

INFRALIT EP/PE 8087-30

Epoxy/polyester primer

INFRALIT EP/PE 8087-30 is a powder coating based on a mixture of solid epoxy and polyester binders. At elevated temperature the powder will melt, cure and form the final paint film.

Suitable as one layer paint for coating metal industry products, such as lighting fixtures, apparatuses, wire gratings and refrigerating fixtures.

INFRALIT EP/PE 8087-30 is also suitable for use as a primer under another INFRALIT powder coating. A paint system of two coats provides a thicker protective layer and facilitates the coating of sharp edges. System is also suitable for outdoor objects which are exposed to UV light when a suitable weather resistant INFRALIT powder coating is chosen as a top coat.

White primer can also be used to improve the hiding power of the top coat when using bright and less opaque shades.

INFRALIT EP/PE 8087-30 forms a film with mechanical and chemical resistance and good anticorrosive properties. On outdoor exposure INFRALIT EP/PE 8087-30 epoxy/polyester powder has a tendency towards matting down (chalking) similar to that of pure epoxies. On the other hand, its tendency to yellow on overbaking and exposure to heat and ultraviolet light is minor as compared with epoxy powders.



TECHNICAL DATA

Fields of application	Ship, Machinery, Steel constructions, Furniture, Household appliances
Recommended substrate	Aluminium, Steel, Zinc
Binder	Epoxy-polyester
Solids	100%
Practical spreading rate	4 - 15 m ² /kg depending on the film thickness.
Film thickness	When painting with two coat system the optimal film thicknesses should be defined case-specifically by test paintings. A suitable basis is abt. 70 µm for each paint coat.
Colours	White (TW 02000) and grey (RAL 7001) Other colours by agreement.
Gloss (60°)	Matt
Density	Approx. 1.60 - 1.70 kg/dm ³

Storage

The storage life is minimum 18 months in dry and cool conditions when the temperature during storage and transportation is max. +25°C.

Take special care during high temperature seasons. Avoid storing close to heat sources and heaters in trucks and storages. Don't store in direct sunlight. The recommended expiry date of the powder coating that has been stored according to the instructions is shown on the package label.

Packaging

20 kg.

DIRECTION FOR USE**Surface preparation**

STEEL SURFACES: Remove grease and dirt. After that blast-cleaning at least to preparation grade Sa 2½ (ISO 8501-1) and/or a suitable chemical pretreatment.

ALUMINIUM SURFACES: Remove grease and dirt. After that chromating or alternatively a suitable chemical pretreatment.

HOT-DIP-GALVANIZED AND ZINC-ELECTROPLATED SURFACES: Remove grease, dirt and white rust by e.g. alkali wash. Depending on exposure conditions, chromating or alternatively a suitable chemical pretreatment is also required.

Application method

Corona charging spray

Powder coating is designed for application by corona charging spray.

Functionality by tribo charging spray must be ensured on every coating line by test application.

Curing time

10 min/180°C (substrate temperature)

Curing time indicates the time needed for the curing of the coating.

Curing parameters and oven type may effect the colour and gloss of the coating.

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.

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

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 explosion limit of typical powder coatings is between 20 g/m³ and 80 g/m³ (CEPE, Safe Powder Coating Guideline 8th Edition, 2020). 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.

FILM PROPERTIES

Typical values	Substrate 0.8 mm thick cold-rolled steel, film thickness 65 µm, curing time 10 min/180°C:
Bend test (Conical mandrel) SFS ISO 6860, mm	OK
Cross-cut test ISO 2409	GTO
Cupping ISO 1520, mm	7.0
Impact resistance, ISO 6272-2, direct, kgcm	40.0
Impact resistance, ISO 6272-2, reverse, kgcm	40.0
Pendulum damping test ISO 1522, s	180.0

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