

Technical Leaflet

WorléeAdd 915

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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.

Suggested powder coating formulation

	Weight %
W'Cryl CP 550	66.0
Dodecanedioic acid	12.6
Titanium Dioxide	19.1
Resiflow PV 88	0.6
W'Add 915	1.7

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

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Suggested formulation for a Polyester-Acrylic Hybrid Powder Coating

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

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.