

TECHNICAL DATA SHEET

REAFREE® 2872-T

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. Suitable for textured finishes in combination with HAA. TMA free type.

SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	30-35 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	60-90 Pa.s	DIN 53229
Color (50%)	2 max Gardner	ASTM D-1544

OTHER CHARACTERISTICS¹

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (T _g)	approx 71 °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 180°C (object temperature)

RECOMMENDED MIXING RATIO

REAFREE® 2872-T / Araldite® PT-910⁽¹⁾ : 92/8

REAFREE® 2872-T / HAA: 95/5

REAFREE® 2872-T / TGIC: 93/7

⁽¹⁾ Huntsman

MARKET & APPLICATIONS

Coatings & Inks

- Industrial Coating
 - General Industry
 - Metal Exterior - Powder
 - Metal Interior - Powder

PERFORMANCE BENEFITS

- High gloss
- Good mechanical properties
- Good outdoor durability
- Excellent transparency in clear coats
- Tribochargeable
- Good texturing properties

REAFREE® 2872-T

FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 2872-T	587
Titanium Dioxide ⁽¹⁾	324
Araldite® PT-910 ⁽²⁾	51
REAFREE® F3300-R10	35
Benzoin	3

⁽¹⁾ Kronos® 2160

⁽²⁾ 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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