

REAFREE® 8308-T

POWDER COATINGS / PRIMID

TECHNICAL DATA SHEET

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.

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.

Polymer Type

- Saturated Carboxylated Polyester Resin

Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	24 - 29
Viscosity 165°C, Pa.s (ICI – DIN 53229)	18 - 32

Other Characteristics¹

Appearance	Pale granules
Glass Transition T, °C (DSC - Tg)	approx 57

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

Curing Conditions

15 minutes at 180°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⁾PRIMID is a trade mark of EMS-Chemie AG

Starting Formulation

REAFREE 8308-T	635
Titanium Dioxide ⁽¹⁾	320
β -Hydroxyalkylamide ⁽²⁾	23
Flow modifier ⁽³⁾	10
Benzoin	2
CRAYVALLAC PC	10

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.

Formulation Guidelines

- (1) Kronos 2160
(2) Primid XL-552 (EMS Chemie)
(3) Resiflow PV 88 (Worlée)

Coating Properties

Film thickness	60-80 microns
Gloss 60°, (ASTM D-523-60E)	Over 90%
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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