



581 SUPERBAKE

APRIL 1997

Alkyd Baking Enamel

Product Data

581 Superbake is a high quality baking enamel which provides a hard, high gloss, durable finish. It is an alkyd / melamine type coating and may be cured at various stoving schedules.

- Good chemical resistance
- Good heat resistance
- Excellent abrasion resistance
- Good durability (interior use)

Uses

For painting machinery, filing cabinets, metal cupboards etc, where a tough, durable finish is required for interior use.

Colour Availability

Black, white, tinted solid and metallic colours available at Point Of Sale.

Packaging

Available 4L, 20L

Substrates

Steel and ferrous metals.

Aluminium / galvanised steel / zintec – MUST be etch primed before applying rest of system.

Surface Preparation

Steel – Remove rust by blasting to SA2.5, or by using power tools or sanding. Degrease.

Aluminium – Degrease, then scour with Scotchbrite. Degrease, prime.

Galv – Clean and degrease. Use a proprietary acid wash if surface has been chromate treated. Prime.

Zintec – Clean and degrease. Prime.

Thinning and Clean Up

Thin as follows:-

Cold conditions: Up to 25% 254 Enamel Reducer MF.

Normal conditions: Up to 25% 475 Enamel Reducer MI.

Hot conditions: Up to 5% 312 Enamel Reducer MR.

Electrostatic spray: Adjust resistivity with 104 Enamel Reducer SF. Adjust to spray viscosity with 475 Enamel Reducer MI.

Clean gun and equipment with 254 or 475 Reducer.

Application

Spray – conventional, pressure pot, electrostatic.

Drying

Stoving schedules:-

30' @ 125C - Bare steel or etch primed substrate

25' @ 140C - On bare steel only – not on etch primed substrate

20' @ 150C - On bare steel only – not on etch primed substrate

10' @ 170C - On bare steel only – not on etch primed substrate

NOTE: The colour may change at the higher temperature stoving schedules.

Total Solids Content

51.4% (wt), 36.7% (vol) – for white

Theoretical Coverage

Approximately 9.2 sq. m/litre @ 40µm DFT – for white.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

CAUTION:

Improper use and handling of this product can be hazardous to health.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapour concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. PPG Industries makes no recommendation about the types of safety measure that may need to be adopted because these depend on application environment and space, of which PPG Industries is unaware and over which it has no control.

If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.

Health and Safety

Avoid breathing vapour. Use with adequate ventilation. High concentrations of vapour may cause headache or nausea, affect the nervous system and respiration. When catalysed this product contains isocyanates, which are harmful by inhalation. Refer to Code of Practice for the Safe Handling of Isocyanates 1989 (or updates) for details on handling isocyanate material.

Do not use in the presence of naked flame or other sources of ignition. Store away from heat.

Wear safety glasses / goggles, an air supplied respirator or hood and PVC or nitrile chemical handling gloves. Persons with a history of respiratory problems are advised not to use this product or any other two pack polyurethane.

Store / dispose of residues in accordance with local body regulations.

First Aid

If poisoning occurs, contact a doctor. The Poisons Information Centre may be of assistance – telephone 0800 POISON (0800 764 766).

If swallowed, do NOT induce vomiting. Give a glass of water to drink and get medical attention urgently.

If affected by vapour, get into fresh air immediately.

If splashed into the eyes, flush them with copious quantities of clean water for 15 minutes and get urgent medical attention.

If splashed onto skin, wash with soap and water.

For further information, refer to the Material Safety Data Sheet for this product.



581 SUPERBAKE

Substrate Systems

Preparation

Steel – Remove rust, clean and degrease, or blast to Class 2 ½ if indicated

Aluminium – Scour with Scotchbrite and degrease

Galv – Clean and degrease

Substrate / Recommended System	WFT / DFT (Microns)	Overcoat Time @ 20 Degrees C	Overcoat Preparation
STEEL 1 st coat 581 Superbake	100-135 / 37-50		
STEEL / ALUMINIUM / GALV / ZINTEC 1 st coat 719 Polyetch 2 nd coat 581 Superbake	70-100 / 7-10 100-135 / 37-50	15-20'	N/A
STEEL / ZINTEC 1 st coat 1894 Etch Primer 2 nd coat 581 Superbake	155-200 / 20-25 100-135 / 37-50	24 hrs plus	Sand 320
ALUMINIUM / GALV / ZINTEC 1 st coat 6002 AC-10 Primer 2 nd coat 581 Superbake	60-90 / 8-12 100-135 / 37-50	1 hour	N/A

DFT = Dry Film Thickness

Technical information given verbally or in writing is based on knowledge and research, given in good faith and believed to be reliable, but no guarantee of accuracy is made or implied. Since methods and conditions of use are beyond our control, all merchandise is sold and received subject to the condition that our liability whether express or implied for any defect in quality, or for any lack of fitness for the specified use thereof, is limited to the return of the purchase price if written claim is made within 14 days from date of delivery. It is recommended that the user makes his or her own tests to determine the suitability of the product for his own requirements. Freedom from patent restrictions is not implied.

PPG Industries NZ Ltd • 5 Monahan Road • Mt Wellington • Auckland • Phone 0800-263 766 • Fax 0800-659 377