

# LongCester® P 3504

Saturated carboxylated polyester resin

## General Description

LongCester® P 3504 is a fast reactivity polyester resin, designed for 50:50 hybrid powder coatings. Coatings based on it exhibit:

- Good flow
- Fast cure
- Good mechanical performance

## Extrusion & Application Conditions

Extruder:	Lingyu SLJ-25
Zone I temp.:	85~105 C
Zone II temp.:	90~110 C
Screw speed:	300~400rpm
Panel:	0.5mm pre-treated cold-rolled steel
Spray gun:	Lingyu SJ-05
Voltage:	60~90kV
Curing cycles:	10 min. @ 180 C

## Packaging

- White PE bag, N.W.25kg/bag, 1000kg/pallet.
- Big bags 750 kg.

## Storage

The product can be stably stored for at least one year when kept in closed containers in a dry place at temperature below 30 C . Avoid exposure to direct sunlight.

## Product Specifications

Property	Range	Test Method
Appearance	Clear granules	Visual
Acid value, mgKOH/g	58~65	ASTM D1639
Viscosity @ 200 C , Pa.S	20~30	ASTM D4287
Gardner Color(50% solution)	max.10	ASTM D1544

## Other Data

Property	Range	Test Method
Glass transition temp., C	approx. 56	DSC

## Starting Formulation

Component	Weight
LongCester® P 3504	300.0
LC-603H	300.0
Titanium dioxide	300.0
LC-88	1.5
Benzoin	3.0
CaCO3 filler	95.5

## Film Properties

Item	Result	Test Method
Film thickness, μm	approx. 70	ASTM D1186
Gloss @ 60°, %	92 unit	ASTM D523
Direct/reverse impact, inch lbs	80/80	ASTM D2794
1/8" Conical mandrel	pass	ASTM D522
Adhesion(cross cut)	5B	ASTM D3359
Pencil hardness (Mar)	H	ISO 15184-98

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