



SA61D

EPOXY BAKING ENAMEL: GLOSS BLACK

SERIES E861

**SPECIFIED TO SUNDSTRAND MS37.20
SPECIFIED TO WESTINGHOUSE 32213AX**



PORT BYRON, IL 61275 • 1-309-523-2121
1-800-747-1084 • FAX: 1-309-523-3912
www.sandstromproducts.com

DESCRIPTION

SA61D is a single component, epoxy base baking enamel, formulated to give exceptional corrosion protection and chemical/fluid protection.

Type I enamel is thinned with SAT-100 activated thinner.

Type II enamel is thinned with methyl ethyl ketone.

TYPICAL USES

- Provides heavy duty service as an exterior protective coating for all metals including magnesium.

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS) and Technical Data Sheet.

OUTSTANDING FEATURES/BENEFITS

- Offers high degree of resistance to chemical corrosion, solvent softening, abrasion and impact
- Exhibits good thermal stability
- Special pigmentation eliminates need for prime coat

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon	8.60 ± 9.30 lbs./gallon	Vehicle	Combination of epoxy resins and thermosetting latent curing agents
Weight Solids	55% ± 2.0%	Pigment	Carbon Black, Corrosion Inhibitors
Volume Solids	45.0% (Theoretical)	Color	Gloss Black
VOC	4.02 lbs./gallon	Gloss	80+ gloss units at 60°F
Odor	Strong solvent	Pot Life	4 days
Viscosity	50 – 70 KU @ 77°F	Coverage Rate* @ 1 mil	727 sq. ft./gallon (as manufactured)
Shelf Life	6 Months from Date of Manufacture	Recommended Coats	
Storage Conditions	Store at 40°F or below IMPORTANT TO ROTATE STOCK	Dry Film Thickness	0.5 – 1.0 mil DFT recommended (use this as a guide to determine the optimum DFT for your specific application)
Freeze/Thaw Stability	Stable	Flash Point	55°F ± 2°F Setflash

*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

PERFORMANCE AND FUNCTIONAL PROPERTIES

Chemical/Fluid Resistance: Excellent Unaffected by immersion in various industrial solvents and hydraulic oils (i.e. Skydrol 500, Acetone, MEK, Trichloroethane, etc.)		Hardness (Pencil)	4H
<i>MEK Double Rubs</i>	100+		
Corrosion Protection:			
Over plain steel	500 hours	<i>(5% salt spray @ .001" DFT) ment</i>	
Over Zinc Phosphate	1000 hours		

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 are accurate to the best of our knowledge. They are based on technical data 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. SANDSTROM PRODUCTS COMPANY

GENERAL

This product is a paint-like material consisting of corrosion inhibitive pigments dispersed in a thermosetting resin system thinned with appropriate solvents. 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 0.0005 to 0.001 inches per spray application. Usually engineering tolerances will permit necessary minimum film buildup of 0.0002 to 0.0003 inches without interference. Whenever possible, the proper tolerances should be designed into the part.

COVERAGE

One gallon of this material will cover 727 sq. ft. with a dry film thickness of .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

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

To accomplish rapid, full cure

Type I: Use 1 part of SAT-100 Activated Thinner to 2 parts of SA61D Black

Type II: Use 1 part MEK to 2 parts SA61D Black

APPLICATION

Conventional spray

BAKING, DRYING, CURING

May remain slightly tacky until it is baked.

After a flash time of 15 minutes, SA61D can be cured according to the following schedule:

Type I 30 minutes @ 300°F (reduced with SAT-100)

Type II 30 minutes @ 350°F (reduced with MEK)

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

CLEANUP

Use MEK for cleaning tools

WARNINGS: Constant stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.

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 are accurate to the best of our knowledge. They are based on technical data 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. SANDSTROM PRODUCTS COMPANY