

TECHNICAL DATA SHEET

REAFREE® 6694

Powder Resins / Saturated Carboxylated Polyester / Epoxy

PRODUCT APPLICATION DETAILS

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

SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	50-56 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	14-20 Pa.s	DIN 53229
Color (50%)	3 max Gardner	ASTM D-1544

OTHER CHARACTERISTICS¹

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx 55 °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 190°C (object temperature)

RECOMMENDED MIXING RATIO

REAFREE® 6694 / Epoxy: 60/40

MARKET & APPLICATIONS

Coatings & Inks

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

PERFORMANCE BENEFITS

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

REAFREE® 6694

FORMULATION GUIDELINES

STARTING FORMULATION	
REAFREE® 6694	363
Titanium Dioxide ⁽¹⁾	334
Epoxy resins ⁽²⁾	263
REAFREE® F3300-A15	37
Benzoin	3

⁽¹⁾ Kronos® 2160

⁽²⁾ Araldite® GT-7004 (Huntsman) DER™ 663 UE (Dow Chemical) Epikote® 3003 (Resolution)

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	80 °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.

Arkema Coating Resins
410 Gregson Dr.
Cary, NC 27511 – USA
T +1 919 469 6700

Arkema Química, S.A.U.
Ctra. Olzinelles, s/n
E-08470 Sant Celoni (BCN)
Spain
T +34 938 674 000

Arkema Chemical India Private Ltd.
D-43, Trans Thane Creek
MIDC Industrial Area
400706 Mumbai - India
T +91 22 67377122

Headquarters: Arkema France
51, Esplanade du Général de Gaulle
92800 Puteaux – France
T +33 (0)1 49 00 80 80

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