

Saturated, carboxylated polyester resin

**General Description**

70:30 indoor polyester type, for hybrid purposes cure with 200C X 10 min.

Flow and mechanical performance balance

Medium cure.

High gloss surface

Economic type

**Starting Formulation**

| Component                      | Weight |
|--------------------------------|--------|
| P 3321                         | 70.0   |
| LC-603H                        | 30.0   |
| Titanium dioxide <sup>2)</sup> | 50.0   |
| LC-88 Flow agent <sup>3)</sup> | 1.5    |
| Benzoin                        | 0.5    |

**Product Specifications**

| Property   | Range          | Test Method |
|------------|----------------|-------------|
| Appearance | clear granule  | Visual      |
| Viscosity  | 30~40 pa.s     | ASTM D-4287 |
| Acid value | 30~35 mg KOH/g | ASTM D-1639 |
| Color      | Max 5          | ASTM D-1544 |
| Tg         | appr. 60       | DSC         |

**Extrusion & Application Conditions**

Extruder: Lingyu SLJ-20

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 JP-80

Voltage: 60~90kV

Curing cycles: 10 min. @ 200°C

**Packaging**

• White PE bag, N.W.25kg/bag, 1000kg/pallet.

**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.

**Film Properties**

| Item                            | Result     | Test Method  |
|---------------------------------|------------|--------------|
| Film thickness, µm              | approx. 60 | ASTM D1186   |
| Gloss @ 60°, %                  | 92 unit    | ASTM D523    |
| Direct/reverse impact, inch lbs | 20/20      | 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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