



LOW BAKE ENAMEL 660 (formerly 660 Low Bake Enamel)

TM2.80

DESCRIPTION

- A gloss, low bake, alkyd/melamine baking enamel

PRINCIPAL CHARACTERISTICS

- excellent gloss, adhesion and mar-resistance
- good abrasion resistance
- low curing temperature (down to 100°C)
- suitable for use on a wide range of metal products, such as shelving, light fittings, drums and office furniture

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

COLOUR AND GLOSS

- AS2700 colour card, 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), 60 microns (wet)
- solids content approx. 40% by volume
- theoretical spreading rate 16m²/L for 25 microns (dry)
- baking time allow 5 minutes air flash off, then bake 10 minutes at 100°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
- 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 Watty 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 Watty



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APPLICATION

- **AIRLESS SPRAY**
 - recommended thinner Industrial Enamel Thinner or Thinner T18
 - volume of thinner up to 15%
 - nozzle orifice approx 0.28 mm (0.011 inch)
 - nozzle pressure 12 MPa (1700 psi)

- **AIR SPRAY**
 - recommended thinner Industrial Enamel Thinner or Thinner T18
 - volume of thinner up to 15%
 - nozzle orifice 1.4 - 1.8 mm
 - nozzle pressure 350 - 450 kPa (50-60 psi)

- **CLEANING SOLVENT** Industrial Enamel Thinner or 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

20 litres

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

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

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