

### General Description

CRYLCOAT® 2608-6 is a high reactive carboxyl functional polyester resin for use with Primid® XL 552 in 95/5 mixing ratio in industrial outdoor powder coatings. Coatings made with CRYLCOAT® 2608-6 exhibit excellent cure response and broad cure window, good flow, improved storage stability and blooming resistance.

(Formerly CRYLCOAT® E 04408)

Preliminary Technical Data Sheet

### Saturated Polyester Resin

#### Product Specification

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	Approx. 4000
Color, b-value	Max. 15
Acid value (mg KOH/g)	Approx. 33

#### Other Properties

	Typical value
Glass transition (°C)	Approx. 60

#### Starting Formulation

Component	Weight (%)
CRYLCOAT® 2608-6	55.6
Primid® XL 552	2.9
Barium sulfate	11.0
Titanium dioxide	29.0
MODAFLOW® Powder 6000	1.0
Benzoin	0.5

#### Extrusion & Application Conditions

Extrusion	
Extruder	Twin screw
Speed	250 rpm
Torque	70 ± 5 %
Temperature	90 to 100 °C
Application	
Application	60 micrometer film on steel/chromated Al panel
Spray Gun	Output voltage: 60 kV
Curing	10 min @ 160° C metal temperature

#### Film Properties

Test	Result
Gloss @ 20°/60° (%)	85/94
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.

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