



product
information

9700 SERIES
HIGH SOLIDS BAKING ENAMEL

Cardinal's 9700 series is a high solids baking enamel which has been developed for metal finishers who need to meet the demand of large volume production lines. This product is a high solids baking enamel which has a tested VOC content if less than 420 grams per liter, as supplied and applied.

TYPICAL USES:

- Business machines
- Decorative metal
- Metal Furniture

BENEFITS:

- Low VOC content
- Easy to apply
- RoHS / WEEE Compliant

CURED FILM PROPERTIES:

Testing conducted on 9708-10 semi-gloss white at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000 test panel, cured 20' @ 350 F

TEST	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	H
Solvent Resistance	ASTM D4752	MEK 25rubs	No effect

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Bubbles and blisters	Gas entrapment	Add 1 oz/gal of SB-09
Paint spatter	Spray tip obstructed	Clean air cap and fluid nozzle with Acetone.
Runs and sags	Paint too wet	Apply further away from part while applying. Speed up rate of application.
Dry spray	Paint too dry	Apply closer to part while applying. Slow down rate of application.

PRODUCT IDENTIFICATION

9708-11350 (example)
 _____ Color number
 _____ Gloss: 0 = flat; 1 = 10°; 2 = 20° . . . etc.; 70° - 80°+ = 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: Acrylic-Melamine

COMPONENTS: One

COLORS: Full range including metallics.

GLOSS: High, semi and flat.

COVERAGE: 850 sq ft per gallon at DFT 1.0 mil. @ 65% TE

VOC CONTENT: 420 GRAMS/LITER (3.50 LBS/GAL)

VOLUME SOLIDS: 49% -53%

Viscosity: 25" – 30" Zahn #3 @ 78F

Conductivity: 10 -30 microamps

FLASH POINT: 24°F TCC

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

APPLICATION:

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

CURE: 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. Air quality regulations may limit allowable emissions from cleaning operations.

PRODUCT LIMITATIONS:

- For industrial use only.

(Continued on page 2)

Safety: Contains organic solvents. Use with adequate ventilation - do not breath vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.

Contents are extremely FLAMMABLE and are under PRESSURE. Do not puncture or incinerate. Keep from heat, sparks or open flame. Exposure to heat may cause bursting.

Allergic reactions are possible. Avoid use by persons with respiratory problems.

Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

Eye contact, flush immediately with plenty of water for at least 15 min. and get medical attention.

Skin contact, wash thoroughly with soap and water for 5 minutes.

If swallowed, do not induce vomiting and get medical attention immediately.

Inhalation, remove to fresh air.

RELATED PRODUCTS:

PRODUCT NO.	DESCRIPTION
A-4100 Series	Acrylic aerosol

G12TL