



SPECTRACRON® 400 SERIES HS POLYESTER BAKING ENAMEL

DESCRIPTION:

SPECTRACRON 400 SERIES HS Polyester Baking Enamel is recommended for industrial use on pretreated or primed metal surfaces. Suitable applications include metal fabrication, metal office furniture, lighting fixtures, small appliances, lockers, cabinets and shelving.

HIGHLIGHTS:

- ❖ Excellent over bake resistance
- ❖ Excellent recoat ability
- ❖ Excellent detergent and cleaner resistance
- ❖ Excellent mar resistance and hardness
- ❖ Contains no heavy metals
- ❖ Low VOC

TECHNICAL PROPERTIES*:

PROPERTY	METHOD	RESULT
Color		Wide Variety
Gloss @ 60° Angle	ASTM D523	30 - 90
Pencil Hardness	ASTM D3363	H – 6H
Conical Mandrel	ASTM D522	Excellent
Impact Resistance	ASTM D2794	60 in-lbs direct
Adhesion	ASTM D3359	5B – Excellent
Humidity Resistance 250 Hrs	ASTM D2247	Excellent
Salt Spray Resistance 200 Hrs	ASTM B117	Good
Chemical Resistance		Very Good
Abrasion Resistance		Excellent
Substrates		CRS, HRS, Alum

*Results obtained over iron phosphated CRS panel

PHYSICAL PROPERTIES:

PROPERTY	VALUE
Weight per gallon	11.0 ± 1.5 lbs / gallon
Solid % (Weight)	76.0 ± 10%
Solid % (Volume)	70.0 ± 10%
Flash Point	106°F (41°C)
VOC	3.0 lbs / gallon maximum
Coverage	962 - 1283 sq ft / gallon @ 1 mil (no loss)
Shelf Life	12 months



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SURFACE PREPARATION:

The surface must be clean and free of all contamination. Chemical treatment of the substrate will improve the performance properties of the coating system.

APPLICATION DATA:

Mixing Instructions: Stir thoroughly before and occasionally during use
Wet Film Thickness: 1.5 - 2.0 mils
Dry Film Thickness: 1.0 - 1.5 mils
Thinner: Not recommended (Aromatic 100 if needed)
Clean up: MEK or Xylene or Acetone

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 *	NA	35	NA	66 DSD
Conventional	Graco Delta Air *	¼" Fluid	20-30	50-60	.042
Air Assisted Airless	Graco Alpha A.A. *	NA	1000-1500	30-40	.013 or .015
HVLP	Binks 2001 HVLP *	NA	50	NA	NA

*Or Equivalent

CURE SCHEDULE:

Bake: Flash 10 min @ ambient: 20 minutes @ 325°F (peak metal temperature)
Flash 10 min @ ambient: 15 minutes @ 350°F (peak metal temperature)

ADDITIONAL INFORMATION:

- ❖ For application below 50°F, please contact your technical sales/service representative
- ❖ No sanding required for recoat
- ❖ In-Service Temperature: 375°F maximum

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It is recommended that the customer should trial the product for adhesion and compatibility using all substrates, surface preparation techniques and application processes in the environment the product will be intended to be used in prior to actual product application.

The technical data presented in this bulletin is based upon information believed by PPG to be currently accurate. However, no guarantees of accuracy, comprehensiveness or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in this bulletin.

