

## P3909-1( 93:7 ) SATURATED POLYESTER RESIN

### PRODUCT

#### Properties

P3909-1(93:7) is a saturated polyester resin, which is used together with TGIC (by 93:7) to produce pure polyester powder coatings.  
It is available for semi-gloss powder coatings.

#### Specifications

Appearance: Light yellow & clear flake

Color (DMF50%): 5-10

Acid value (mgKOH/g): 28-34

Glass Transition Temperature (°C): ≥63

Viscosity (200°C/mPa.s): 3000-4500

#### Recommended Formulation

INGREDIENT	WEIGHT
Polyester resin P3909-1(93:7)	600g
TGIC	45g
TiO <sub>2</sub> (R902)	350g
Flow agent(PV88/GLP588)	10g
Benzoin	5g
Matting Agent	20-50g

#### Technical condition for making coatings

Extruder: SLJ-30AF

Clamp set temperature(°C): 110-120

Helix pole temperature(°C): 60

Rotational speed(rpm): 50

Powder particle size(μm .max): 100

Curing condition: 200°C/15 min (metal temperature)

#### Coating film properties

Film thickness(μm): 70± 10      Gloss (60°C) %: ≤ 30± 10

Bend (mm): ≤6      Impact intensity(kg·cm): 50

Pencil hardness: 1H

#### Package and Shelf Life

**a. Package:** net 25kgs in PE bag or multi-ply paper bag;

**b. Shelf Life:** in a ventilative, dry and clean place under 30°C, its shelf life is one year.

#### Spraying methods and conditions

Oilless and rustless cold-rolled steel plate (mm): 0.5

Electrostatic spraying (kv): 50

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