Longcester®

Longcester® P 3310-1

Saturated, carboxylated polyester resin

Product Data Sheet

General Description

P 3310-1 is a high reactivity polyester resin, designed
for 70:30 hybrid powder coatings. Coatings based on it exhibit:

· Good flow

· Outstanding mechanical properties

· Good yellowing resistance

Extrusion & Application Conditions

Extruder:	Lingyu SLJ-25
Zone I temp.:	85~105℃
Zone II temp.:	100~120℃
Screw speed:	400~500rpm
Panel:	0.5mm pre-treated cold-rolled steel
Spray gun:	Lingyu SJ-5
Voltage:	60~90kV
Curing cycles:	10 min. @ 180℃

Packaging

· White PE bag, N.W.25kg/bag, 1000kg/pallet.
· Big bags 750 kg.

Storage

The product can be stably stored for at least one year when kept
in closed containers in a dry place at temperature below 30℃.
Avoid exposure to direct sunlight.

Product Specifications

Property	Range	Test Method
Appearance	Pale granules	Visual
Acid value	28-38 mgKOH/g	ASTM D1639
Viscosity	5000~6000 mPa.s	ASTM D4287
Color	max.3	ASTM D1544
Tg	appr. 57	DSC

Starting Formulation

Component	Weight
P 3310-1	210.0
Epoxy Resin	90.0
Barium sulfate	60.0
Titanium dioxide	90.0
LC-88 Flow agent	5.0
Benzoin	3.0

Film Properties

Item	Result	Test Method
Film thickness, µm	approx. 60	ASTM D1186
Gloss @ 60°, %	min. 90	ASTM D523
Direct/reverse impact, inch lbs	160/160	ASTM D2794
1/8" Conical mandrel	pass	ASTM D522
Adhesion(cross cut)	5B	ASTM D3359
Pencil hardness	H	ASTM D3363