

## Exterior can coating, solvent-based

### Application

Clear, exterior metal packaging coating based on benzoguanamine crosslinkers, with excellent flexibility and chemical resistance. Free of Bisphenol A, very low free formaldehyde content.

Components	Solid content [%]	Amount [g]
Dynapol LH 818-05 <sup>(1)</sup>	50	60.6
Resimene CE 8824 ULF <sup>(2)</sup>	98	9.0
Maprenal BF 892 ULF <sup>(2)</sup>	70	6.1
Nacure 5925 <sup>(3)</sup>	25	0.2
CAB 551-02 <sup>(4)</sup> , solution 20% in BGDA	20	1.4
Butyldiglycol		9.2
Butyldiglycolacetate		3.0
Solvent Naphtha 150		10.5
Total		100.0
Theoretical solids (%)		43.0
Ratio Polyester Resin / Crosslinker (solid resins)		70 : 30
Catalyst concentration (as supplied on solid binder resins, %)		0.46
Viscosity (23 °C, DIN 53211 4 mm cup, sec)		80

(1) [www.evonik.com](http://www.evonik.com) (2) [www.prefere.com](http://www.prefere.com) (3) [www.kingindustries.com](http://www.kingindustries.com)

(4) [www.eastman.com](http://www.eastman.com)

### Manufacturing Procedure

While stirring, mix all raw materials in the order indicated until homogeneous.

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Coating Application	
Substrate	Tinplate E1 (2.8 / 2.8), 0.25 mm
Wet film application (spiral doctor blade)	50 µm
Dry film thickness	7 µm
Curing conditions	8 min 23 °C, 10 min 200 °C

Film Properties	
Crosshatch adhesion (DIN EN ISO 2409)	gt 0
Erichsen cupping	> 9 mm
Wedge bend test	< 40 mm
MEK double rub test (1 kg)	> 100
Sterilization 90 min 119 °C:	<i>(blush / roughness / adhesion)*</i>
3% sodium chloride	0 / R0 / gt 1
3% acetic acid	0 / R1 / gt 1
3% lactic acid	2 / R1 / gt 4

\*Evaluation scale:   blush: 0 = best, 5 = worst  
                           roughness: R0 = best, R3 = worst  
                           adhesion: 0 = best, 5 = worst

### Handling and safety requirements

Detailed information is available in the safety data sheets of the individual raw materials.

### Common indications

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