

## TECHNICAL DATA SHEET

# REAFREE® 6614

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. No catalysed resin.

### SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	51-56 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	14-20 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 54 °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 200°C (oven temperature) (With REAFREE C4705-10)

### RECOMMENDED MIXING RATIO

REAFREE® 6614 / Epoxy: 60/40

### MARKET

#### Coatings & Inks

- Industrial Coating
  - Appliance
  - Automotive - OEM
  - General Industry
  - Metal Interior - Powder

### PERFORMANCE BENEFITS

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

# REAFREE® 6614

## FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 6614	347
REAFREE® C4705-10	16
Titanium Dioxide <sup>(1)</sup>	334
Epoxy resin <sup>(2)</sup>	263
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 (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.

Arkema Coating Resins 410 Gregson Dr. Cary, NC 27511 – USA T +1 919 469 6700	Arkema Química, S.A.U. Ctra. Olzinelles, s/n E-08470 Sant Celoni (BCN) Spain T +34 938 674 000	Arkema Chemical India Private Ltd. D-43, Trans Thane Creek MIDC Industrial Area 400706 Mumbai – India T +91 22 67377122	Headquarters: Arkema France 420, rue d'Estienne d'Orves 92705 Colombes Cedex France T +33 (0)1 49 00 80 80
---	--	---	--

Disclaimer - Please consult Arkema's disclaimer regarding the use of Arkema's products on <https://www.arkema.com/global/en/products/product-safety/disclaimer/> which is incorporated herein by reference and made a part hereof.  
Arkema France, a French société anonyme registered at the Trade and Companies Register of Nanterre under the number 319 632 790