

REAFREE® 4704

POWDER COATINGS / TGIC

TECHNICAL DATA SHEET

Product Application details

Saturated carboxylated polyester for combination with Triglycidyl Isocyanurate.
Suitable for the formulation of outdoor durable and protective thermosetting powders for electrostatic application.

High Tg resin.

TMA free type.

Performance Benefits

- Good flow.
- High gloss.
- High binding power.
- Good mechanical properties.
- Excellent outdoor durability.

Polymer Type

- Saturated Carboxylated Polyester Resin

Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	33 - 38
Viscosity 165°C, Pa.s (ICI – DIN 53229)	40 - 65

Other Characteristics¹

Appearance	Pale granules
Glass Transition T, °C (DSC - Tg)	approx 72

¹ The 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 4704 / TGIC : 93/7

Starting Formulation

REAFREE 4704	595
Titanium Dioxide ⁽¹⁾	320
Triglycidyl Isocyanurate ⁽²⁾	45
REAFREE F3300-A15	37
Benzoin	3

⁽¹⁾ Kronos 2160

⁽²⁾ Araldite PT-810 (Huntsman) / Tepic (Nissan Chemical)

Formulation Guidelines

Application / Extrusion Conditions

Extruder:	BUSS PCS-30
Torque:	40%
Speed:	200 rpm
Extrusion temperature:	80°C
Spraying Gun:	GEMA PG 1-B
Application voltage:	60-80 Kv
Test substrate:	Degreased steel 1 mm

Coating Properties

Film thickness	60-80 microns
Gloss 60°, (ASTM D-523-60E)	Over 90%
Cupping test, (DIN 53156)	Over 8 mm
Direct Impact, (ASTM D-2794)	Over 80 Kg.cm
Reverse Impact, (ASTM D-2794)	Over 80 Kg.cm
Conical mandrel, (ASTM D-522)	100%
Adhesion, (DIN 53151)	Gt0

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 & 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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