# M2310

## Technical data sheet

<table>
<thead>
<tr>
<th>Application</th>
<th>Outdoor</th>
<th>System</th>
<th>TGIC</th>
<th>Ratio</th>
</tr>
</thead>
<tbody>
<tr>
<td>M2310 is a carboxylated polyester resin for outdoor use</td>
<td></td>
<td></td>
<td></td>
<td>93:7</td>
</tr>
</tbody>
</table>

### Resin

**Description**
M2310 is applied in Alu-profile and metal-fixure

**Properties**
- Be suitable for tribo gun
- Good flexibility
- Outstanding flow
- Rich film appearance
- Excellent mechanical properties
- Excellent overbaking resistance
- Good storage stability

**Spec.**
- Appearance: Pale granules
- Acid value: 30-36 mgKOH/g
- Viscosity-175 °C: 15000-19000 mPa-s
- Color, b value: max 10
- Tg: Approx. 63 °C

### Powder

**Recipe**
- M2311: 558 g
- TGIC: 42 g
- TiO2: 386 g
- Levelling agent M99: 10 g
- Benzoin: 4 g

**Process**
- Extruder: Twin screw
- Barrel temperature: 95-105 °C
- Torque: 70-80 %
- Speed: 250 rpm
- Sieving: 180 mesh
- Curing-metal temp.: 200 °C × 10 min

**Finishing**
- Voltage: 60-90 KV
- Degreased steel: 0.5 mm
- Film thickness: 55-75 μm
- Gloss 60°: ≥90 %
- Adhesion: GT0
- Bending: ≤2 mm
- Cupping test: >8 mm
- Reverse impact: 50 Kg.cm
- Pencil hardness: F-1H

### Package
- White opaque polyethylene bags of 25kg

### Storage
- The shelf life of the resin will be one year
- Stored in a dry place at temperature below 30 °C
- Avoid direct sunlight