

TECHNICAL DATA SHEET

REAFREE® 8301

Powder Resins / Saturated Carboxylated Polyester / β -Hydroxyalkylamide

PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester for combination with β -Hydroxyalkylamide type hardeners. Suitable for the formulation of outdoor durable and protective thermosetting powders for electrostatic applications. For matt powder coatings by dry blending. Gas oven stabilised. TMA free type.

SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	14-17 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	15-35 Pa.s	DIN 53229
Color (50%)	2 max Gardner	ASTM D-1544

OTHER CHARACTERISTICS¹

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (Tg)	approx.52 °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)
15 minutes at 180°C (object temperature)

RECOMMENDED MIXING RATIO

REAFREE® 8301 / PRIMID XL-552⁽¹⁾: 97/3
REAFREE® 8301 / PRIMID QM-1260⁽¹⁾: 96/4
⁽¹⁾ EMS-Chemie AG

MARKET & APPLICATIONS

Coatings & Inks

- Industrial Coating
 - General Industry
 - Metal Exterior - Powder
 - Wood Furniture
 - Powder Coating - Others

PERFORMANCE BENEFITS

- Excellent levelling.
- Good degassing properties.
- For matt finishes by dry blending with REAFREE 8184.
- Good mechanical properties.
- Good yellowing resistance curing with direct-fired gas ovens.
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REAFREE® 8301

FORMULATION GUIDELINES

	STARTING FORMULATION	
	A	B
REAFREE® 8301	608	-
REAFREE® 8184	-	564
Titanium Dioxide ⁽¹⁾	319	317
β-Hydroxyalkylamide ⁽²⁾	19	63
CRAYVALLAC® WN-1495	10	10
Flow modifier ⁽³⁾	10	10
Benzoin	2	2
Barium sulfate	32	34

⁽¹⁾ Kronos® 2160

⁽²⁾ Primid® XL-552 (EMS Chemie)

⁽³⁾ Resiflow PV-88 (Worlée)

DRY-blend paints A/B: 50/50

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°)	Ca 28 %	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 %	DIN 53151
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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