

## Water Bake

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p><i>Water Bake</i> is a water based acrylic-melamine modified enamel. This coating is designed to meet all state and federal VOC regulations. <i>Water Bake</i> is engineered as a direct replacement for standard solvent borne bake enamels.</p> <p>Apply <i>Water Bake</i> to metal substrates that have been properly cleaned and pretreated – iron phosphate for steel or yellow or clear chromate for aluminum. It is also excellent on zinc plated/cadmium plated steel commonly associated with the electronics industry.</p> <p><i>Water Bake</i> is custom matched according to the customer’s specifications and is capable of being textured using standard air pressurized spray equipment. It is also available as a self texturing single application product.</p> <p><b>CAUTION: AVOID FREEZING.</b></p> <p>Randolph Products Co. warrants that its products meet its internal specifications and are of merchantable quality. However, the purchaser is solely responsible for the suitability of the product for any particular application. The purchaser should thoroughly test or qualify the product for serviceability, environmental compliance and health and safety factors prior to use. Further, our total liability is limited to the price of the product or replacement in kind.</p> <p>Randolph Products Company  33 Haynes Circle  Chicopee, MA 01020  Phone: 413-592-4191  Fax: 413-594-7321  www.randolphproducts.com</p>	<p>Physical and chemical tests were performed on iron phosphate treated steel panels. Adhesion tests were performed on the appropriate substrates.</p> <ol style="list-style-type: none"> <li><b>1. Volume Solids:</b> 40 - 45% (varies by color)</li> <li><b>2. Pencil Hardness:</b> 2H</li> <li><b>3. Cross Hatch Adhesion:</b> 5B</li> <li><b>4. Flexibility:</b> Pass 1/8” Mandrel</li> <li><b>5. Theoretical Coverage @ 1 mil dft:</b> 641 - 721 ft<sup>2</sup>/gallon (varies by color)</li> <li><b>6. Direct Impact:</b> 120 inch lbs.</li> <li><b>7. Reverse Impact:</b> 120 inch lbs</li> <li><b>8. Solvent Resistance:</b> 10 double rubs – “No effect” is defined as no permanent softening of film and/or permanent change in appearance.  <b>Isopropyl Alcohol:</b> No effect</li> <li><b>13. Taber Abrasion (1000 grams; 1000 cycles; CS10 wheels):</b> &lt; 85 mg. loss.</li> <li><b>14. Gloss @ 60°:</b> 0 – 75 (varies by color and product)</li> <li><b>15. VOC:</b> 1.5 – 2.0 lbs/gallon (varies by color)</li> <li><b>16. Shelf Life:</b> Six Months</li> </ol>	<p>Use conventional air pressurized spray equipment. Stainless steel is highly recommended.</p> <p><b>BASE COAT</b></p> <p>Fluid pressure of 15 – 20 psi  Air pressure of 50 psi  Spray Viscosity: 17 – 22 seconds #3 Zahn cup @ 77°F.</p> <p>Reduction: 5 - 10% reduction with tap water if needed  NOTE: Viscosity adjustments by use of Zahn cup may be misleading due to the thixotropic nature of this product.</p> <p>Apply a smooth coat. If texturing allow a minimum of 15 minutes flash off or pre bake 5 minutes at 275°F. If smooth finish coat is desired, flash off 15 – 30 minutes and bake at 275 - 300°F for 20 – 30 minutes.</p> <p><b>TEXTURE COAT</b>  Fluid pressure of 10 – 15 psi  Air pressure of 5 – 20 psi  Depends on texture pattern desired.</p> <p>Viscosity: Use same as base coat or increase according to texture pattern.</p> <p>Flash off: 15 – 30 minutes after texturing depending on ambient air temperature and air movement.</p> <p><b>BAKE CYCLE</b>  Flash off: 15 – 30 minutes (prebake base coat 5 minutes at 275°F  Bake times: 20 – 30 minutes at 275 - 300°F</p> <p>Strategic placement of fans and heat will help shorten flash off times especially during humid days.</p>

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**Safety Precautions:**

This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.