



product
information

9000 SERIES
HIGH SOLIDS BAKING ENAMEL

Cardinal's 9000 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. 9000 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 9008-10 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 >10 in. lbs.
Hardness	ASTM D3363	Pencil	H – 2H
Solvent Resistance	ASTM D4752	MEK 100rubs IPA 200 rubs	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	Spray further away from part while applying. Speed up rate of application.
Dry spray	Paint too dry	Spray closer to part while applying. Slow down rate of application.

PRODUCT IDENTIFICATION

9008-11350 (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: Polyester-Melamine

COMPONENTS: One

COLORS: Full range including metallics.

GLOSS: High, semi and flat.

COVERAGE: 1150-1250 sq ft per gallon at DFT 1.0 mil.
@ 65% TE

VOC CONTENT: 275 GRAMS/LITER (3.00 LBS/GAL)

VOLUME SOLIDS: 72% -78%

Viscosity: 25" – 30" Zahn #3 @ 78F

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. 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.

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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.

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