DATA SHEET 2232
1 11.10.2017

INFRALIT PE 8435-10

Polyester Powder

PAINT TYPE

INFRALIT PE 8435-10 is a powder coating based on polyester resin, which due to its special hardener is free of TGIC. At elevated temperatures the powder melts, cures and forms the final paint film.

USAGE

INFRALIT PE 8435-10 Polyester Powder is suitable for coating objects where anti-microbic properties are needed.
INFRALIT PE 8435-10 Polyester Powder's anti-microbic properties are based on the active ingredients of noble metals.

SPECIAL PROPERTIES

INFRALIT PE 8435-10 forms a mechanically and chemically resistant paint film that has good anticorrosive properties. The surface has good gloss retention even in outdoor conditions.

APPROVALS

INFRALIT PE 8435-10 Polyester Powder fulfils the requirements of ISO 22196 for preventing the growth of certain microbes.

TECHNICAL DATA

Colours	Clear varnish
Gloss grades	Gloss
Solids	100%
Specific gravity	Abt. 1,3 kg/dm³
Spreading rate	6 - 10 m²/kg depending on the film thickness
Film thickness	The recommended film thickness is 60 - 100 µm. When the film thickness exceeds 120 µm, water that evaporates in the curing process may form holes and bubbles in the paint film.
Curing time	15 min/190°C (metal temperature).
Packages	In 15 kg packages.
Storage	In dry and cool conditions.

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.

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DIRECTION FOR USE

Surface preparation

COLD-ROLLED SURFACES: Degrease by trichloroethylene vapour bath or alkali wash. Zinc phosphating is also required if the workpiece is destined for outdoor exposure or will be subjected to exceptional strain indoors.

ALUMINIUM SURFACES: Degrease by e.g. alkali wash. Surfaces to be exposed to severe atmospheric conditions should also be chromated or alternatively treated with a suitable conversion treatment.

FILM PROPERTIES

Substrate 0.8 mm thick cold-rolled steel, curing time 15 min/190°C, film thickness 70 µm:

Physical properties

Flexibility (Erichsen, ISO 1520)	7 mm
Impact resistance (Erichsen, SFS EN ISO 6272)	
- direct	40 kgcm
- reverse	40 kgcm
Pendulum hardness (König, SFS 3642)	180 s
Flexibility (SFS ISO 6860)	passes
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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