

## General Description

CRYLCOAT® 2618-3 is a high performance, tribo-active carboxylated polyester resin for use with Primid® XL-552 to produce powder coatings. Formulations based on CRYLCOAT® 2618-3 exhibit good flow and mechanical properties, very good overbake resistance, and good gas resistance. These formulations provide a level of outdoor weathering resistance that meets GSB and Qualicoat standards.

## Saturated Polyester Resin

### Product Specification

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	2800-3400
Color, b-value	Max. 10
Acid value (mg KOH/g)	30-35

### Other Properties

	Typical value
Glass transition (°C)	Approx. 61

### Starting Formulation

Component	Weight (%)
CRYLCOAT® 2618-3	65.3
Primid® XL 552	3.3
Titanium dioxide	30.0
MODAFLOW® Powder 6000	1.0
Benzoin	0.4

### Extrusion & Application Conditions

Extrusion	
Extruder	Twin screw
Speed	250 rpm
Torque	75 ± 5 %
Temperature	95 to 105 °C
Application	
Application	60 micrometer film on steel / chromated Al panel
Spray Gun	Output voltage: 60 kV
Curing	10 min @ 180° C metal temperature

### Film Properties

Test	Result
Gloss @ 20°/60° (%)	89/95
Direct/reverse impact on steel (kg. cm or in. lbs.)	160/160
Direct/reverse impact on Al (kg. cm or in. lbs.)	80/80

### Shelf Life

Under normal storage conditions (≤30°C), the shelf life of the resin will be 24 months from date of manufacturing. For product older than 24 months, it is recommended to check the acid value and the viscosity every year.

### Safety & Environmental Protection

For more information, please refer to the Material Safety Data Sheet.

July 2020 – Supersedes previous versions