

#8558

ALUMINUM CORROSION INHIBITING BAKING FINISH

SERIES E860



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DESCRIPTION

The **#8558 Aluminum Baking Finish Kit** consists of:
4 Parts Component A (E860-000) Clear Vehicle
1 Part Component B (E860-M16) Pigment
3 Parts Catalyst Thinner (G110-C01)

Sold by the kit SAN-E860-M16-CD4 formerly known as
UNS 8558.

TYPICAL USES

- Provides exterior protective coating for all metals including magnesium
- Special pigmentation eliminates need for prime coat
- Exhibits good thermal stability
- Will not discolor appreciably when subjected to temperatures of 450°F for 24 hours

COMPOSITION AND PHYSICAL PROPERTIES

	Component A	Component B	Thinner
Net Weight per Gallon	8.8 ± .2 lbs.	10.4 ± .2 lbs.	6.8 ± .2 lbs
Non Volatiles (Minimum)			
By Weight	70% ± 3%	45 - 52%	6 - 7%
Theoretical By Volume	66% ± 3%	25% ± 3%	5.5 - 6.0%
Viscosity @ 77°F	250 ±100 cps #3 spindle @ 20 rpm		
Flash Point (±2°F) Setaflash	58°F	79°F	23°F
Operating Temperature Range	-320°F - +450°F		
Vehicle Type	Epoxy		
Pigmentation	Component A - Clear Component B - Aluminum		Corrosion Protection Over Plain Steel 264 hrs** Over Zinc Phosphate 1200 hrs** (5% Salt Spray @ .0005 DFT) **Test halted before failure occurred
Shelf Life	6 months from date of shipment / NOTE: Components A & B must be stored in freezer to assure shelf life		Chemical/Fluid Resistance Excellent Unaffected by immersion in various industrial solvents and hydraulic oils (i.e. Skydrol 500, Acetone, MEK, Trichloroethane, etc.)
Pot Life	Mixed product 3 - 4 days @60°F and may be extended by refrigeration		Odor Strong solvent
Coverage (Mixed)	620 sq ft @ 1 mil DFT		Method of Application Conventional spray
Thermal Stability	Withstands thermal shock with no sign of blistering, cracking, peeling, chipping loss adhesion or high temperature aging.		Cure TYPE I 20 minutes @ 300°F TYPE II 30 minutes @ 350°F
		Cured Film Hardness	4H minimum

NOTICE

Before using this product, read all warnings and safety information printed on the label, the Material Safety Data Sheet, and the Technical Info-Guide. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY. This product is flammable and the safety precautions usually followed when using flammable materials must be observed.

SURFACE PREPARATION

The following surface preparations are recommended for the individual metals listed to develop maximum adhesion and corrosion protection. Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

STEEL

Degrease using naphtha meeting the requirements of FED spec TT-N-95, grit blast (30-60 rms optimum), remove grit blast debris from surface, zinc phosphatize (1100-1600 milligrams per sq. ft.).

STAINLESS STEEL

Degrease using naphtha meeting the requirements of FED spec TT-N-95, grit blast (30-60 rms optimum), remove grit blast debris from surface, passivate.

ALUMINUM

Degrease using naphtha meeting the requirements of FED spec TT-N-95, anodize (hot water or nickel acetate seal only) or hard coat and seal.

TITANIUM

Solvent wash (nonchlorinated) and alkaline anodize.

COPPER ALLOYS

Degrease using naphtha meeting the requirements of FED spec TT-N-95, then pretreat using one of the following methods (in order of preference).

- a) Black oxide treat
(according to MIL Spec MIL-F-495C)
- b) Bright dip or grit blast (30-60 rms optimum)

IMPORTANT! AVOID TOUCHING THE SURFACES TO BE COATED--OIL FROM HANDS WILL INTERFERE WITH PROPER COATING. Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING

IMPORTANT! THIS PRODUCT CONTAINS HEAVY PIGMENTS WHICH SETTLE RAPIDLY. THEREFORE, IT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND CONTINUOUSLY DURING APPLICATION.

MIXING INSTRUCTIONS

TYPE I (Thinned): Mix 4 Parts of Component A with 1 Part of Component B and thin with 3 Parts of Activated Thinner.

TYPE II: Mix 4 Parts of Component A with 1 Part of Component B.

APPLICATION

Properly mixed product should be sprayed to desired film thickness (.8 - 1 Mil). Allow parts to flash off at least 10 minutes before placing in oven.

CURING

TYPE I: Bake for 20 minutes at 300°F.

TYPE II: Bake for 30 minutes at 350°F.

Note - Start timing when the part reaches the curing temperature, **NOT** when it is placed in the oven.

CLEANUP

Use MEK for cleaning tools.

Strict compliance to the instructions given in Surface Treatment, Stirring, and Baking is essential to obtain optimum results.

WARNINGS: Constant stirring is imperative for best results. Caution: Flammable. Keep away from sparks and open flame. Use with adequate ventilation. Avoid prolonged breathing of vapors. If swallowed--DO NOT INDUCE VOMITING. Contains Methyl Ethyl Ketone. Call physician immediately.

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY

We warrant our products to be free of manufacturing defects, and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and is accurate to the best of our knowledge. They are based on technical data which we believe to be reliable, and are intended for use by persons having skill and "know-how," at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED, OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders or other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. © 2/1/98 SANDSTROM PRODUCTS COMPANY 11/7/02