M2309 Technical data sheet

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<th>Outdoor</th>
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### Resin

**Description**

M2309 is a kind of saturated carboxyl polyester resin mixed with TGIC in 93/7 for exterior environment polyester powder coatings.

**Properties**

- High gloss
- Good flow
- Good mechanical properties
- Perfect anti-yellowing
- Good storage stability

**Spec.**

- Appearance: Chip Solid
- Color(50%DMF)max: 3
- Acid value(mgKOH/g): 30-36
- ICI Viscosity(175 °C)Po: 15000-19000
- Softening Point(ball) °C: 100-120
- Tg (°C): ~63

**Package**

25kgs net in bag

**Storage**

One year in dry and well-ventilated condition below 30°C. If exceed shelf life, please check again. It can be used if inspection result is ok.

### Powder

**Recipe**

- M2309 600g
- TGIC 46g
- TiO2 350g
- Flow Agent M99 8g
- Benzoin 5g

**Process**

- Extruder: BUSS PLK 46
- Casting setting tem: 110-120°C
- Kneading screw tem: 60°C
- R.P.m: 60rpm
- Particle size(μm): Max100
- Curing Condition: 180°C×15min(MT)

**Finishing**

- Spraying tension KV: 50
- Degreased and stainless cold-rolled steel(mm): 0.5mm

**Film pro.**

- Thickness μm: 60 ± 10
- Gloss(60°)%: Min.90
- Adhesion(2mm): 0-1
- Bending(mm): Max.4
- Erichsen(mm): Min.7
- Impact(Kg.cm): 50
- Hardness (pencil) H: 1H

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