



# TECHNICAL DATA SHEET

## STOKES COMPLIANT STOVING ENAMEL PAINT

Reference	Revision No	Revision Date	Printed	Page 1 of 2
CS	4	29 September 2011	29 September 2011	

WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899  
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<b>Properties and Uses</b>	<p><b>PROPERTIES</b> Stokes Compliant Stoving Enamel Paints providing hard, tough finishes for metal. Short stoving schedules allow for rapid rates of production and reduced drying space. Careful choice of resins and solvents has allowed us to produce paints with low odour levels. Paints in this range are specially formulated to comply with the requirements of the Environmental Protection Act Process Guidance Note PG6/23(11).</p> <p><b>USES</b> Suitable for use on a wide range of metal articles e.g. furniture, tools, metal fabrications, castings, etc.</p>
<b>Technical Data</b>	<p><b>TYPE</b> Alkyd / amino resin system with carefully selected heat stable pigments.</p> <p><b>STOVING TIME &amp; TEMPERATURE</b> Typical stoving schedule would be 7 mins. at 160°C (metal temperature). Lower temperatures for longer periods of time are also possible. (Refer to Technical Department for other recommendations).</p> <p><b>THEORETICAL SPREADING CAPACITY</b> Approximately 24 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 25 microns (1 thou).</p> <p><b>FLASH POINT</b> Between 21°C and 55°C FLAMMABLE LIQUID.</p> <p><b>NON VOLATILE CONTENT</b> By volume 60% nominal. By weight 65 - 70%.</p> <p><b>CLEANING SOLVENT</b> Stokes Thinners Ref. TH004 or TH012. (See also application section).</p> <p><b>OIL RESISTANCE</b> Good resistance to most lubricating and industrial oils. Tests for suitability with any particular oil should be made before large scale application.</p> <p><b>CHEMICAL RESISTANCE</b> Good resistance to most common dilute acids and alkalis. Tests should be made for resistance to particular reagents before large scale application.</p> <p><b>LEAD CONTENT</b> Any colours containing lead pigments are clearly labelled on the container. If in any doubt contact our Technical Department.</p> <p><b>COLOUR RANGE</b> Paints in this range are produced to meet customers specific requirements.</p>
<b>Stock Container Sizes</b>	<p>20 &amp; 200 Litres. Other size packs available by arrangement.</p>
<b>Processes</b>	<p><b>PREPARATION</b> The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, peeling or loose material or any other contamination.</p> <p><b>FINISHING</b> A single coat of the stoving enamel paint will be satisfactory for most purposes. However, either a coat of etch primer prior to applying the stoving enamel paint or use of phosphated steel will improve the performance of the coating.</p>



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<b>Application</b>	<p>Paints from this range are normally applied through hot spray equipment at approx. 50°C. Thinning of paints in this range will render them as non-compliant coating outside the requirements of Process Guidance Note PG6/23(97).</p> <p>CONVENTIONAL HOT SPRAY Supplied ready for use.</p> <p>ELECTROSTATIC HOT AIRLESS SPRAY Supplied ready for use.</p>
<b>Storage</b>	<p>Use within 12 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of MSDS CS).</p>
<b>Health and Safety</b>	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. CS FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING MEASURES, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
<b>Disclaimer</b>	<p>The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.</p> <p>This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes &amp; Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.</p> <p>R.J.Stokes &amp; Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.</p>