# CRYLCOAT® 2651-3



## **General Description**

CRYLCOAT® 2651-3 is a high performance tribo active carboxyl functional polyester resin for Primid® XL 552 based outdoor powder coatings. Powder films based on CRYLCOAT® 2651-3 exhibit excellent flow and degassing properties, excellent outdoor durability; good mechanical properties, over-bake and gas oven resistance.

(Formerly CRYLCOAT® E 04151)

## **Saturated Polyester Resin**

### **Product Specification**

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	2300-3300
Color, b-value	Max. 15
Acid value (mg KOH/g)	28 - 32

## **Other Properties**

	Typical value
Glass transition (°C)	Approx. 54

## **Starting Formulation**

Component	Weight (%)
CRYLCOAT <sup>®</sup> 2651-3	60.5
Primid <sup>®</sup> XL 552	3.2
MODAFLOW <sup>®</sup> Powder 6000	1.0
Barium sulfate	10.0
Titanium dioxide	25.0
Benzoin	0.3

# **Extrusion & Application Conditions**

Extrusion		
Extruder	Twin screw	
Speed	300 rpm	
Torque	80 ± 5 %	
Temperature	110 to 120 °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° (%)	82/95
Direct/reverse impact on steel (kg. cm or in. lbs.)	160/160
Direct/reverse impact on AI (kg. cm or in. lbs.)	80/80

## Shelf Life

Under normal storage conditions ( $\leq 25^{\circ}$ 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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## 2.1 / 03.07.2020 (replaces all previous versions)

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