

REAFREE® 2776-TS

POWDER COATINGS / PT-910

TECHNICAL DATA SHEET

Product Application details

Saturated carboxylated polyester suitable for the formulation of outdoor durable and protective tribochargeable thermosetting powders in combination with Araldite PT-910 or PT-912 type hardeners. Polyester for pigmented and clear coats. Gas oven stabilised. TMA free type.

Performance Benefits

- Good flow.
- High gloss.
- Good mechanical properties.
- Good outdoor durability
- Excellent over-bake resistance, also in gas oven applications.
- Excellent transparency in clear coats.
- Tribochargeable.

Polymer Type

- Saturated Carboxylated Polyester Resin

Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	23 - 28
Viscosity 165°C, Pa.s (ICI – DIN 53229)	50 - 90

Other Characteristics¹

Appearance	Pale granules
Glass Transition T, °C (DSC - Tg)	approx 67

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

Curing Conditions

20 minutes at 170°C (object temperature)

Recommended Mixing Ratio

REAFREE 2776-TS / Araldite PT-910⁽¹⁾ : 93/7
⁽¹⁾ARALDITE PT-910 is a trade mark of Huntsman.

Formulation Guidelines

Starting Formulation

	Paint	Clear Coat
REAFREE 2776-TS	594	844
Titanium Dioxide ⁽¹⁾	271	-
Barium Sulfate ⁽²⁾	53	-
Araldite PT-910 ⁽³⁾	44	71
REAFREE F3300-A15	35	-
REAFREE F4700-B10	-	80
Benzoin	3	5

- (1) Kronos 2160
(2) Minerals Girona
(3) Huntsman

Application / Extrusion Conditions

Extruder:	BUSS PCS-30
Torque:	40%
Speed:	200 rpm
Extrusion temperature:	105°C
Spraying Gun:	GEMA PG 1-B
Application voltage:	60-80 Kv
Test substrate:	Degreased steel 1 mm

Coating Properties (pigmented paint)

Film thickness	60-80 microns
Gloss 60°, (ASTM D-523-60E)	Over 94%
Cupping test, (DIN 53156)	Over 8 mm
Direct Impact, (ASTM D-2794)	Over 80 Kg.cm
Reverse Impact, (ASTM D-2794)	Over 80 Kg.cm
Conical mandrel, (ASTM D-522)	100%
Adhesion, (DIN 53151)	Gt0

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 & 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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