



WE-2722-07 W/R HAPS Free Gloss Black Bake

Description:

Gloss black waterborne, HAPS free, bake enamel formulated to provide a protective coating for metal stamping.

Reduction Rate/Mix Ratio:

Reduce to 17"-18" #2 Zahn for dip application. Typical mix ratio is 7 parts paint to 3 part water by volume

Product Information:

Color: Black

Weight Per Gallon: 8.70±0.15

Solids By Weight: 40.37±1 %

Solids by Volume: 36.06±1 %

VOC: 1.69 MAX Lb/Gal

VOC Note: 201 MAX grams/liter, <0.28 kg/liter of solids applied

Gloss: 80+ / 60 ° meter

Viscosity: 58-65 KU as supplied

pH Level: 8.2-8.6

Pot Life: n/a

Recommended Application:

Reduce to 17"-18" #2 Zahn for dip application. Check product periodically for viscosity.

Clean Up Solvent(s):

water

Curing Schedule: 77° F, 50% R. H. (Air Dry)

Air Dry, Tack Free: n/a

Dry Through: n/a

Bake, Flash Time: n/a

Bake Temp: 600°F

Dwell Time: 50"-60"

PMT: 420°F

Theoretical Coverage @ 1.0 Mil: 578 sq. ft. / gallon

Recommended Dry Film Thickness:

0.2-0.3 mils

Performance:

Adhesion: n/a

Durability: n/a

Flexibility: n/a

Hardness: H pencil, ASTM D 3363*

Impact: n/a

MEK Rubs: Passes 50 DR MEK, ASM D 5402*

Salt Spray: n/a

Other: *As run on product applied full body to S-412 Q-Panel and baked as indicated above.

Date: 09/03/09

Supersedes:

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