REAFREE®

TECHNICAL DATA SHEET

REAFREE® 8308-T

Powder Resins / Saturated Carboxylated Polyester / β-Hydroxyalkylamide

PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester for combination with β-Hydroxyalkylamide type hardeners. Suitable for the formulation of outdoor durable and protective tribochargeable thermosetting powders for electrostatic application. For high gloss systems with improved flow and degassing properties. Low cross-linker demand Gas oven stabilised. TMA free type.

SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	24-29 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	18-32 Pa.s	DIN 53229
Color (50%)	2 max Gardner	ASTM D-1544

OTHER CHARACTERISTICS[1]

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx 57 °C	DSC

[1] 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)
15 minutes at 170°C (object temperature)

RECOMMENDED MIXING RATIO

REAFREE® 8308-T / PRIMID XL-552[(1)]: 96,5/3,5
REAFREE® 8308-T / PRIMID QM-1260[(1)]: 95,5/4,5
[(1)] EMS-Chemie AG

MARKET

Coatings & Inks

- Industrial Coating
  - General Industry

PERFORMANCE BENEFITS

- Excellent flow and degassing properties.
- High gloss.
- Good mechanical properties.
- Excellent outdoor durability.
- Good yellowing resistance curing with direct-fired gas ovens.
- Tribochargeable.

REAFREE® 8308-T

FORMULATION GUIDELINES

	STARTING FORMULATION
REAFREE® 8308-T	635
Titanium Dioxide [1]	320
ß-Hydroxyalkylamide [2]	23
Flow modifier [3]	10
Benzoin	2
CRAYVALLAC® PC	10

[1] Kronos® 2160
[2] Primid® XL-552 (EMS Chemie)
[3] Resiflow® PV-88 (Worlee)

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 90 %	
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 30ºC. Avoid direct sunlight.

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