

REAFREE® 6803-T

POWDER COATINGS / HYBRID

TECHNICAL DATA SHEET

Product

Saturated carboxylated polyester suitable for the formulation of decorative and protective thermosetting tribochargeable powders in combination with epoxy resins.

Application details

Flow improved.

Performance Benefits

- Very good flow.
- High salt spray resistance.
- Good mechanical properties.
- Good recoatability.
- Tribochargeable.

Polymer Type

- Saturated Carboxylated Polyester Resin

Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	70 - 78
Viscosity 165°C, Pa.s (ICI - DIN 53229)	5 - 15

Other Characteristics¹

Appearance	Pale granules
Glass Transition T, °C (DSC - Tg)	approx 52

¹ 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 200°C (oven temperature).

Recommended Mixing Ratio

REAFREE 6803-T / Epoxy : 50/50

Starting Formulation

REAFREE 6803-T	328
Titanium Dioxide ⁽¹⁾	331
Epoxy resins ⁽²⁾	328
Flow modifier ⁽³⁾	10
Benzoin	3

(1) Kronos 2160

(2) Araldite GT-7004 (Huntsman) DER 663 UE (Dow Chemical)

Epikote 3003 (Resolution)

(3) BBYK 360 P (Byk Chemie)

Formulation Guidelines

Application / Extrusion Conditions

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

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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