

P3913(93:7) SATURATED POLYESTER RESIN

PRODUCT

Properties

P3913(93:7) is a saturated polyester resin, which is used together with TGIC (by 93:7) to produce pure polyester powder coatings, low temperature curing, giving high gloss.

Specifications

Appearance: Light yellow & clear flake

Color (DMF50%): 5-10

Acid value (mgKOH/g): 30-36

Glass Transition Temperature (°C): ≥64

Viscosity (200°C/mPa.s): 4500-6000

Technical condition for making coatings

Extruder: SLJ-30AF

Clamp set temperature(°C): 110-120

Helix pole temperature(°C): 60

Rotational speed(rpm): 60

Powder particle size(μm .max): 100

Curing condition: 160°C/12 min (metal temperature)

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.

Recommended Formulation

INGREDIENT	WEIGHT
Polyester resin P3913(93:7)	600g
TGIC	45g
TiO ₂ (R902)	342g
Flow agent(PV88/GLP588)	10g
Benzoin	3g

Coating film properties

Film thickness(μm): 70± 10 Gloss (60°C) %: ≥90
 Bend (mm): ≤6 Impact intensity(kg·cm): 50
 Pencil hardness: 1H

Spraying methods and conditions

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

Electrostatic spraying (kv): 50

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