KHUA®
ZHEJIANG GUANGHUA TECHNOLOGY

Technical Data Sheet

GH-4412

Version: September 1,2020

POWDER COATING RESINS	PRIMID
PE : HARDENER = 93 : 7	

Description

GH-4412 is a saturated carboxylated polyester resin designed for 93/7 Primid powders to be cured at 180°C. Dry blending with GH-4411 at ratio 1/1 to produce powder coating with 60º gloss between25-30%. The coating shows very good mechanical properties and weathering resistance that meet Qualicoat class 1 specifications.

Specification

Item	Limits
Acid value (mg KOH/g)	50 - 54
Viscosity @ 200 °C, (mPa.s)	4000 - 5200
Color, b value	Max 15

Other

Item	Typical value
Glass transition temperature (°C)	60

Storage conditions

The resin in its original unopened bags is stable for more than 1 year, stored in a dry place at temperature below 30°C. Avoid direct sunlight.

Delivery form

Granules. White opaque polyethylene bags of 25kg. One ton per pallet .

Starting Formulation

Component	Weight (g)	Weight (g)
GH-4411	582	---
GH-4412	---	558
XL-552	18	42
TiO_2	386	386
Flow agent	10	10
Benzoin	4	4

Application/Extrusion Conditions

Extrusion	
Extruder	Twin screw
Speed	250 rpm
1st Zone Temperature	100 °C
2nd Zone Temperature	120 °C
Application	
Application	70 micrometer film on 0.5 mm chromated Al panel
Spray Gun	Output voltage: 70 kV
Curing	10 min @ 180° C metal temperature

Coating Properties

Test Items	Result
Film thickness (microns)	60-80
Gloss @ 60° (%)	25-30
Cupping test (mm)	7
Direct impact (kg.cm)	80
Reverse impact (kg.cm)	80
Adhesion (grade)	0

System Properties

- Very good weathering resistance
- Very good mechanical properties
- Gas-oven resistance
- Good flow

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