



General Industrial Coatings

CC-B9

PRODUCTION BAKE ENAMEL

Gloss Black..... F73B10 Blending White F73W100
Blending Clear..... F73V101 Custom Blend Series F73XX

DESCRIPTION

Production Baking Enamel is a high gloss, alkyd-amino baking enamel. Ideal for use on a wide range of metal products for both interior and exterior applications.

Advantages:

- Hard, tough, mar resistant finish
- Good exterior durability
- Good one coat protection
- Good flexibility
- High gloss
- Lower glosses are available by using Gloss Modifier, D64F100
- Available in a broad range of colors

Special Order Only / Not Stocked:

Metallic Silver..... F73S19

CHARACTERISTICS

60° Gloss: 85+
May be adjusted

Volume Solids: 35-43 ± 1 %
Varies by color

Viscosity: 35-65 secs., #2 Zahn Cup
(at 77° F) 27-45 secs., #4 Ford Cup

Recommended Film Thickness:
Mils Wet 2.5-3.5
Mils Dry 1.0-1.35

Spreading Rate (no application loss):
410-690 ft.²/gal. at 1.0-1.35 mils DFT

Cure:
Force Dry 5 mins. flash, 15 mins. at 300° F
or 5 mins. flash, 10 mins. at 325° F

To ensure proper cure, peak metal temperature must reach 300° F. Heavy gauge metal may require higher temperatures or longer cure time.

Flash Point (varies by color): 35-45° F
(Pensky Martens Closed Cup)

Air Quality Data:
Photochemically Reactive
Volatile Organic Compounds (VOC), Less Exempts
As supplied 4.4 lb/gal, 520 g/L
Reduced 15 % (vol.) with R2K4 (Xylene) 4.8 lb/gal, 575 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life: 1 year, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

Aluminum: A minimum of a five-stage chrome phosphate metal treatment, or equivalent, is required for good adhesion and optimum coating performance properties.

Steel or Iron: 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.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

* VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

APPLICATION

Typical Setups

May be applied by: Conventional Spray
Electrostatic Spray
HVLP Spray

Conventional Spray:

Air Pressure 30-60 psi
Fluid Pressure 15-25 psi
Reducer R2K4, Xylene
Reduction Rate 15% (vol.)

Electrostatic Spray:

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

HVLP Spray:

Air Pressure 40-60 psi
Fluid Pressure 10-15 psi
Reducer R2K4, Xylene
Reduction Rate 15% (vol.)

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R2K4 (Xylene).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Allow 5 minutes flash off for optimum flow and leveling.
2. Maximum film build of 4.0 mils wet, 1.5 mils DFT per coat.
3. Not recommended for airless or air assisted airless application.
4. 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.
5. Due to wide variations in aluminum substrate and treatment, test adhesion before use.
6. To ensure proper cure, peak metal temperature must reach 300° F. Heavy gauge metal may require higher temperatures or longer cure time.
7. To ensure a smooth surface, use D64F100 to lower gloss down to 50 units.
8. Blend custom colors using Phoenix® Opticolor Express®, or GIS colorants.
9. Gloss Black F73B10 is a stand-alone color with better jetness. Do not use for blending.
10. Metallic Silver, F73S19, should be blended 1:1 (equal parts) with Blending Clear, F73V101, for a high gloss, bright metallic appearance.
11. The maximum colorant levels allowed are shown in the table below:

	Maximum Colorant Levels (ounces colorant per gallon paint)		
	GIS	Opticolor Express	Phoenix
F73V101	32	32	32
F73W100	28	28	28
F73S19	28	28	-
F73B10	28	28	-

Performance Tests

Substrate: 24 gauge Bonderite® 1000
Cold rolled steel panels
Cure: Baked 10 minutes at 325° F
DFT: 1.0-1.35 mils F73B10

Conical Mandrel, 1/8" Pass
Impact Resistance, Direct 30 in lb
Impact Resistance, Indirect 30 in lb
Pencil Hardness HB*

*Pencil Hardness may vary depending on dry film thickness, substrate and tester.

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

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

Note:

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