



TECHNICAL DATA SHEET

STOKES LOW BAKE STOVING ENAMEL PAINT

Reference LB	Revision No 1	Revision Date 18 May 1998	Printed 15 January 2008	Page 1 of 2
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WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
Little London Road | Sheffield | S8 0UH | Tel: 0114 258 9595 | Fax: 0114 250 9836 | Email: sales@rjstokes.co.uk

Properties and Uses	<p>PROPERTIES Stokes Low Bake Stoving Enamel Paint provides a hard, tough, durable finish for metal. Short stoving schedules allow for rapid rates of productions.</p> <p>USES Coating all types of metal articles e.g. metal fabrications, tools etc. One coat of stoving enamel, applied over Stokes Low Bake Zinc Phosphate Primer Ref. IP081 or Etch Primer, provides a highly durable decorative finish.</p>
Technical Data	<p>TYPE Alkyd/amino medium and first quality pigments.</p> <p>STOVING SCHEDULE 20 minutes , 100°C (metal temperature). For other possible stoving schedules, consult Stokes Technical Department for advice.</p> <p>THEORETICAL SPREADING CAPACITY 11 - 13 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 30 - 35 microns. (Depends on colour).</p> <p>FLASH POINT Between 22°C and 32°C. FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT (Depends on colour). By volume 40% nominal. By weight 49% nominal.</p> <p>THINNERS AND CLEANING SOLVENT Stokes Thinners Ref. TH035.</p> <p>HEAT RESISTANCE Up to 150°C.</p> <p>OIL RESISTANCE Good resistance to most lubricating and industrial oils. Tests for suitability with any particular oil should be made before large scale application.</p> <p>CHEMICAL RESISTANCE Good resistance to most common dilute acids and alkalis. Tests should be made for resistance to particular agents before large scale application.</p> <p>LEAD CONTENT Unless stated on the label, no added lead. Please refer to the MSDS Ref. LB.</p> <p>COLOUR RANGE Limited colour range held in stock. Shades to meet customers special requirements can be supplied by arrangement.</p>
Stock Container Sizes	20 litres, other sizes by special arrangement.
Processes	<p>PREPARATION The surface to be painted must be clean, dry and free from grease, dust, dirt, rust and peeling or loose material. If a high standard of protection is required over bare metal, then first apply a coat of Stokes Low Bake Zinc Phosphate Primer Ref. IP081.</p> <p>FINISHING Apply one coat of Stokes Low Bake Stoving Enamel Paint as directed below.</p>
Application	<p>CONVENTIONAL SPRAY, AIRLESS SPRAY AND DIPPING Thin as necessary with Stokes Thinners Ref. TH035.</p> <p>ELECTROSTATIC SPRAY Adjust conductivity of paint if necessary with Stokes Thinner Ref. TH009.</p>



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Storage	<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 Stokes Material Safety Data Sheet Ref. LB).</p>
Health and Safety	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. LB FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
Disclaimer	<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 & 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 & 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>