

EP-1604

Version: Aug 30,2017

**POWDER COATING
RESINS**

HYBRID

PE : HARDENER = 60 : 40

Description

EP-1604 is a saturated carboxylated polyester resin designed for 60/40 hybrid powders to be cured at 200°C. Coatings based on EP-1604 combine excellent flow and flexibility, the filler can be more added in the recipe.

Specification

Item	Limits
Acid value (mg KOH/g)	50 - 56
Viscosity @ 175 °C, (mPa.s)	7500 - 9500
Color, b value	Max 15

Other

Item	Typical value
Glass transition temperature (°C)	50

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)
EP-1604	360
Epoxy resin	240
TiO ₂	386
Flow agent	10
Benzoin	4
EP-7109	2.0

Application/Extrusion Conditions

Extrusion	
Extruder	Twin screw
Speed	250 rpm
1 st Zone Temperature	95 °C
2 nd Zone Temperature	105 °C
Application	
Application	70 micrometer film on 0.5 mm steel panel
Spray Gun	Output voltage: 70 kV
Curing	10 min @ 200° C metal temperature

Coating Properties

Test Items	Result
Film thickness (microns)	60-80
Gloss @ 60° (%)	94
Cupping test (mm)	8
Direct impact (kg.cm)	160
Reverse impact (kg.cm)	160
Adhesion (grade)	0

System Properties

- ❖ High gloss
- ❖ Excellent flow
- ❖ Good flexibility

ZHEJIANG GUANGHUA TECHNOLOGY CO., LTD www.khua.com	Customer Service	Technical Service
	Tel. 86-573-87771555 Fax 86-573-87771222	Tel. 86-573-87771188 Fax 86-573-87771222

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