Chem-Bake 1 Step

Endura-Clad Coatings

2 Part Acrylic Polyurethane Coating

Product Description

Chem-Bake 1 Step is a 2 –part, VOC compliant acrylic polyurethane coating. 9T00-A activator and additives required.

Advantages

- Very good color fastness
- Low HAPS
- VOC compliant
- Direct to metal
- Exterior
- Good flexibility
- Good flow and leveling
- Available in many colors
- Self-priming on many substrates
- Spray, brush, or roll*

* with proper additives

Product Characteristics

Resin	Acrylic polyurethane
Clean-Up	Acetone
Flash Point	73° F
Finish:	Gloss (90)
Color:	24 standard, unlimited custom colors available
Volume Solids:	57% ± 2%
Weight Solids:	64% ± 2%
Weight per Gal:	10 ± 2%
VOC (unreduced):	<249 g/l; 2.8 lb/gal
Packaging:	Short fill 1 gallon & short fill 5 gallon containers
Storage:	Store indoors at 45°F - 120°F. Protect from freezing.
Shelf Life	12 month unopened from date of manufacture

Theoretical Coverage Rate per Gallon:

Square ft coverage rate per gal	912	456	304
Wet mil film application rate	1.75	3.51	5.26
Dry mil film thickness achieved	1.00	2.00	3.00

Film builds **below 2 .5 mils total DFT** will not provide maximum film properties. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the

Drying Schedule @ 4.5 mils wet

Applied @50%RH	50°	77°	90°	Fahrenheit
To touch		2 hr	1 hr	
To handle		8 hr	4 hr	
To recoat		4 hr	2 hr	
To cure		7 days	7 days	
Pot Life		3 hr	2 hr	
Sweat in time	N/A			
Activation	9T00-A			

Application Conditions

Do not apply if the application surface or ambient temperature is below 35°F (2°C) or above 110°F (43°C), or if the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 90%. Don't apply when there is a risk of rain or freezing temperatures within 12 hours after application. Don't apply within 2 hours of sunset if the temperature is below 60 degrees.

Recommended Uses

Designed as a coating for repainting prefinished metal surfaces including SMP coil coated sheet metal that is used in the manufacturer of rolling steel doors, roofs, gutters, and metal siding.

- Self Storage Facilities
- Repainting interior or exterior metal wall systems.
- Premier refinish system for roll doors
- Gutters, downspouts and trim
- Swing doors

Not Recommended for:

- Immersion service
- Floors
- Direct application to rusted surfaces

Recommended Substrates

- Previously Painted Surfaces
- Primed steel
- Aluminum
- Galvanized Metal
- SMP coil coated steel

Compatibility with other Coatings

- Compatible with most coating types. It may be used over most aged and hard-cured coatings in good condition.
- Can be used overtop all Endura-Clad & Chem-Bake primers

Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings.

Performance Characteristics & ASTM Data

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Surface Preparation

The service life of the coating is directly related to the surface preparation. Surfaces to be painted should be clean, dry and free from wax, grease, dust, silicone, oil and excessive chalk. Do not use hydrocarbon solvents for cleaning. If solvent cleaning is required use acetone.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Seal stains from water, smoke, ink, pencil, grease, etc. with the appropriate primer/sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Existing Painted Surfaces: Remove all oil, dust, grease, dirt, chalk, rust, loose or peeling paint and all foreign matter. Scrape and sand peeled or checked paint to a sound surface. Steel rust and mill scale must be removed using sandpaper, wire brush, or other abrading method. Bare steel must be primed the same day as cleaned. Glossy or smooth hard surfaces should be dulled and/or abraded using Sand & Scrub cleaning mixture, silicon carbide sandpaper, Scotch-Brite® or other abrading medium to create a surface profile. If adequate surface profile is not achieved then *Chem-Bake®* bonding primer is recommended.

Aluminum and Galvanized Steel: Can be applied over properly prepared surfaces.

Masonry, Concrete, Block, Stucco: Not Applicable.

Wood, Plywood, Composition Board: Not Applicable.

Mildew Prior to attempting to remove mildew, it is recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised. Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach/water solution.

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

Mixing & Reduction

Mixing: Chem-Bake 1 Step is a two component product. Use 9T00-A activator. Mix contents of each container in a strict 6:1 ratio. Additives may be needed to optimize product for specific requirements.
VG-39021 Pot-life extender : use up 2 oz. per RTS gallon. Increases pot life up to 2 hours.
089-S: For high temp application: 90-110°F. Use up to 2 oz. per RTS gallon. Increases the open time and increases the pot-life.
Thinning: No need to be reduced, if desired, up to 5%. Use Medium reducer, fast reducer or reducer grade acetone.

Application Instructions

Airless Sprayer:. Recommended. Use spray equipment that delivers paint at an even consistent pressure without "surge". The sprayer, hoses and gun must be thoroughly clean and flushed with solvent. Always use a hose that is dedicated for spraying solvent based coatings, separate from spraying water based products. Spray with the least amount of pressure that still atomizes the paint properly. Recommended tip size and type: .010 -.014 fine finish.

When spraying use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle. Application in two light coats is generally better than one heavy coat.

Roller: Hi quality 1/4" - 1/2" nap non-shedding

Brush: Hi quality Nylon or Nylon/Polyester

When rolling 1 Step, add 1 oz, per activated gallon of 9M05 Rolling Thinner to reduce bubbling. Any thinning may hamper ability to achieve high film builds and may cause sagging. Application by brush or roller may require additional coats to achieve recommended dry film thickness. Once rolling thinner is added, product CANNOT be sprayed.

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Clean-Up

Clean spills and spatters immediately with Acetone. Clean hands and tools immediately after use with acetone or lacquer thinner. Never leave material in equipment when not in use. Dried paint film, spray equipment, and mixing equipment can be cleaned by soaking and scrubbing with acetone.

Safety & Handling

For use only by professional, trained painters. Before using, read and follow all label and MSDS precautions. When handling or applying any industrial coating always wear chemical resistant gloves and avoid contact with the skin. Always use a properly fitted respirator that employs chemical cartridges while handling, mixing, or spraying. If mixed with other components, mixture will have hazards of all components. All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Published technical data and instructions are subject to change without notice.
Warranty: All products are warranted to be free of manufacturing defects. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product.