

**INFRALIT PE 8642****low temperature curing polyester powder**

PAINT TYPE	INFRALIT PE 8642 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 8642 is suitable for steel and aluminium constructions in objects where good weather resistance is required.
SPECIAL PROPERTIES	INFRALIT PE 8642 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 8642-00 is the general variant suitable for both corona and tribo spraying. Variants PE 8642-02 and PE 8642-09 are suitable for corona only.
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TECHNICAL DATA	
Colours	By agreement.
Gloss 60°	Wavy structure
Spreading rate	6 - 10 m ² /kg depending on the film thickness
Film thickness	The recommended film thickness is 80 - 140 µm.
Curing time	10 min/160°C (metal temperature) 6 min/180°C (metal temperature)
	The colour and the gloss of the paint match the stoving of 10 min/160 °C. Using a higher stoving temperature may cause changes in the appearance of the paint film. This does not effect the mechanical properties of the surface. Also the anti-corrosive and weather resistance properties remain unaltered.
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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.

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