

Product Data Sheet**Intended Use**

Food - 3-Piece Ends & Bodies - Lacquer - Internal & External
For professional use only!

Chemical/Physical Characteristics

Technology	Solvent based	
Polymer Type	Epoxy/Phenolic	
Dry Film Color	Pale Gold	
Solid Content	35.0 ± 1.0%	20 minutes at 200 °C / 392 °F
Viscosity	85 ± 15 seconds	Ford 4 at 30 °C / 86 °F
Density	0.975 ± 0.015 kg/liter	

Storage Details

Storage Temperatures	Minimum 15 °C / 59 °F Maximum 35 °C / 95 °F Optimum 25 °C / 77 °F
Shelf Life (as supplied in original sealed containers)	6 Months at optimum

Viscosity increase during storage is possible!
Avoid storage of coating containers in direct sunlight.
Stir container thoroughly before use.

Comments

Before using this product refer to the Health and Safety Data Sheet and the appropriate Application Data Sheet. Consult the supplier for datasheets for this product relating to other end-use sectors if appropriate.

Disclaimer

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Application Data Sheet

Intended Use

Food - 3-Piece Ends & Bodies - Lacquer - Internal & External
 Food - EOE - Lacquer - Internal
 General Line - Industrial & Promotional - Lacquer - Internal
 For professional use only!

Application Details

Application Method	Rollcoat
Coating Preparation	Stir or Tumble at least 30 minutes Avoid introducing air into the product! Stir container thoroughly before use.
Application Coating Temp	30 ± 10 °C / 86 ± 18 °F
Substrate	ETP, TFS

Curing Details

Rollcoat, Single Coat	7.0 + 1.0 /- 1.0 gsm
Circulating Hot Air	11 + 1 /- 1 minutes @ 197.5 + 2.5 /- 2.5 °C PMT
Recommended Applied Film:	
1st Coat of Double Coat	6.0 + 1.0 /- 1.0 gsm
Recommended Cure:	
Circulating Hot Air	10 + 2 /- 2 minutes @ 175 + 5 /- 5 °C PMT
Recommended Applied Film:	
2nd Coat of Double Coat	6.0 + 1.0 /- 1.0 gsm
Recommended Cure:	
Circulating Hot Air	10 + 2 /- 2 minutes @ 195 + 5 /- 5 °C PMT

Oven air temperature must be set to achieve the specific PMT's where applicable. These values may vary due to capacity and efficiency of the oven.

Thinning and Cleaning

Thinner	Butyl Cellosolve Thinner PPG2004
Equipment Cleaner	Butyl Cellosolve Thinner PPG2004

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Coating spillages can be cleaned up with soap and water.

Supplied ready for use

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