

# REAFREE® 8784-T

POWDER COATINGS / PRIMID

TECHNICAL DATA SHEET

## 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 and triboelectric applications. For matt powder coatings by dry blending. Gas oven stabilised. TMA free type.

## Performance Benefits

- Good flow.
- For matt finishes by dry blending with REAFREE 8304-T.
- Good mechanical properties.
- Excellent outdoor durability.
- Good yellowing resistance.
- Tribochargeable.

## Polymer Type

- Saturated Carboxylated Polyester Resin

## Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	47 - 52
Viscosity 165°C, Pa.s (ICI – DIN 53229)	18 - 38

## Other Characteristics<sup>1</sup>

Appearance	Pale granules
Glass Transition T, °C (DSC - Tg)	approx 68

<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 8784-T / PRIMID XL-552<sup>(1)</sup> : 93/7  
REAFREE 8784-T / PRIMID QM-1260<sup>(1)</sup> : 91,5/8,5  
<sup>(1)</sup>PRIMID is a trade mark of EMS-Chemie AG

## Starting Formulation

	A	B
<b>REAFREE 8784-T</b>	---	583
<b>REAFREE 8304-T</b>	608	---
Titanium Dioxide <sup>(1)</sup>	319	317
$\beta$ -Hydroxyalkylamide <sup>(2)</sup>	19	44
CRAYVALLAC WN-1495	10	10
Flow modifier <sup>(3)</sup>	10	10
Benzoin	2	2
Barium sulfate	32	34

## Formulation Guidelines

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

DRY-blend paints **A/B**: 50/50

## 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.
Curing conditions:	15min. at 200°C

## Coating Properties

Film thickness	60-80 microns
Gloss 60°, (ASTM D-523-60E)	Ca 28%
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

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**Product Safety**

Please refer to the corresponding Safety Data Sheet.

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**Delivery form**

Granules. White opaque polyethylene bags of 25 Kg. One Ton pallet shrink – wrapped.

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**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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