



HIGH BAKE ADDITIVE

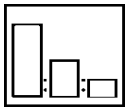
PRODUCT DESCRIPTION

Commercial Performance Coatings High Bake Additive is formulated to be used with Performance Enamel Topcoat to provide a high bake, thermosetting enamel topcoat that is suited for the coating of agricultural equipment, machinery and trailers in a production environment where high bake oven facilities are available. It must only be used in the Commercial Performance Coatings products as recommended in this technical data sheet to ensure proper performance of the product.

PRODUCTS

Performance Enamel Topcoat Mixed Colour		PET
High Bake Additive		HBADD
Reducers	<i>Normal conditions</i>	AER20 Alkyd Enamel Reducer Normal
	<i>Hot conditions</i>	AER30 Alkyd Enamel Reducer Slow

MIXING RATIO BY VOLUME



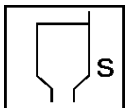
PRODUCT

PET
HBADD
Reducer

PARTS

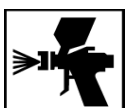
4
1
Up to 20%

SPRAY VISCOSITY



16 - 20 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 2 - 3 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

Allow 10 - 15 minutes flash off at 25°C before baking

DRYING TIME



BAKE (120°C Metal Temperature)

30 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Recoat immediately after bake and cool-down. Surfaces which have been baked must be sanded prior to recoating.

TOTAL DRY FILM BUILD

40 - 50 µm

TECHNICAL PARAMETERS

COVERAGE

6.0 - 9.3 metres squared per litre (m²/L)

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only. The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development. Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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