

General Description

CRYLCOAT® 2640-3 is a low demand carboxyl functional polyester resin for use with 3.5% Primid® XL-552 in the production of powder coatings. Coatings based on CRYLCOAT® 2640-3 combine good mechanical properties with excellent outdoor durability.

(Formerly CRYLCOAT® E 04220)

Preliminary Technical Data Sheet

Saturated Polyester Resin

Product Specification

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	Approx. 7000
Color, b-value	Max. 15
Acid value (mg KOH/g)	Approx. 23

Other Properties

	Typical value
Glass transition (°C)	Approx. 60

Starting Formulation

Component	Weight (%)
CRYLCOAT® 2640-3	66.4
Primid® XL 552	2.4
Titanium dioxide	30.0
MODAFLOW® Powder 6000	1.0
Benzoin	0.2

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° (%)	87/96
Direct/reverse impact on Al (kg. cm or in. lbs.)	80/80
Direct/reverse impact on steel (kg. cm or in. lbs.)	160/160

Shelf Life

Under normal storage conditions ($\leq 30^{\circ}\text{C}$), 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.

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