## M2311 Technical data sheet

<table>
<thead>
<tr>
<th>Application</th>
<th>Outdoor</th>
<th>System</th>
<th>TGIC</th>
<th>Ratio</th>
</tr>
</thead>
</table>

### Resin

**Description**: M2311 is a carboxylated polyester resin for outdoor use.

M2311 is applied in Alu-profile and metal-fixture.

**Properties**
- Excellent outdoor durability
- 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-200 °C: 4800 mPa-s
- Color, b value: max 10
- Tg: Approx. 67°C

**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

### Powder

<table>
<thead>
<tr>
<th>Recipe</th>
<th>Powder</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>M2311</strong></td>
<td>558 g</td>
</tr>
<tr>
<td><strong>TGIC</strong></td>
<td>42 g</td>
</tr>
<tr>
<td><strong>TiO2</strong></td>
<td>386 g</td>
</tr>
<tr>
<td>Levelling agent M99</td>
<td>10 g</td>
</tr>
<tr>
<td>Benzoin</td>
<td>4 g</td>
</tr>
</tbody>
</table>

**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