

# Phenoxy PKHM-301

## USE

Gabriel Phenoxy PK™HM-301 is a solid-grade phenoxy PKHC resin melt blended with an oligomeric polyester polyol containing primary hydroxyl functional groups. Phenoxy resins (polyhydroxyethers) are tough, ductile, amorphous, thermoplastic polymers having excellent thermal stability, adhesive strength, and vapor barrier properties. Phenoxy resins may be crosslinked by reacting its hydroxyl functional groups with isocyanates, melamine resins, or phenolic resins. Crosslinked phenoxy resins exhibit excellent chemical resistance, hardness, and adhesion on many substrates including steel, aluminum, glass, and carbon fibers, and plastics such as nylon and polyester (PET).

PKHM-301 provides for improved reactivity due to the presence of primary hydroxyls and the lower glass transition temperature of the alloy. PKHM-301 has a glass transition temperature of about 35 °C which imparts improved solids/viscosity ratios in common solvents like MEK. Coatings of PKHM-301 exhibit high levels of flexibility and formability when appropriately cured.

## TYPICAL APPLICATIONS

- Thermoset Coatings
- Adhesives/Sealants
- Can and Coil Coatings
- Flexible and Rigid Packaging

## TYPICAL PROPERTIES

Solids, %.....	99
Viscosity, cP Brookfield, @ 25 °C; (20% solution in cyclohexanone) .....	100 – 300
Molecular Weight (Weight Average, Daltons) .....	39,000
Color (APHA); (20% solution in cyclohexanone, max.) .....	200
OH Equivalent Weight (g/equiv.).....	334

## Phenoxy PKHM-301 (cont.)

### REGULATORY STATUS

TSCA (USA), DSL (Canada), PICCS (Philippines), AICS (Australia), ENCS/MITI (Japan), IECSC (China).

Polymer Exempt: EINECS (EU)

### PACKAGING, STORAGE AND HANDLING

Gabriel Phenoxy PK™HM-301 is sold as pellet form in 55 pound (25 KG) net weight lined fiber containers. The pellets should be stored at temperatures below 60 °F (16 °C) to avoid blocking. Even if “blocking” occurs, the resin is usable (must be broken apart) if stored in unopened containers.

Phenoxy PKHM-301 meets USFDA requirements for use in food contact and packaging applications (21 CFR 175.300).

Consult the product SDS for additional information on properties, hazards, and handling.

### MANUFACTURING LOCATION

Rock Hill, South Carolina or Ashtabula, Ohio, USA.

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