

General Description

CRYLCOAT® 2506-1 is a carboxyl functional polyester resin cured with Araldite® PT 910 (91/9) at 180°C. Coatings based on CRYLCOAT® 2506-1 exhibit excellent flow and outdoor durability. The resin is tribo active and can be used in gas-fired ovens.

Saturated Polyester Resin

Product Specification

	Limits
Appearance	Pale granules
Brookfield Viscosity @ 200 °C, mPa.s	4000-6000
Color, b-value	Max. 10
Acid value (mg KOH/g)	30-36

Other Properties

	Typical value
Glass transition (°C)	Approx. 67

Starting Formulation

Component	Weight (%)
CRYLCOAT® 2506-1	62.4
Araldite® PT 910	6.2
Titanium dioxide	30.0
MODAFLOW® Powder 6000	1.0
Benzoin	0.4

Extrusion & Application Conditions

Extrusion	
Extruder	Twin screw
Speed	250 rpm
Torque	70 to 80 %
Temperature	95 to 105 °C
Application	
Application	60 micrometer film on 0.5 mm chromated Al panel
Spray Gun	Output voltage: 60 kV
Curing	15 min @ 180 °C metal temperature

Film Properties

Test	Result
Gloss @ 20°/60° (%)	82/94
Direct/reverse impact (kg. cm or in. lbs.)	80/80

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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