

General Description

CRYLCOAT® 2668-6 is a low bake tribo active carboxyl functional Primid® polyester resin in ratio of 97/3 for matte dry- blend systems. In combination with CRYLCOAT® 2693-6, powder coatings with 60° gloss between 25 and 30 gloss units can be formulated; full cure can be achieved at 12 min x 160°C schedule.

(Formerly CRYLCOAT® E 04668)

Preliminary Technical Data Sheet

Saturated Polyester Resin

Product Specification

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	Approx. 12000
Color, b-value	Max. 15
Acid value (mg KOH/g)	Approx. 18

Other Properties

	Typical value
Glass transition (°C)	Approx. 60

Starting Formulation

Component	Weight (%)	
CRYLCOAT® 2668-6	66.6	--
CRYLCOAT® 2693-6	--	63.9
Primid® XL-552	2.1	4.8
Titanium dioxide	30.0	30.0
MODAFLOW® Powder 6000	1.0	1.0
Benzoin	0.3	0.3

Extrusion & Application Conditions

Extrusion	
Extruder	Twin screw
Speed	300 rpm
Torque	50 ± 5 %
Temperature	95 to 105 °C
Application	
Application	60 micrometer film on pre-treated aluminium panel
Spray Gun	Output voltage: 60 kV
Curing	12 min @ 160° C metal temperature

Film Properties

Test	Result
Gloss @ 60° (%) with CRYLCOAT® 2693-6 (1 : 1)	30
Reverse impact (kg. cm or in. lbs.) Al-panel	50

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.

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