SANCRYL 890

ACRYLIC PTFE BAKING ENAMEL: HEAT CURE

SERIES A890

GLOSS FINISH

SANDSTROM PRODUCTS COMPANY

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DESCRIPTION

Sancryl 890 Acrylic PTFE Baking Enamel provides a durable glossy finish with excellent UV light resistance. This versatile solventborne single component coating is optimized for spray and dip spin application.

OUTSTANDING FEATURES/BENEFITS

- Excellent UV weatherability and gloss retention
- Fast cure response
- Lubricity through PTFE reduces friction in applications with surface contact
- May be recoated with no extra surface preparation (allow to fully cure prior to recoating)

TYPICAL USES

- On coating fasteners
- As UV protective finish
- As light reflective finish

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet and Technical Data Sheet. The properties listed on this sheet are not intended for use as a specification. Please contact our Technical Service Team.

Refer to our website for answers to common questions:
https://www.sandstromproducts.com/resources/FAQs/

LIMITATIONS

- Do not use where temperatures regularly exceed 400°F.
- Product not suitable for food contact or food processing equipment.

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon^ *ASTM D1475*	8.0 - 12.0 lbs./gallon (Theoretical)	**Vehicle**	Acrylic
Weight Solids^ *ASTM D2369*	65 - 77% (Theoretical) Varies by color	**Lubricating Pigment**	PTFE
Volume Solids	50 - 65% (Theoretical)	**Color**	White, Tan (Custom Colors Available)
VOC	2.0 - 3.0 lbs./gallon	**Finish**	Smooth and glossy
Odor	Strong solvent	**Gloss^** *ASTM D523*	50+ gloss units at 60°
Viscosity^ *ASTM D562*	60 - 70 KU @ 77°F	**Pot Life**	Not Applicable
Shelf Life	12 months from Date of Manufacture	**Coverage Rate***	900-1000 sq. ft./gallon @ 1 mil DFT
Storage Conditions	32°F to100°F	**Recommended Coats**	1
Freeze/Thaw Stability	Stable	**Dry Film Thickness** *ASTM D7091*	0.75 – 1.25 mils

*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.
^ Property tested with each production batch.

PERFORMANCE AND FUNCTIONAL PROPERTIES

Chemical/Fluid Resistance:		**Hardness**	H pencil
*MEK Double Rubs^* *ASTM D5402*	125 (^ tested at 100)	**Operating Temperature Range**	-300°F to 400°F
Crosscut Adhesion *ASTM D3359*	5A over cold rolled steel		

^ Property tested with each production batch.

GENERAL
This product is a heat curing acrylic baking enamel, optimized for spraying and dip spin application. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

FILM THICKNESS & ENGINEERING TOLERANCE
As supplied, this product will yield a film thickness of about 0.00075 to 0.001 inches per spray application.

COVERAGE
One gallon of this material will cover 900 - 1000 sq. ft. with a dry film thickness of 0.001 inches. Coverage depends upon methods of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION
It is recommended that the surface be thoroughly de-greased with a suitable solvent and grit blasted and/or zinc, iron, or manganese phosphate pre-treatment be applied for best results. Minimum preparation requires the surface be dry and free of dust and greases or oils.

IMPORTANT! ***DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.*** Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING
IMPORTANT! STIR THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING APPLICATION.

THINNING
For spray application it is recommended to thin the coating 2:1 based on volume with Sandstrom's D152-C01 Thinner Blend. Optimal thinning must be determined for each individual dip spin assembly.

APPLICATION
For spraying – Thin as described above and spray as any conventional paint. Note: if air assisted airless spray equipment is used, ensure the spray tip orifice is greater than 0.001 cm.
For dipping – For dip spin technical assistance, contact the Sandstrom Solutions Center.

BAKING / CURING
After application and prior to being placed in an oven, it is recommended that parts flash off for 10 minutes @ 77°F ± 5°F and ≤70% relative humidity. Once the parts are dry, bake at 300°F for 20 minutes to reach full cure and attain full mechanical characteristics.

IMPORTANT! The time starts when **the part** reaches temperature, not when placed in a Class A oven.

CLEANUP
Wet product may be wiped away with a rag. If product is dry but not cured, a solvent such as MEK or acetone may be used.

REMOVAL
It is recommended that the cured film be removed by abrasive blasting or sanding.

WARNINGS: Constant stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.