

TECHNICAL DATA SHEET

REAFREE® 2707-TS

Powder Resins / Saturated Carboxylated Polyester/ Glycidyl Ester

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.

SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Color (50%)	2 max Gardner	ASTM D-1544
Acid value	24 - 29 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	50 - 90 Pa.s	DIN 53229

OTHER CHARACTERISTICS¹

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx. 69 °C	DSC

¹The 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 (object temperature)

RECOMMENDED MIXING RATIO

REAFREE 2707-TS / Araldite PT-910 ⁽¹⁾ : 93/7

⁽¹⁾ ARALDITE PT-910 is a trade mark of Huntsman.

MARKET & APPLICATIONS

Coatings & Inks

- Industrial Coating
 - General Industry
 - Metal Exterior - Powder

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.

REAFREE® 2707-TS

FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 2707-TS	642
Titanium Dioxide ⁽¹⁾	296
Araldite PT-910 ⁽²⁾	48
Flow modifier ⁽³⁾	10
Benzoin	4

⁽¹⁾ Kronos® 2160

⁽²⁾ Huntsman

⁽³⁾ Resiflow PV-88 (Worlée)

APPLICATION / EXTRUSION CONDITIONS

CHARACTERISTICS	
Extruder	BUSS PCS-30
Spraying gun	GEMA PG 1-B
Extrusion speed	200 rpm
Torque	40 %
Extrusion temperature	105 °C
Application voltage	60-80 kV
Test substrate (Degreased steel)	1 mm

COATING PROPERTIES

	CHARACTERISTICS	METHODS
Film thickness	60-80 microns	
Gloss (60°)	Over 94 %	ASTM D-523-60E
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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