# SIRALES® PE 8420

PRODUCT DATA SHEET

RS/034/030004/1

### **Description**

Carboxylated polyester resin, free from trimellitic anhydride, suitable for HYBRID powder coatings.

### **Applications**

Sirales PE 8420 is suggested in combination 70/30 p.b.w. with EPOSIR 7167 PG or EPOSIR 7175 PG, to manufacture powder coatings with very good flow and gloss, good overbaking and with good Tribo applicability.

Curing cycles (real time) 15 min. at 200°C

20 min. at 180°C

**Sales specification** 

Property	Value	Unit	Method
Acid number	32 40	mg KOH/gr	SIR 10328
Viscosity at 200°C (ICI cone plate)	3500 5500	m.Pa.s.	SIR 10391
Colour (1)	3 max.	Sc. Gardner	ASTM D 1544

<sup>(1)</sup> Determined on 50% m/m solution on dimethylformamide.

### **Typical Properties**

Property	Value	Unit	Method
Glass transition temperature	54	°C	ASTM D 3418

### **Supply Form**

Product is available as irregular flakes packed in 25 kg Polyethylene bags.

### Storage stability

The product should be stored in the original bags kept tightly closed, away from sunshine and heat sources. Under these conditions and at a normal temperature (20°C) the resin should have a stability of one year.

#### **Safety**

The product is not flammable and no toxic effect has been determined.

Further information are provided in the relevant safety data sheet.

SIRALES ®: SIR INDUSTRIALE registered trade mark.

N.B.: The data given in this brochure do not constitute characteristic properties of the single product.

To our best knowledge, the information contained in this brochure is accurate and corresponds to the truth.

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**APPLICATION DATA** 

## **Typical formulation**

SIRALES PE 8420	420
EPOSIR 7168 PG	126
EPOSIR 7170 PGF-10	60
BENZOIN	4
KRONOS 2310	290
Blanc Fixe F	100

### **Extrusion condition**

Extruder	BUSS PLK 46
Casting temperature	100°C
Screw temperature	Cold
Speed	80 - 120 rpm

### Film properties (curing cycle 15 min. at 200°C; 20 min. at 180°C real time)

	-,,,,
Film thickness	60-100μm
Identation (DIN 53156)	> 9 mm
Direct gardner impact (ASTM D 2794)	> 10 Nm
Reverse gardner impact (ASTM D 2794)	> 10 Nm
Mandrel bend resistance (ASTM D 522)	pass

### **Formulation MATT**

SIRALES PE 8420	294
EPOSIR 7168 PG	288
HULLS B 68	18
BYK 360/P	12
KRONOS 2310	300
HYDROCARB (Omya)	100

### **Extrusion condition**

Extruder	BUSS PLK 46
Casting temperature	100°C
Screw temperature	Cold
Speed	80 - 120 rpm

### Film properties (curing cycle 15 min. at 200°C; 20 min. at 180°C real time)

Time properties (caring cycle it immit at 200°C) 20 immit at 100°C real time)		
Film thickness 60-100µm		
	15'/200°C	20'/180°C
Gloss 60°	35	34
Gloss 20°	9	9

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