REAFREE® 8784-T

POWDER COATINGS / PRIMID — TECHNICAL DATA SHEET

Product Application details

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

Performance Benefits

- Good flow.
- For matt finishes by dry blending with REAFREE 8304-T.
- Good mechanical properties.
- Excellent outdoor durability.
- Good yellowing resistance.
- Tribochargeable.

Polymer Type

- Saturated Carboxylated Polyester Resin

Sales Specifications

Colour (50%), (ASTM D-1544)	2 max
Acid value, mg KOH/g (ASTM D-1639)	47 - 52
Viscosity 165ºC, Pa.s (ICI – DIN 53229)	18 - 38

Other Characteristics[1]

Appearance	Pale granules
Glass Transition T, ºC (DSC - Tg)	Approx 68

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 180ºC (object temperature)

Recommended Mixing Ratio

REAFREE 8784-T / PRIMID XL-552(1): 93/7
REAFREE 8784-T / PRIMID QM-1260(1): 91,5/8,5
(1)PRIMID is a trademark of EMS-Chemie AG

Formulation Guidelines

Starting Formulation

	A	B
REAFREE 8784-T	---	583
REAFREE 8304-T	608	---
Titanium Dioxide(1)	319	317
β-Hydroxy-alkylamide(2)	19	44
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

Extruder:	BUSS PCS-30
Torque:	40%
Speed:	200 rpm
Extrusion temperature:	105ºC
Spraying Gun:	GEMA PG 1-B
Application voltage:	60-80 Kv
Test substrate:	Degreased steel 1 mm.
Curing conditions:	15min. at 200ºC

Coating Properties

Film thickness	60-80 microns
Gloss 60º, (ASTM D-523-60E)	Ca 28%
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

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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 30ºC. Avoid direct sunlight.

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