

## General Description

CRYLCOAT® 1620-0 is a carboxylated polyester resin for use in hybrid powder coatings in a ratio range of 50/50 to 60/40. Coatings based on CRYLCOAT® 1620-0 can be blended with CRYLCOAT® 1622-0 in all ratios to provide intermediate reactivity.

## Saturated Polyester Resin

### Product Specification

|                                      | Limits        |
|--------------------------------------|---------------|
| Appearance                           | Pale granules |
| Brookfield Viscosity @ 200 °C, mPa.s | 2000-3300     |
| Color, b-value                       | Max. 15       |
| Acid value (mg KOH/g)                | 55-65         |

### Other Properties

|                       | Typical value |
|-----------------------|---------------|
| Glass transition (°C) | Approx. 54    |

### Starting Formulation

| Component                 | Weight (%) |
|---------------------------|------------|
| CRYLCOAT® 1620-0          | 33.0       |
| Epoxy resin (EEW 700-900) | 24.0       |
| Titanium dioxide          | 29.0       |
| Barium sulfate            | 10.5       |
| ADDITOL® P 896            | 3.0        |
| Benzoin                   | 0.5        |

### Extrusion & Application Conditions

| Extrusion   |  |
|-------------|--|
| Extruder    | Twin screw   |
| Speed       | 250 rpm  |
| Torque      | 75 ± 5 %   |
| Temperature | 95 to 105 °C   |
| Application |  |
| Application | 60 micrometer film on steel panel                                      |
| Spray Gun   | Output voltage: 60 kV  |
| Curing      | 10 min @ 170° C metal temperature<br>20 min @ 160° C metal temperature |

### Film Properties

| Test                                       | Result  |
|--|---------|
| Gloss @ 20°/60° (%)                        | 84/94   |
| Direct/reverse impact (kg. cm or in. lbs.) | 160/160 |

### 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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