

SELECTION & SPECIFICATION DATA

Generic Type	A single package, low VOC, high solids baking enamel
Description	A single package, low VOC, high solids baking enamel designed to provide good corrosion, hardness & protection for industrial uses.
Features	<ul style="list-style-type: none"> • Single coat direct to metal • High Solids & low VOC • Excellent adhesion • Good resistance to corrosion • Ready to use viscosity • Good hardness
Color	Black, White or per customer requirements
Gloss	85°+ (ASTM D523 @ 60° angle)
Dry Film Thickness	0.75 - 0.9 mils (19 - 23 microns) per coat
Solids Content	By Volume 57% +/- 3%
Theoretical Coverage Rate	1210 ft ² /gal at 0.8 mils (29.7 m ² /l at 19 microns) 1009 ft ² /gal at 0.9 mils (24.8 m ² /l at 22 microns) 908 ft ² /gal at 1.0 mils (22.3 m ² /l at 25 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : Per EPA Method: 2.8 lbs / gal (336 g/l) These are nominal values and may vary slightly with color. Product contains VOC-exempt t-butyl acetate. Check local regulations regarding product usage.
Viscosity	30-35 seconds #2 EZ Zahn @ 25 +/- 1°C

SUBSTRATES & SURFACE PREPARATION

Steel	Surface to be free of all loose rust, dirt, grease and other contaminants
	Tin Plate Steel: Surface to be free of all loose rust, dirt, grease and other contaminants

Baquik HS Enamel

PRODUCT DATA SHEET



PERFORMANCE DATA

Test Method	Results
Adhesion (ASTM D3359)	4A (Trace Peeling)
Chip Resistance (Procedure FLTM BI 157-06)	Min 6 Rating-Pass
Fluid Resistance (ASTM D3359, Procedure FLTM BI 168-01 as directed in Section 1 Specification 1.3)	No Blistering, 4B Hardness (Procedure FLTM B 168-01 as directed in Section 1 Specification 1.3)
Hardness (ASTM D522)	H-2H
Lab Accelerated Cyclic Corrosion (ASTM D610, Procedure CETP 000.00-L467)	<2% Surface Corrosion after 3 weeks exposure
Salt Spray (ASTM D1654, Procedure A, Method 2)	Max Allowable Creepage @ scribe<=5 mm-Pass after 96 hrs exposure

MIXING & THINNING

Mixing | Agitate thoroughly.

Thinning | Not Recommended, consult Carboline for recommendations

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Airless Spray | 45:1 Airless spray equipment, HVLP or Conventional
Tip Size: 0.015 to 0.021"
Pump Pressure: Airless - 2000-3000 psi (17-24 MPa)

APPLICATION PROCEDURES

General | Designed to be applied direct to metal in a single coat application.

APPLICATION CONDITIONS

Condition

Must be a minimum of 5°F (3°C) above the dew point during the surface preparation and coating application.

CURING SCHEDULE

Curing Details | **Bake:** 1 minute flash @ 75°F (23°C) before oven. Then bake 5 minutes @335°F(168°C). Allow to cool for 5 minutes
Must be baked to fully cure.

CLEANUP & SAFETY

Cleanup | MEK may be used for clean up.

CLEANUP & SAFETY

Safety | Handle with care. Before and during use, observe all safety labels on packaging and paint containers and follow all caution statements on this product data sheet. Consult the Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. Employ normal workmanlike safety precautions.

Ventilation | When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

PACKAGING, HANDLING & STORAGE

Packaging | 55 gal drums or 5 gal pails

Shelf Life | Generally one year from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers.

Do not use material beyond shelf life.

Storage Temperature & Humidity | Do not store at temperatures above 100°F (38°C).

Storage | Containers must be closed tightly. Do not store outside. Rotate stock.

Flash Point (Setaflash) | 63°F (17°C)

WARRANTY

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