# M2312 Technical data sheet

<table>
<thead>
<tr>
<th>Application</th>
<th>Outdoor System</th>
<th>TGIC Ratio</th>
<th>93:7</th>
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</thead>
</table>

## Resin

**Description**
M2312 is a carboxylated polyester resin for outdoor use

M2312 is applied in Alu-profile and metal-fixture

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

**Spec.**
- Appearance: Pale granules
- Acid value: 30-36 mgKOH/g
- Viscosity-200 °C: 4600 mPa-s
- Color, b value: max 10
- Tg: Approx. 67 °C

## Powder

**Recipe**
- M2312: 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

**Finishing**
- Curing-metal temp.: 200 °C x 10 min
- 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