

## Technical Leaflet

# Resiflow P-64F

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Resiflow P-64F is an acrylic flow control agent designed for powder coating systems. It is based on a liquid polymer which has been converted into free-flowing powder by absorption onto a specific silica filler.

Resiflow P-64F has been specifically designed to provide outstanding clarity in clear acrylic powder coatings. If applied at effective concentrations, it will correct surface imperfections and provide a smooth film with high distinctiveness of image (DOI).

### Technical Data:

Appearance	white powder
Activity	min. 65%

### Application and properties:

Resiflow P-64F is used to improve flow and eliminate air entrapment, orange peel, pinholes, craters, and other surface defects.

For an optimally performing system, it is recommended that Resiflow P-64F should be used in conjunction with Isocryl EP-450 epoxy functional acrylic resin.

The recommended concentration of Resiflow P-64F is between 0.7 - 3.0% calculated on total formulation weight. The method of incorporating Resiflow P-64F into coating formulation does not affect the performance of the coating as long as it is uniformly dispersed in the system. This can be achieved by thoroughly mixing Resiflow P-64F with the other paint ingredients prior to extruding the powder coating formulation

### Suggested formulation for a powder acrylic clear coat

	Weight %
Isocryl EP-450	76.5
Dodecanedioic Acid	21.5
Resiflow P-64F	1.0
Benzoin	1.0



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Extrusion conditions

Zone 1 - 90 °C

Zone 2 - 95 °C

Screw - 150 rpm, double extrusion

\* This formulation is an example based on experimental data acquired on a 25 mm single screw extruder. Processing conditions and formulation concentrations may need optimisation to meet the individual customer's requirements.