



# Mid★America

**PROTECTIVE COATINGS, INC.**

1395 LOUIS AVENUE  
ELK GROVE VILLAGE, ILLINOIS 60007  
PHONE (847) 593-3239 • FAX (847) 593-3391

3348 WASHINGTON STREET  
FRANKLIN PARK, ILLINOIS 60131  
PHONE (847) 678-5775 • FAX (847) 678-5950

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>W/R Baking Enamels are the coatings designed for use on a wide variety of interior and exterior metal applications. This quality topcoat provides an excellent appearance, color and color retention either by itself or over commercially available primers. Meet the EPA volatile organic compounds emission for metal finishing.</p> <p><u>Advantages:</u></p> <ol style="list-style-type: none"> <li>1. Meets Federal HAPs rule for metal finishes as packaged</li> <li>2. User friendly - ease of handle.</li> <li>3. Excellent mar resistance.</li> <li>4. Good resistance to yellowing.</li> <li>5. Excellent hardness/flexibility balance.</li> <li>6. Early water resistance</li> <li>7. Flow and leveling</li> <li>8. Ease of cleanup - soap and water</li> <li>9. Full gloss range available.</li> <li>10. Full color range available.</li> </ol>	<p><u>Gloss:</u> High 70+ units Semi 30-60 units Low 10-20 units</p> <p><u>Solids:</u> Volume 30-35% Weight 45-50%</p> <p><u>Viscosity:</u> 50-60" (#2Zahn Cup)</p> <p><u>Recommended Film Thickness:</u> Wet Mills 3.0 - 4.0 Dry Mills 1.0 - 1.5</p> <p><u>Cure Schedule:</u> 10 min @350F</p> <p><u>Substrate:</u> Cold Rolled Steel, aluminum</p> <p><u>Hardness :</u> H - 2H</p> <p>Good air movement and humidity control are necessary for proper drying of w/r products. Flash off is recommended for leveling.</p> <p><u>pH</u> 8.5 - 9.5</p> <p><u>Package Life</u> 1 year unopened inside storage</p> <p><u>Protect from freezing</u></p> <p><u>Volatile Organic Compounds:</u> 1.5-1.9#/gal less water</p> <p><u>Impact Resistance:</u> direct 160 reverse 60</p> <p><u>Humidity (hours):</u> 150 Blisters none</p> <p><u>Crosshatch Adhesion:</u> 100%</p> <p><u>Salt Spray (hours):</u> over cooled rolled steel 150 scribe blisters medium dense #4 scribe creep (mm) 3</p>	<p><u>Metal :</u> Must be clean, dry free of grease, oil, dirt and any contamination to ensure proper adhesion and coating properties.</p> <p><u>Testing:</u> Due to the wide variety of substrates, surface preparations, application methods and environments customer should test complete system prior to full scale application.</p> <p><u>Metal Finishing System:</u></p> <ol style="list-style-type: none"> <li>1. If used as a topcoat - apply at 3 - 4 wet mills. Flash off 10 min @ 77F, 50% (RH). Bake 10 min @ 350F minimum</li> <li>2. If another coat is necessary apply at 3 -4 wet mills. Maximum dry film thickness must not exceed 3 mills dry.</li> </ol>