



**Technical Leaflet** 

# WorléeAdd 915

Art.-No. 114501-00840

Revision: 07.06.2019

WorléeAdd 915 is a powder coating additive capable of improving mechanical properties of powder coatings and their surface appearance.

It can be formulated into powder coating compositions primarily based on acrylics and polyester / GMA 300 hybrids.

### Technical Data:

| Appearance           | white powder |
|----------------------|--------------|
| Non volatile content | min. 98%     |
| Activity             | 80 - 85%     |

## **Application and Properties:**

WorléeAdd 915 is a free flowing powder which is convenient in handling, easy to disperse and reliable in performance. For best results WorléeAdd 915 should be pre-blended with other coating ingredients in a high-intensity mixer, then homogenized in an extruder.

WorléeAdd 915 should be used at concentrations of 1.5 - 2.5% based on the resin used.

For each new formulation an individual laboratory test is required to determine the optimum concentration of the additive.

WorléeAdd 915 is especially developed for WorléeCryl CP 550 or GMA-300 based powder coatings.

WorléeAdd 915 should always be used in combination with Resiflow PV 88 or an equivalent flow control agent.

Weight %

### Suggested powder coating formulation

| 0    |
|------|
|      |
| 66.0 |
| 12.6 |
| 19.1 |
| 0.6  |
| 1.7  |
|      |

Curing Schedule: 20 min. at 180 °C, or 10 min. at 200 °C.

The above declarations serve for information purposes only. In particular, they shall not be relevant to define binding specifications for any orders. With respect to any order, the specifications shall be governed by the provisions of the sales contract to be concluded between the parties (e.g. the "product specification").

Any deliveries are exclusively subject to our general standard terms and conditions in their respectively valid version. We will be happy to provide you with the general standard terms and conditions upon your request and they can be downloaded online at http://www.worlee.de/GSTC Worlée-Chemie GmbH • Grusonstrasse 26 • D-22113 Hamburg • Tel.: +49 4153 596-0 • Fax: +49 4153 536 49 • E-Mail: service@worlee.de • www.worlee.de





#### WorléeAdd 915

# Suggested formulation for a Polyester-Acrylic Hybrid Powder Coating

|  | Α  |                                   | В                        |  |  |
|--|--|-----------------------------------|--------------------------|--|--|
| Polyester (acid value 30-36)<br>W´Cryl CP 550<br>Titanium Dioxide<br>Resiflow PV 88<br>W´Add 915 | 57.4<br>20.1<br>20.2<br>0.6<br><u>1.7</u><br>100.0 | 20.1<br>20.2<br>0.6<br><u>1.7</u> |                          | 56.3<br>19.8<br>19.8<br>0.6<br><u>3.5</u><br>100.0 |  |
| Cure Temperature<br>Cure Time  | 180 °C<br>20 min                                   | 200 °C<br>10 min                  | 150 °C<br>30 min         | 200 °C<br>10 min                                   |  |
| 60° gloss<br>Impact (kg/cm)<br>direct<br>reverse<br>MEK Rubs                                     | 10<br>160<br>160<br>50 +                           | 9<br>160<br>160<br>50 +           | 46<br>160<br>160<br>50 + | 41<br>160<br>160<br>50 +                           |  |

2

### Shelf Life:

The storage stability of WorléeAdd 915 in the originally closed barrel is at a storage temperature from + 5 to + 25 °C six months, counted from the day of the delivery ex works.

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