



Baking Enamel

Fast curing baking finish

2000 - line

Description

- General purpose baking enamel for steel fabrications

Properties

- Fast cure
- Tough cross-linked coating
- Three gloss levels
- Extensive colour library and easy colour matching with Coloryte® Industrial Tint System

Typical Applications

- Steel fabrications (appliances, office equipment, signs, light fittings, etc.)

General Data

- Weather resistance Generally good; chalking may occur with lengthy exterior exposure, but film integrity should not be affected
- Solvent resistance Resists splashes of most common solvents; not recommended for continuous immersion
- Chemical resistance Good to mild chemicals
- Abrasion resistance Good
- Recommended primers Rhinogrip Etch Primer, or may be applied directly to bare metal

Specifications (at 25°C and 50% relative humidity)

- Resin type.....Alkyd / aminoplast
- Typical solids content.....36% (by volume)
- Typical film thickness (per coat)..... 25 microns (dry)
75 microns (wet)
- Theoretical coverage.....15m² / L @ 25 microns dry film thickness (dependant on colour)
- Baking..... 20 min. @ 150°C
30 min. @ 120°C
- Gloss.....Gloss, Satin, Matt
- Colours..... Full range (refer to Properties)
- Shelf life.....minimum 12 months (in cool, dry conditions)

Surface Preparation

- Bare steel surfaces should have rust and scale removed with abrasive paper or wire brush
- Wipe with clean solvent and rags to remove grease and any other residues

Mixing recommendation

- Mix the entire contents of the can before decanting
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even consistency of the product
- Thin up to 20% by volume with Wagon Paints' T9 Universal Thinner or T4 Enamel Thinner and stir as above
- Thin with T19 Electrostatic No. 2 Thinner for application by electrostatic spray

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Application

- May be spray applied using airless or conventional air spray equipment
- **Airless Spray** nozzle size.....0.33 – 0.38 mm
nozzle pressure..... 2000 – 2500 psi (14 - 17mPa)
volume of thinner.....up to 10%
- **Air Spray** nozzle size.....1.6 – 2.0 mm
nozzle pressure..... 45 – 60 psi (300 - 400kPa)
volume of thinner.....10 – 20%
- **Cleaning solvent**T4 Enamel Thinner or T9 Universal Thinner

Safety precautions

- **Refer to the relevant Material Safety Data Sheet**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group II **UN No. 1263**

Pack sizes 4 litre, 20 litre

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These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



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