

**INFRALIT PE 8643****low temperature curing polyester powder**

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<b>PAINT TYPE</b>	INFRALIT PE 8643 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.
<b>USAGE</b>	INFRALIT PE 8643 is suitable for steel and aluminium constructions in objects where good weather resistance is required.
<b>SPECIAL PROPERTIES</b>	INFRALIT PE 8643 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 8643-00 is the general variant suitable for both corona and tribo spraying. Variant PE 8643-02 is suitable for corona only. Variant PE 8643-07 is a bonded metallic colour. Variant PE 8643-09 is a metallic or pearlescent colour designed for corona spraying.

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**TECHNICAL DATA**

<b>Colours</b>	By agreement.
<b>Gloss 60°</b>	25 - 45
<b>Spreading rate</b>	6 - 10 m <sup>2</sup> /kg depending on the film thickness
<b>Film thickness</b>	The recommended film thickness is 60 - 100 µm.
<b>Curing time</b>	15 min/160°C (metal temperature) 10 min/170°C (metal temperature) 7 min/180°C (metal temperature) 5 min/190°C (metal temperature)

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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<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.

**PTO**

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**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 15 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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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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