

General Description

CRYLCOAT® 2471-4 is a carboxyl functional polyester resin for clear exterior durable powder coatings when used with 93/7 TGIC. CRYLCOAT® 2471-4 exhibits optimized flow and transparency.

Saturated Polyester Resin

Product Specification

| | Limits |
|--------------------------------------|---------------|
| Appearance | Pale granules |
| Brookfield Viscosity @ 200 °C, mPa.s | 2500-4500 |
| Color, b-value | Max. 15 |
| Acid value (mg KOH/g) | 30-36 |

Other Properties

| | Typical value |
|-----------------------|---------------|
| Glass transition (°C) | Approx. 58 |

Starting Formulation

| Component | Weight (%) |
|------------------|------------|
| CRYLCOAT® 2471-4 | 92.5 |
| TGIC | 7.0 |
| Benzoin | 0.5 |

Extrusion & Application Conditions

| Extrusion | |
|-------------|--|
| Extruder | Twin screw |
| Speed | 250 rpm |
| Torque | 70-80 % |
| Temperature | 95 to 105 °C |
| Application | |
| Application | 60 micrometer film on 0.5 mm steel/chromated Al panel |
| Spray Gun | Output voltage: 60 kV |
| Curing | 10 min @ 200° C metal temperature 15 min @ 170° C metal temperature |

Film Properties

| Test | Result |
|---|---------|
| Direct/reverse impact on Al (kg cm or in-lb) | 80/80 |
| Direct/reverse impact on steel (kg cm or in-lb) | 160/160 |

Shelf Life

Under normal storage conditions ($\leq 30^{\circ}\text{C}$), 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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