



**SHERWIN  
WILLIAMS.**

# Chemical Coatings

CC-B9

## Production Baking Enamel

Gloss Black ..... F73B10  
 Metallic Silver ..... F73S19  
 Blending White ..... F73W100  
 Blending Clear.....F73V101

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p><b>Production Baking Enamel</b> is a full gloss, alkyd-amino baking enamel. Ideal for use on a wide range of metal products for both interior and exterior applications.</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Hard, tough, mar resistant finish</li> <li>• Good exterior durability</li> <li>• Good one coat protection</li> <li>• Good flexibility</li> <li>• High gloss. Lower glosses are available by using Gloss Modifier, D64F100</li> <li>• Available in a broad range of colors</li> <li>• Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16 CFR Chapter II: Subchapter B, part 1303.</li> </ul>	<p><b>Gloss:</b> Full, may be adjusted</p> <p><b>Volume Solids:</b> 35-43% varies by color</p> <p><b>Viscosity:</b> 32-65 seconds #2 Zahn Cup 27-45 seconds #4 Ford Cup</p> <p><b>Recommended film thickness:</b> Mils Wet 2.5 - 3.5 Mils Dry 1.0 - 1.25</p> <p><b>Spreading Rate</b> (no application loss) 449-690 sq ft/gal @ 1.0-1.35 mils DFT</p> <p><b>Baking Schedule:</b> Flash off time 5 minutes then bake 15 minutes at 300°F or 10 minutes at 325°F</p> <p><b>Flash Point:</b> 35-45°F Pinsky- Martens Closed Cup</p> <p>To ensure proper cure, peak metal temperature must reach 300°F. Heavy gauge metal may require higher temperatures or longer cure time.</p> <p><b>Package Life:</b> 1 year, unopened</p> <p><b>Air Quality Data:</b> Photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 4.25 lb/gal, 521 g/L reduced 15% with Xylol, maximum 4.78 lb/gal, 574 g/L HAPS maximum as packaged 1.93 lbs/gal of solids</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p><b>General:</b> Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.</p> <p><b>Aluminum:</b> A minimum of a five-stage chrome phosphate metal treatment, or equivalent, is required for good adhesion and optimum coating performance properties.</p> <p><b>Steel or Iron:</b> Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection and adhesion.</p> <p><b>Testing:</b> Due to the wide variety of substrates, surface preparation methods, and application methods and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p>

## APPLICATION

### Typical Setup

#### **Conventional Spray:**

Air Pressure .....36-60 psi  
Fluid Pressure .....15-25 psi  
Reducer ..... Xylol R2K4  
Reduction Rate ..... 15%

#### **Electrostatic Spray:**

Resistance ..... 0.3 - 1.0 megohms  
Reduction Rate ..... as needed  
Reducer for flow ..... Xylol R2K4  
Reduction Rate ..... 15%  
Further reduction may require the addition of polar solvents such as ketones or alcohols for proper conductivity.

#### **HVLP:**

Air Pressure .....40-60 psi  
Fluid Pressure ..... 10-15  
Reducer ..... Xylol R2K4  
Reduction Rate ..... 15%

#### **Cleanup:**

Clean tools/equipment immediately after use with n-butyl acetate, R6K18 as a HAPS compliant clean-up solvent, or Xylol, R2K4 for non-compliant clean-up.

Follow manufacturer's safety recommendations when using any solvent.

## SPECIFICATIONS

#### **Product Limitations:**

- Allow 5 minutes flash off for optimum flow and leveling.
- Maximum film build of 4.0 mils wet, 1.5 mils dft per coat.
- Not recommended for airless or air assisted airless application.
- Not recommended for use over untreated metal surfaces because of possible adhesion failure. Use zinc or iron phosphate on steel or Alodine treatment on aluminum.
- Due to wide variations in aluminum substrate and treatment, test adhesion before use.
- To ensure proper cure, peak metal temperature must reach 300°F. Heavy gauge metal may require higher temperatures or longer cure time.
- To ensure a smooth surface, use D64F100 to lower gloss down to 50 units.
- Blend custom colors using Phoenix™ Colorants
- Metallic Silver, F73S19, should be blended 1:1 (equal parts) with Blending Clear, F73V101, for a high gloss, bright metallic appearance.
- Gloss Black F73B10 is a stand alone color with better jetness. Do not use for blending.

#### **Performance Tests**

Substrate: 24 gauge Bonderite 1000 P-60 panels, baked 10 minutes at 325°F  
Finish: 1.0 - 1.2 @ mils dft

Pencil Hardness (minimum)  
ASTM D3363 ..... HB

1/4" Conical Mandrel ..... passes

Impact Resistance - Direct ..... 30 in/lbs

Impact Resistance - Reverse ..... 30 in/lbs

Taber Abrasion, CS-10 Wheel, 100g Load  
500 cycles ..... <100mg loss

## CAUTIONS

#### **FOR INDUSTRIAL SHOP APPLICATION**

Thoroughly review product label and Material Safety Data Sheet (MSDS) for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

Please direct any questions or comments to your local Sherwin-Williams facility.

**Note:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.