

## TECHNICAL DATA SHEET

# REAFREE® 6484-S

Powder Resins / Saturated Carboxylated Polyester / Epoxy

### PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester suitable for the formulation of decorative and protective thermosetting powders in combination with epoxy resins. General purpose polyester. TMA free type. Gas oven stabilized.

### SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	30-36 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	16-26 Pa.s	DIN 53229
Color (50%)	3 max Gardner	ASTM D-1544

### OTHER CHARACTERISTICS<sup>1</sup>

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx.58 °C	DSC

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

### CURING CONDITIONS

10 minutes at 180°C (object temperature)

### RECOMMENDED MIXING RATIO

REAFREE® 6484-S / Epoxy: 70/30

### MARKET

#### Coatings & Inks

- Industrial Coating
  - General Industry
  - Metal Exterior - Powder
  - Wood Furniture
  - Powder Coating - Others

### PERFORMANCE BENEFITS

- Very good flow.
- Very good gloss.
- High salt spray resistance.
- Good mechanical properties.

# REAFREE® 6484-S

## FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 6484-S	438
Titanium Dioxide <sup>(1)</sup>	334
Epoxy resins <sup>(2)</sup>	188
REAFREE® F3300-A15	37
Benzoin	3

<sup>(1)</sup> Kronos® 2160  
<sup>(2)</sup> Araldite® GT-7004 (Huntsman) DER™ 663 UE (Dow Chemical) Epikote® 3003 (Resolution)

## 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	80 °C

## COATING PROPERTIES

	CHARACTERISTICS	METHODS
Film thickness	60-80 microns	
Gloss	Over 94 %	ASTM D-523-60E
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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