

## TECHNICAL DATA SHEET

# REAFREE® 8709

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 thermosetting powders for electrostatic application. Gas oven stabilised. TMA free type. High Tg polyester.

### SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	40-45 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	16-36 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 73 °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 160°C (object temperature)  
20 minutes at 150°C (object temperature)

### RECOMMENDED MIXING RATIO

REAFREE® 8709 / PRIMID XL-552<sup>(1)</sup>: 94/6  
REAFREE® 8709 / PRIMID QM-1260<sup>(1)</sup>: 93/7

<sup>(1)</sup> EMS-Chemie AG

### MARKET

#### Coatings & Inks

- Industrial Coating
  - Automotive - OEM
  - General Industry
  - Metal Exterior - Powder

### PERFORMANCE BENEFITS

- Good anti-scratch properties.
- High gloss.
- Good mechanical properties.
- Excellent outdoor durability.
- Good yellowing resistance curing with direct-fired gas ovens.

# REAFREE® 8709

## FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 8709	557
Titanium Dioxide <sup>(1)</sup>	310
β-Hydroxyalkylamide <sup>(2)</sup>	36
REAFREE® F3300-R10	75
Benzoin	2
CRAYVALLAC® PC	10
CRAYVALLAC® WN-1265	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 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 30°C. Avoid direct sunlight.

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