



HIGH BAKE ENAMEL 609 (formerly 609 Baking Enamel)

TM2.60

DESCRIPTION

- A high bake, alkyd/melamine baking enamel

PRINCIPAL CHARACTERISTICS

- excellent gloss
- excellent adhesion to correctly prepared substrates
- excellent mar-resistance
- excellent abrasion resistance
- suitable for application to domestic appliances, office furniture, steel shelving and new drums

Note: We advise that you test this product to determine if it is suitable for your particular use.

COLOUR AND GLOSS

- available in customer specific colours, full gloss

BASIC DATA AT 25°C and 50% RELATIVE HUMIDITY

- vehicle type alkyd/melamine-formaldehyde resin blend
- typical film thickness (per coat) 25 microns (dry), 65 microns (wet)
- solids content approx. 38% by volume
- theoretical spreading rate 15.2m²/L for 25 microns (dry)
- baking time allow 10 minutes air flash off, then bake 30 minutes at 120°C;
or 20 minutes at 160°C; or 15 minutes at 175°C
baking schedule may affect gloss and colour
- shelf life (cool, dry place) at least 12 months in unopened container

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- best coating performance will be obtained with the highest degree of surface preparation
- degrease thoroughly to remove all oil, grease and other surface contaminants
- mild steel; remove all rust and any loose material by wire brush or mechanical sander
- for optimum performance a multistage phosphate pre-treatment process is recommended
- non-ferrous metals, galvanised iron; abrade using a Scotch-Brite® pad or wet and dry sandpaper. Do not use steel wool. Prime with WattyI Super Etch® Primer
- suitable previous coat; mechanically sand with P220-240 grit sandpaper
- substrate temperature should be at least 3°C above dew point
- relative humidity should not exceed 85%

INSTRUCTIONS FOR USE

- stir thoroughly with a flat-bladed or mechanical stirrer before, and during use
- paint temperature must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in low sag resistance and slower cure
- adequate ventilation must be continuously maintained during application and curing
- suitable for application by conventional, airless or electrostatic spray
- for recommendations outside those contained in this data sheet, refer to WattyI



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APPLICATION

- **AIRLESS SPRAY**
 - recommended thinner Thinner L703
 - volume of thinner up to 10%
 - nozzle orifice approx. 0.28 mm (0.011 inch)
 - nozzle pressure 12 MPa (1700 psi)

- **AIR SPRAY**
 - recommended thinner Thinner L703
 - volume of thinner 10-30%
 - nozzle orifice 1.4 - 1.8 mm
 - nozzle pressure 350 - 450 kPa (50-60 psi)

- **CLEANING SOLVENT** Thinner L703

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

PACKAGING

20 litres, 200 litres

For the most up to date information contact Wattyl Customer Service Hotline or visit the Wattyl Website.

	Australia	New Zealand
CUSTOMER SERVICE HOTLINE	132 101	0800 735 551
WEBSITE	http://www.wattyl.com.au	http://www.wattyl.co.nz

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