

Baking Enamel

General Properties

A heat-convertible coating that cures to a hard, durable, mar and abrasion resistant film. Suitable for interior or limited exterior applications. Available in stock and custom colors and finishes.

Recommended Uses

Production line finishes for shelving, racking, cabinets, furniture and metal containers.

Product Information

GENERIC TYPE	Alkyd/Melamine
PIGMENT TYPE	Heat-resistant Pigments
COLOR	White, Factory-Mixed and Custom Colors
BASES	73003 White, 73002 Deep, 73001 Clear
FINISH	Semi Gloss
AVERAGE VOLUME SOLIDS	34%
AVERAGE WEIGHT SOLIDS	48%

RECOMMENDED FILM THICKNESS	Wet: 3 - 4.5 mils Dry: 1 - 1.5 Mils See your Cloverdale Representative for project recommendations.
THEORETICAL COVERAGE	545 ft ² /gal @1 mil (25 microns) DFT 13.3 m ² /L @ 1 mil (25 microns) DFT Actual coverage may vary depending on substrate and application methods.
VISCOSITY	45" - 55" #4 Ford Cup
TEMPERATURE RESISTANCE (DRY)	93°C (200°F) Continuous 120°C (250°F) Intermittent
V.O.C. AS APPLIED	539 g/L (4.48 lbs/gal)
THINNER	78011 Xylene

Methods of Application

AIRLESS SPRAY	Speeflo Atlas 30:1 with tip sizes .013" - .015" or equivalent
H.V.L.P.	Binks Model Mach 1 94 x 97AP (pressure) or equivalent
CONVENTIONAL	Binks Model 95GUN 63CSS x 63PB (pressure) or equivalent
BRUSH / ROLLER	Brushing is limited to small areas or touch-up

Baking Schedule - Recommended flash-off time 5 minutes @ 25°C (77°F)

130°C (266°F)	150°C (302°F)	170°C (338°F)
20 minutes	15 minutes	8 minutes

Recommended Primer

STEEL	Self Priming
CONCRETE	Not Recommended
GALVANIZED	Not Recommended
ALUMINUM	Not Recommended

Surface Preparation

Surfaces must be clean, dry and free of all surface contamination. A minimum 3-stage phosphate wash is recommended on ferrous metals: see your Cloverdale Paint Representative.

Limitations

Not for exterior exposure. An anti-corrosive primer is recommended for corrosive environments.

Mixing Instructions

Mix well before using.

Safety Precautions

This product is for industrial use only. **Refer to Material Safety Data Sheet for proper health and safety information.**

Storage and Handling

FLASH POINT	-7°C (19°F) TCC
PRODUCT WEIGHT	8.86 lbs/gal (container extra)
STORAGE	Cool, dry, secure location. See your Cloverdale Paint Representative.
PACKAGE SIZE	1 gallon, 5 gallon pail, 55 gallon drum

Some package sizes or colors may be by special order only. Please check with your Cloverdale Representative when ordering.

Warranty Disclaimer

Cloverdale Paint manufactures quality products. In the event that this product is defective or in any way unsuitable for the application for which it is sold, Cloverdale Paint Inc. will replace the product free of charge. The warranty provided by this data sheet is the only warranty or guarantee of quality made in respect of this product by Cloverdale Paint Inc. By purchasing this product the customer accepts this warranty in lieu of all others, and waives all claims to any other remedy arising from any warranty or guarantee of quality, whether such warranty or guarantee of quality was made expressly to the customer or implied by any applicable law.

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**Cloverdale Paint Inc.**

6950 King George Highway, Surrey, British Columbia, Canada V3W 4Z1
Web Site: www.cloverdalepaint.com Email: helpdesk@cloverdalepaint.com
Phone: 604 596 6261 Fax: 604 597 2677