



HIGH BAKE HEAT RESISTANT ENAMEL (formerly 637 Heat Resistant Enamel)

TM5.01

DESCRIPTION

- a high bake, heat resistant baking enamel

PRINCIPAL CHARACTERISTICS

- excellent resistant to heat up to 500°C
- suitable for interior and exterior use
- recommended for application to household heaters, stoves, engine parts, industrial smoke stacks etc.

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

COLOUR AND GLOSS

- black, matt

BASIC DATA AT 25°C and 50% RELATIVE HUMIDITY

- vehicle type silicone resin
- typical film thickness (per coat) 25 microns (dry), 80 microns (wet)
- solids content approx. 32% by volume
- theoretical spreading rate 12.8m²/L for 25 microns (dry)
- baking time allow 10 minutes air flash off, then bake 20 minutes at 175°C or 30 minutes at 150°C
- 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
- 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
- do not apply over previous coatings
- 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
- for recommendations outside those contained in this data sheet, refer to WattyI



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APPLICATION

- **AIRLESS SPRAY**
 - recommended thinner Thinner T18
 - 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 T18
 - volume of thinner 10-30%
 - nozzle orifice 1.4 - 1.8 mm
 - nozzle pressure 350 - 450 kPa (50-60 psi)

- **CLEANING SOLVENT** Thinner T18

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

4 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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