

## TECHNICAL DATA SHEET

# REAFREE® 8400-T

Powder Resins / Saturated Carboxylated Polyester /  $\beta$ -Hydroxyalkylamide

### PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester for combination with  $\beta$ -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 crosslinker demand. Gas oven stabilised. TMA free type.

### SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	26-30 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	18-30 Pa.s	DIN 53229
Color (50%)	2 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® 8400-T / PRIMID XL-552<sup>(1)</sup>: 96/4

REAFREE® 8400-T / PRIMID QM-1260<sup>(1)</sup>: 95,5/4,5

<sup>(1)</sup> 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 and overbake.
- Tribochargeable.

# REAFREE® 8400-T

## FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 8400-T	569
Titanium Dioxide <sup>(1)</sup>	320
β-Hydroxyalkylamide <sup>(2)</sup>	24
REAFREE® F3300-B10	75
Benzoin	2
CRAYVALLAC PC	10

<sup>(1)</sup> Kronos® 2160  
<sup>(2)</sup> Primid® XL-552 (EMS Chemie)

## 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 95 %	
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.

<b>Arkema Coating Resins</b> 410 Gregson Dr. Cary, NC 27511 – USA T +1 919 469 6700	<b>Arkema Química, S.A.U.</b> Ctra. Olzinelles, s/n E-08470 Sant Celoni (BCN) Spain T +34 938 674 000	<b>Arkema Chemical India Private Ltd.</b> D-43, Trans Thane Creek MIDC Industrial Area 400706 Mumbai - India T +91 22 67377122	<b>Headquarter: Arkema France</b> 51, Esplanade du Général de Gaulle 92800 Puteaux – France T +33 (0)1 49 00 80 80
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