

product information

9300 SERIES HIGH SOLIDS BAKING ENAMEL

Cardinal's 9300 series has been developed for the office furniture and general metal coating industry to provide an economic compliance alternative. This product has the same film qualities that conventional baking enamels have but has a VOC content of 360 grams/liter. 9300 series is an ideal paint to be used on cold rolled steel, phosphatize steel, pretreated aluminum, etc.

TYPICAL USES:

Business machines Decorative metal Metal Furniture

BENEFITS:

Low VOC content Easy to apply RoHS / WEEE Compliant

CURED FILM PROPERTIES:

Testing conducted on 9308-10 semi-gloss white at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000 test panel, cured 20' @ 350 F

<u>TEST</u>	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	0% loss
Impact	ASTM D2794	Direct Reverse	>60 in. lbs >30 in. lbs.
Hardness	ASTM D3363	Pencil	F-H
Solvent Resistance	ASTM D4752	MEK 25rubs	No effect

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Bubbles and blisters	Gas entrapment	Add 1 oz/gal of
Paint spatter	Spray tip obstructed	Remove spray button and clean orifice with fine wire. Clean with lacquer thinner.
Runs and sags	Paint too wet	Hold can further away from part while applying. Speed up rate of application.
Dry spray	Paint too dry	Hold can closer to part while applying. Slow down rate of application.

PRODUCT IDENTIFICATION

<u>9308</u> – <u>11350</u> (example) | | | Color number

Gloss: $0 = \text{flat}; 1 = 10^\circ; 2 = 20^\circ \dots \text{etc.}; 70^\circ - 80^\circ + = \text{high gloss}$ Special: eg., 2 = metallic; 3 = hammer; 4 = texture; 6 = primer; 7 = clear Product type

FOR INDUSTRIAL USE ONLY NOT FOR RESIDENTIAL USE

TYPE: Alkyd-Melamine

COMPONENTS: One

COLORS: Full range including metallics.

GLOSS: High , semi and flat.

COVERAGE: 900-950 sq ft per gallon at DFT 1.0 mil. @ 65% TE

VOC CONTENT: 360 GRAMS/LITER (3.00 LBS/GAL)

Volume Solids: 56% -58% Viscosity: 25" – 30" Zahn #3 @ 78F

FLASH POINT: 24°F TCC

SHELF LIFE: 1 year from date of manufacture on the label

APPLICATION:

CURE:

Thoroughly mix the paint prior to application. Apply a uniform coating to the specified substrate. Brushing, rolling and dipping are not recommended. See Surface Preparation and Priming section for further instructions.

RECOMMENDED FILM THICKNESS: 1.0 - 1.5 mils

Force Dry 20' @ 325 F 15' @ 350 F 10' @ 375 F

(At 1.5 mils dry film thickness, 78° F, 50% RH)

CLEAN-UP: Clean up should be done as soon as possible. The drier the paint, the more resistant it is to clean up. Air quality regulations may limit allowable emissions from cleaning operations.

PRODUCT LIMITATIONS:

- Not intended for exterior applications.
- For industrial use only.

(Continued on page 2)

So. El Monte, CA 1329 Potrero Ave. 91733 (323) 283-9335 (626) 444-9274 Fax (626) 444-0382

www.cardinalpaint.com

NO WARRANTY EXPRESSED OR IMPLIED, ACCEPTABILITY TO BE DETERMINED BY USER, SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

	o not breath vapors or spray mists.
supplied respi	Vs are exceeded, a NIOSH approved a rator is advised. See MSDS for TL
information.	extremely FLAMMABLE and are under
	Do not puncture or incinerate. Keep from
	or open flame. Exposure to heat ma
	ons are possible. Avoid use by persor
with respirator	
thoroughly afte	with eyes, skin, and clothing. Was er handling.
FIRST AID:	
Eye contact, fl	ush immediately with plenty of water for
	and get medical attention.
Skin contact,:	 and get medical attention. wash thoroughly with soap and water for
Skin contact,: 5 minutes.	wash thoroughly with soap and water for
Skin contact,: 5 minutes.	wash thoroughly with soap and water for do not induce vomiting and get medica
Skin contact,: 5 minutes. If swallowed, o attention imme	wash thoroughly with soap and water for do not induce vomiting and get medica
Skin contact,: 5 minutes. If swallowed, o attention imme	wash thoroughly with soap and water for do not induce vomiting and get medica ediately. hove to fresh air.
Skin contact,: 5 minutes. If swallowed, attention imme Inhalation, rem	wash thoroughly with soap and water for do not induce vomiting and get medica ediately. hove to fresh air.

G12TL

IMPORTANT: Warranty and Disclaimer — The performance characteristics of these products vary according to product application, operating conditions, materials applied to or with and use. Since these factors can affect results, we strongly recommend that you make your own test to determine to your satisfaction whether the product is of acceptable quality, has not been affected by storage or transport and is suitable for your particular purpose under your own operation conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.