

## TECHNICAL DATA SHEET

# REAFREE® 8598-T

Powder Resins / Saturated Carboxylated Polyester /  $\beta$ -Hydroxyalkylamide

### PRODUCT APPLICATION DETAILS

Saturated carboxylated polyester for combination with  $\beta$ -Hydroxyalkylamide type hardeners. Suitable for the formulation of outdoor durable and protective tribochargeable thermosetting powders for electrostatic application. For high gloss systems with improved flow and degassing properties. Gas oven stabilised. TMA free type.

### SALES SPECIFICATIONS

	CHARACTERISTICS	METHODS
Acid value	28-34 mg KOH/g	ASTM D-1639
Viscosity (Cone and plate - 165°C)	16-26 Pa.s	DIN 53229
Color (50%)	2 max Gardner	ASTM D-1544

### OTHER CHARACTERISTICS<sup>1</sup>

	CHARACTERISTICS	METHODS
Appearance	Pale granules	
Glass transition temperature (T <sub>g</sub> )	approx 58 °C	DSC

<sup>1</sup>The data provided for these properties are typical values, intended only as guides, and should not be construed as sales specifications

### CURING CONDITIONS

15 minutes at 180°C (object temperature)

### RECOMMENDED MIXING RATIO

REAFREE® 8598-T / PRIMID XL-552<sup>(1)</sup>: 95/5  
REAFREE® 8598-T / PRIMID QM-1260<sup>(1)</sup>: 94,5/5,5  
<sup>(1)</sup> EMS-Chemie AG

### MARKET

#### Coatings & Inks

- Industrial Coating
  - General Industry
  - Metal Exterior - Powder

### PERFORMANCE BENEFITS

- Excellent flow and degassing properties.
- High gloss.
- Good mechanical properties.
- Excellent outdoor durability.
- Good yellowing resistance curing with direct-fired gas ovens.
- Tribochargeable.

# REAFREE® 8598-T

## FORMULATION GUIDELINES

STARTING FORMULATION	
<b>REAFREE® 8598-T</b>	564
Titanium Dioxide <sup>(1)</sup>	310
β-Hydroxyalkylamide <sup>(2)</sup>	29
<b>REAFREE® F3300-R10</b>	75
Benzoin	2
CRAYVALLAC® PC	10
CRAYVALLAC® WN-1265	10

<sup>(1)</sup> Kronos® 2160

<sup>(2)</sup> Primid® XL-552 (EMS Chemie)

## APPLICATION / EXTRUSION CONDITIONS

CHARACTERISTICS	
Extruder	BUSS PCS-30
Spraying gun	GEMA PG 1-B
Torque	40 %
Extrusion speed	200 rpm
Application voltage	60-80 kV
Test substrate (Degreased steel)	1 mm
Extrusion temperature	105 °C

## COATING PROPERTIES

	CHARACTERISTICS	METHODS
Film thickness	60-80 microns	
Gloss (60°)	Over 90 %	
Cupping test	Over 8 mm	DIN 53156
Direct impact	Over 80 kg.cm	ASTM D-2794
Reverse impact	Over 80 kg.cm	ASTM D-2794
Conical mandrel	100 %	ASTM D-522
Adhesion	Gt0	DIN 53151

## 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 AND HANDLING

The resin in its original unopened bags is stable for more than three years, stored in a dry place at temperature below 30°C. Avoid direct sunlight.

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