

### General Description

- 60:40 indoor polyester type, for hybrid purposes.
- Excellent flow
  - Medium cure
  - High gloss surface
  - Very good mechanical performance

### Extrusion & Application Conditions

|                |                                      |
|----------------|--------------------------------------|
| Extruder:      | Lingyu SLJ-25                        |
| Zone I temp.:  | 85~105 °C                            |
| Zone II temp.: | 90~110 °C                            |
| Screw speed:   | 400~500rpm                           |
| Panel:         | 0.5mm pre-treated cold-rolled steel  |
| Spray gun:     | Lingyu SJ-5                          |
| Voltage:       | 60~90kV                              |
| Curing cycles: | 10 min. @ 180 °C<br>15 min. @ 160 °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 granule   | Visual      |
| Viscosity  | 2000~4000 mpa.s | ASTM D4287  |
| Acid value | 48~55 mg KOH/g  | ASTM D1639  |
| Color      | Max 5           | ASTM D1544  |
| Tg         | appr.58         | DSC         |

### Starting Formulation

| Component        | Weight |
|------------------|--------|
| P 3407           | 360.0  |
| LC-604E          | 240.0  |
| Titanium dioxide | 300.0  |
| LC-88 Flow agent | 9.0    |
| Benzoin          | 4.5    |

### Film Properties

| Item                            | Result     | Test Method |
|---------------------------------|------------|-------------|
| Film thickness, μm              | approx. 60 | ASTM D1186  |
| Gloss @ 60°, %                  | 92 unit    | ASTM D523   |
| Direct/reverse impact, inch lbs | 160/160    | ASTM D2794  |
| 1/8" Conical mandrel            | pass       | ASTM D522   |
| Adhesion(cross cut)             | 5B         | ASTM D3359  |
| Pencil hardness                 | H          | ASTM D3363  |

Yantai Longcai Advanced Materials Co., Ltd

No.18 Hangzhou Road., Haiyang Development Zone, Yantai, China  
Post code: 265100

Tel.: +86 535-330 6639

Web-site: [www.longcester.com](http://www.longcester.com)

Fax: +86 535-330 6828

E-mail: [info@longcester.com](mailto:info@longcester.com)

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