PE 8641 forms a mechanically and chemically resistant paint film which has good corrosion resistance and good colour stability and gloss retention also in outdoor conditions. INFRALIT PE 8641-00 is the general variant suitable for both corona and tribo spraying. Variant PE 8641-02 is suitable for corona only. Variant PE 8641-07 is a pearlescent colour.

TECHNICAL DATA

Colours	By agreement.
Gloss 60°	Effect resembling sandpaper
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/160°C (metal temperature) 6 min/180°C (metal temperature) 3 min/200°C (metal temperature)

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 STEEL: Degreasing and zinc phosphating.

ALUMINIUM: Degreasing and chromating.

FILM PROPERTIES

Substrate chromated aluminium (100 x 300 x 0.6 mm), stoving 10 min/160°C:

Physical properties

Flexibility (Erichsen, ISO 1520)

over 6 mm

Impact resistance (SFS EN ISO 6272)

- direct

above 40 kgcm

- reverse

above 40 kgcm

Flexibility (ISO 1519)

less than 5 mm

Adhesion (cross-cut test, EN ISO 2409)

GT 0

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