

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® 2651-3	60.5
Primid® XL 552	3.2
MODAFLOW® 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 Al (kg. cm or in. lbs.)	80/80

Shelf Life

Under normal storage conditions (≤25°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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