

Product Description: Modified Polyester Baking Enamel System

PRODUCT CODES: IS-0010 – Clear | IS-1011 – White | IS-1012 – Deep | IS-2010 – Metallic
IS-3010 – Yellow | IS-5010 – Red

DESCRIPTION: This Modified Polyester Baking Enamel is a versatile, low temperature curing industrial finishing enamel for manufacturers of metal products. This baking system can offer regulatory compliance, excellent color and gloss retention, along with a broad curing curve. This coating system is ideal for industrial OEM uses, including agricultural and construction equipment.

PHYSICAL PROPERTIES:

Weight Solids: 56% to 65%
Volume Solids: 48% to 54%
Resin Type: Modified Polyester
Gloss: 90+ at 60°
Theoretical Coverage: 770 to 860 square feet at 1.0 mil
Weight Per Gallon: 8.5 to 10.0 pounds
Viscosity: #2 Zahn – 40 to 60 seconds at 77°F
EPA VOC: 3.5 pounds per gallon

SURFACE PREPARATION: The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits. Bake Modified Polyester Baking Enamel may be applied over a monobaking primer and other properly prepared substrates. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils and then coated before flash rusting occurs.

Steel: Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.
Aluminum/Galvanized: Aluminum and galvanized should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer or acrylic latex primer.

APPLICATION: Modified Polyester Baking Enamel may be used for one-coat, direct to metal applications; however a primer will be required for long term corrosion protection. Sag resistance will be approximately 3.0 to 4.0 mils wet.

Airless: For airless or air-assist airless application, apply without reduction. Airless tip sizes should be in the .011 to .015 range, with fluid pressures at 900 to 1000 pounds.

Conventional Air: For air spray or conventional reduce approximately 5% with Butyl Acetate by volume. Viscosity should be in the 18 to 23 second range with a #2 Zahn cup.

Dry Film Thickness: Dry Film thicknesses required are 1.0 to 2.0 mils above primer in a minimum of one or two wet coats.

DRY TIMES:

Bake Schedule: High solids polyester bake enamels can be cured from a range of 250°F to 325°F. Typical schedules would be from 20 minutes at 250°F to 8 minutes at 325°F. Full hardness and mar resistance is obtained after 24 hours.

CLEAN UP: Use xylol or butyl acetate to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.

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PERFORMANCE: Typical, tested on B-1000 panels at 1.0 to 1.5 mils DFT. (White and Black, other colors must be verified)

Iowa Exposure: After one year facing south at a 60° angle – less than 5% loss of gloss at 60°

Florida Exposure: After one year facing south at a 60° angle – approximately 10% loss of gloss at 60°

Salt Spray: ASTM B-117 – 300 hours – Pass

SAFETY PRECAUTIONS: Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice.