

INFRALIT PE 8949

Polyester Powder

**PAINT TYPE
USAGE**

INFRALIT PE 8949 is a powder coating that is TGIC-free and based on polyester resin.
INFRALIT PE 8949 is suitable for use on steel and aluminium objects indoors and outdoors.

SPECIAL PROPERTIES

INFRALIT PE 8949 forms a mechanically and chemically resistant, smooth paint film which will not yellow and which protects from UV-light.
The powders are produced with the Powder Mix Colour Service principle. The powders are available on very short delivery time. The typical batch size is 5 - 100 kg. The powders are not suitable for recycling.

The powders are designed for corona-charging spray, and therefore their suitability for tribo-charging sprays cannot be guaranteed.

VARIANTS

Surface	Without metallic/pearlescent pigment	With metallic/pearlescent pigment
Semigloss (G60° = 65 - 85)	INFRALIT PE 8350-20	INFRALIT PE 8949-09
Structured (hammer finish)	INFRALIT PE 8949-12	INFRALIT PE 8949-22
Semi-matt (G60° = 40 - 60)	INFRALIT PE 8949-17	INFRALIT PE 8949-27

TECHNICAL DATA**Colours**

Available in colours according to colour cards RAL and NCS, and in colours of numerous other colour cards. Also available in pearlescent and metallic shades and structured finish.

Gloss 60°

PE 8949-12 and -22: The gloss of the structured finish is not definable.
PE 8949-17 and -27: 40 - 60. Glosses below 40 are not possible.

Film thickness

As a principal rule, the recommended film thickness is 75 - 110 µm. When using hammer finish and semimatt powders, it is possible that even higher film thicknesses have to be used in order to achieve acceptable results. This is the case especially with yellow and red shades. The optimal film thickness must then be defined case-specifically by test applications.

Curing time

10 min/180°C (metal temperature).

The temperature of the powder coating has to reach the temperature inside the paint shop before the package is opened. The application properties may be deteriorated, if the temperature of the powder is lower than this.

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.

DIRECTION FOR USE**Surface preparation**

COLD-ROLLED STEEL: Degreasing and zinc phosphating.

ALUMINIUM: Degreasing and chromating.

FILM PROPERTIES

Test after 1 h curing, substrate 0.6 mm thick chromated aluminium, curing 10 min/180 °C (metal surface), film thickness 70 µm:

Physical properties

Flexibility (Erichsen, ISO 1520)

over 6 mm

Impact resistance (ASTM D 2794; 15.9 mm diameter)

- 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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