

## TECHNICAL DATA SHEET

# REAFREE® 2776-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
Acid value	23-28 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	50-90 Pa.s	DIN 53229
Color (50%)	2 max Gardner	ASTM D-1544

### OTHER CHARACTERISTICS<sup>1</sup>

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx 67 °C	DSC

<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

20 minutes at 170°C (object temperature)

### RECOMMENDED MIXING RATIO

REAFREE® 2776-TS / Araldite® PT-910<sup>(1)</sup> : 93/7

<sup>(1)</sup> 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® 2776-TS

## FORMULATION GUIDELINES

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

<sup>(1)</sup> Kronos® 2160

<sup>(2)</sup> Minerals Girona

<sup>(3)</sup> Huntsman

## APPLICATION / EXTRUSION CONDITIONS

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

## COATING PROPERTIES

	CHARACTERISTICS	METHODS
Film thickness	60-80 microns	
Gloss (60°)	Over 94 %	
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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