



Polyester Resin HH-2683

◇ Applications:

HH2683 is a carboxyl polyester resin designed for 60/40 hybrid powder coatings for general purpose.

◇ Basic features:

- Good flow
- Good mechanical properties
- Excellent chemical resistance
- Excellent over baking resistance

◇ Specifications:

Appearance	pale yellow flake
Color(50%DMF):	max:3
Acid number(mgKOH/g)	47~54
Softening point(°C)	97~107
Glass transition temp.(°C)	~52
Melting viscosity(200°C, cone/plate, mPa·s):	2800~4500
Reactivity at 180°C(s, 40% Epoxy):	150±35

◇ Recommend Formulation:

HH2683—E12

HH2683	E12	Filler & pigment	Leveling agent	Benzoin
360	240	384	7	3

◇ Extrusion Condition:

- Two-screw extruder
- Zone I: 90~110°C Zone II: 110~120°C
- Speed of revolution: 500~1200rpm
- Fineness of powder: <100 μ m

◇ Application Condition:

- Electrostatic spraying with: 40~70KV
- Coating film thickness: 50~100 μ m
- Degreased cold-rolled steel 0.5mm

◇ Curing Requirement: 180°C×15min or 200°C×10min

◇ Film Properties:

Gel time(180°C,s)	160~220
Gloss (60°):	≥90%
Bending (φ 1mm):	pass
Adhesion (1mm,grade):	0
Pencil hardness:	≥1H
Impact (direct):	pass 50kg·cm
Storage test (40°C, 24hr):	good