

TECHNICAL DATA SHEET

REAFREE® 2892-T

Powder Resins / Saturated Carboxylated Polyester/ Glycidyl Ester

PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester suitable for the formulation of outdoor durable and protective tribochargeable thermosetting powders in combination with Araldite PT-910 or PT-912 type hardeners. Polyester for pigmented and clear coats. TMA free type.

SALES SPECIFICATIONS

| | CHARACTERISTICS | METHODS |
|------------------------------------|-----------------|-------------|
| Acid value | 30-35 mg KOH/g | ASTM D-1639 |
| Viscosity (Cone and plate - 165°C) | 60-90 Pa.s | DIN 53229 |
| Color (50%) | 2 max Gardner | ASTM D-1544 |

OTHER CHARACTERISTICS¹

| | CHARACTERISTICS | METHODS |
|--|-----------------|---------|
| Appearance | Pale granules | |
| Glass transition temperature (T _g) | approx 71 °C | DSC |

¹The data provided for these properties are typical values, intended only as guides, and should not be construed as sales specifications

CURING CONDITIONS

15 minutes at 190°C (object temperature)

RECOMMENDED MIXING RATIO

REAFREE® 2892-T / Araldite® PT-910⁽¹⁾ : 92/8

⁽¹⁾ Huntsman

MARKET

Coatings & Inks

- Industrial Coating
 - General Industry
 - Metal Exterior - Powder

PERFORMANCE BENEFITS

- Good flow.
- High gloss.
- Good mechanical properties.
- Good outdoor durability
- Excellent transparency in clear coats.
- Tribochargeable.

REAFREE® 2892-T

FORMULATION GUIDELINES

| STARTING FORMULATION | |
|---------------------------------|-----|
| REAFREE® 2892-T | 587 |
| Titanium Dioxide ⁽¹⁾ | 324 |
| Araldite PT-910 ⁽²⁾ | 51 |
| REAFREE® F3300-R10 | 35 |
| Benzoin | 3 |

⁽¹⁾ Kronos 2160

⁽²⁾ Huntsman

APPLICATION / EXTRUSION CONDITIONS

| CHARACTERISTICS | |
|----------------------------------|-------------|
| Extruder | BUSS PCS-30 |
| Spraying gun | GEMA PG 1-B |
| Torque | 40 % |
| Extrusion speed | 200 rpm |
| Application voltage | 60-80 kV |
| Test substrate (Degreased steel) | 1 mm |
| Extrusion temperature | 105 °C |

COATING PROPERTIES

| | CHARACTERISTICS | METHODS |
|-----------------|-----------------|-------------|
| Film thickness | 60-80 microns | |
| Gloss (60°) | Over 94 % | |
| Cupping test | Over 8 mm | DIN 53156 |
| Direct impact | Over 80 kg.cm | ASTM D-2794 |
| Reverse impact | Over 80 kg.cm | ASTM D-2794 |
| Conical mandrel | 100 % | ASTM D-522 |
| Adhesion | Gt0 | DIN 53151 |

PRODUCT SAFETY

Please refer to the corresponding Safety Data Sheet.

DELIVERY FORM

Granules. White opaque polyethylene bags of 25 Kg. One Ton pallet shrink – wrapped.

STORAGE AND HANDLING

The resin in its original unopened bags is stable for more than three years, stored in a dry place at temperature below 30°C. Avoid direct sunlight.

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