

2200 Line

Alkyd Melamine Baking Enamel

Recommended for bake application where a blend of hardness and flexibility are necessary. Typical uses included metal office furniture, filing cabinets, electric motor housings, vacuum cleaners, etc.

SPECIFICATION

DHMS C4.07
MIL-E-15090 Type III

PHYSICAL DATA

Finish:	Full Gloss Range
Colour:	Full Range of Industrial Colours
Weight Solids:	43% \pm 2%
Volume Solids:	35% \pm 5%
V.O.C.	500 - 600 g/L

RECOMMENDED SYSTEMS

This product line is designed for direct to metal application. To improve corrosion and adhesion please use a zinc or iron phosphate pre treatment.

Note: all physical and chemical resistance tests conducted after one week cure time at 20-25°C (70-75°F) on properly cleaned substrate.



SURFACE PREPARATION

Substrate must be dry and free from dirt, oil, grease, rust or other surface contaminants. For best results ferrous substrate should have some pre-treatment such as Iron or Zinc Phosphate. Aluminum surfaces must be clean as well and coated with 36-6001 Vinyl Wash Primer to ensure good adhesion.



INSTRUCTIONS FOR USE

Components: One



MIXING INSTRUCTIONS

Reduce 10 - 15% with appropriate reducer. See application method section for appropriate selection.



SPRAYING VISCOSITY

50-60 Seconds #4 Ford Cup



APPLICATION METHOD

Allow for application loss and surface irregularities.

Application:	Conventional or Electrostatic		
Reduction:	Slow	20-4102	High Flash Naptha
	Medium	20-4100	Xylene
	Fast	20-4101	Toluene



Technical Data Sheet

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RESISTANCE TABLE

Bake enamels develop excellent solvent and chemical resistance. Good resistance to alkali.

SUBSTRATES:

- Zinc Phosphated Steel
- Iron Phosphated Steel



EQUIPMENT

Most enamels are formulated for conventional air spray, however some minor adjustments may be necessary for electrostatic units. For best atomization 0.009"-0.011" spray tip should be used. Reduction to 20-25 seconds #2 Zahn cup with High Flash Naphtha or Xylene/Toluene is recommended. Adjust for Electrostatic spray may be necessary.



RECOMMENDED FILM BUILD THICKNESS & COVER RATE

Total Dry Film Recommendation 1.2 – 1.4 MILS DFT

Calculated Coverage at:

1.0 MILS:	561 ft ² /USG
25 MICRONS:	52 m ² /USG



ENVIRONMENTAL CONDITIONS

Temperature:	N/A
Relative Humidity:	N/A



DRY TIME

Bake:	10 - 15 minutes @ 300 - 350°F
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CLEAN UP

Cleaner:	Xylene
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STORAGE & SHIPPING

Flash Point:	-9°C
Shelf Life:	12 months unmixed for unopened cans



SAFETY PRECAUTIONS

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only.