Bakote™

Industrial Maintenance and Marine Enamel

SELECTION DATA

DESCRIPTION:

Bakote, **35** series, is a classic general purpose, high solids, oil modified, long and medium oil alkyd industrial and marine maintenance enamel. It has high gloss, relatively flexible, crack resistant film, the ability to penetrate through minor surface contaminants, excellent corrosion protection and very simple to brush, roll or spray application. **Bakote** is designed for application to primed surfaces but is recommended for direct application to clean iron and steel and to previously painted surfaces that have been abraded to dull.

USE:

Primary design use is the maintenance of industrial iron and steel. Frequent uses include structural steel, rail cars, factory piping, factory doors, storage tanks, catwalks, etc. **Bakote** is also used as an OEM finish on larger air dried iron and steel fabrications such as farm and construction equipment. Excellent uses include water craft maintenance, hand rails, public rest rooms, garage walls, lockers, patio furniture, cabinets, shelving, railings, tanks, machinery, trailers, poles, table tops, utility equipment, piping, etc.

ADVANTAGES:

- Very sprayable viscosity at 75° F.
- Excellent water/weather resistance and protection for iron, steel and wood.
- Superior wetting provides secure adhesion & forgiving application.

LIMITATIONS:

- Low temperatures will *greatly* increase viscosity.
- This product is for industrial use and may not conform to air quality regulations for use or architectural surfaces.
- No corrosion inhibiting pigmentation; direct application to iron and steel does not provide resistance to "undercutting" from scraped or otherwise bare metal.
- Wood and galvanized must be primed.
- Not recommended for surfaces subject to continuous submersion or direct contact with chemicals.
- All alkyds chalk with exterior exposure; normal gloss retention is some chalking after 18 – 24 months, chalking to flat with 4 – 5 years full exposure, loss of film integrity at 5 – 7 years.
- Not compatible with urethane "hardeners".

PHYSICAL PROPERTIES

VOC: [as packaged] ..... 400 g/l – (3.3 lbs./gal.)

APPEARANCE: [Gloss at 60°]

Gloss (G) ..... Above 85
Semigloss (S) ..... 45 – 60

WEIGHT PER GALLON: [average] ..... 10.7 lbs.

FLASH POINT: [setaflash] ..... 108° F.

PACKAGE VISCOSITY: ..... 75 – 80 KU

SOLIDS: [average]

By Weight ..... 68 ± 1 %
By Volume ..... 52 ± 1 %

COVERAGE: [average]

Theoretical at 1 mil DFT ..... 835 sq.ft./gal.
Theoretical at 1.5 mils DFT ..... 556 sq.ft./gal.
Required Minimum DFT ..... 1.5 – 2 mils
Recommended DFT per coat ..... 1.5 mils

DRY SCHEDULE: [at 50% RH and 1.5 mils DFT]

	45° F.	*60° F.*	*75° F.*	*90° F.*
Touch	3 hrs.	2 hrs.	50 mins.	40 mins.
Handle	5 hrs.	3 hrs.	1½ hrs.	1¼ hrs.
Recoat	24 hrs.	12 hrs.	6 hrs.	4 hrs.
Hard Cure	48 hrs.	30 hrs.	24 hrs.	24 hrs.

COLOR AVAILABILITY:

Bakote is packaged in black, white, the OSHA Safety Colors (except Radiation Purple) and four traditional industrial colors: ANSI #61 Gray, a dark green, blue and a dark gray. **35G** series is also packaged in a full line of bases designed for field or store tinting with Colortrend 888 "Universal" Colorants and 844 "Industrial" (solvent only) Colorants. Factory batch production available with min. 25 gallon orders. All colors are lead and chromate free.

ORDER CODE: ..... 35 + gloss + color #

Individual products are identified by the product series number, followed by a gloss identifier (G=gloss, S=semigloss) and ending in the color number For example, 35G700 is **Bakote** (35) gloss (G) White (700).

PACKAGING: [average]

Six ea. 1 quart cans per case ..... 20 lbs.
Four ea. 1 gallon cans per case ..... 50 lbs.
One ea. 5 gallon metal pail ..... 60 lbs.

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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Surface and ambient temperatures must be between 42° F. and 95° F. and minimum 5° F. above dewpoint for normal application. Special procedures required from 28° F. to 42° F. and 95° – 115° F. Secure procedures from Triangle representative.
- Surfaces must be free of moisture, corrosion (flash rust OK), oils, loose paint, dirt, all forms of silicone, waxes, etc. SSPC-SP1, SP2 or SP3 as minimum.
- Performance over mill scale cannot be predicted. All scale should be removed.
- Enameled surfaces must be abraded to dull.

PRIMING:

Reference Tech Advisory 1 & 3 for a complete review of recommended primers and options.

Iron & Steel ..... 903 Bakote Primer
Galvanized ..... 938 AquaMAX Primer
Wood ..... 292 Apex Primer

FILM DEVELOPMENT:

Optimum dry film thickness is 1.5 mils per coat. Use one coat over primed or previously painted surfaces, two or more coats over bare metal. However, without reduction it is difficult to apply VOC compliant alkyds that thin. Typical, acceptable DFTs range between 1.75 and 2.0 mils. Maximum recommended wet film thickness is 4 wet mils unreduced or 2 mils DFT. Thicker films surface dry, are less durable and have no benefit. Unreduced, **Bakote** applied at 525 sq.ft./gal. over smooth, sealed surfaces will produce a 1.50 mil DFT and allow for 3% waste (1.75 mils DFT = 450 sq.ft./gal.).

RECOMMENDED THINNING: ..... Not required

Maximum Thinning Allowed By Regulation:

420 g/l ..... Thin up to 5 fl.oz./gallon
500 g/l ..... Thin up to 32 fl.oz./gallon

Thinner: ..... Xylene

In unregulated areas a 0 – 15% reduction with mineral spirits is recommended for brushing. A 15 – 25% reduction with xylene is recommended for conventional or HVLP spray.

VOC regulations vary by state and county. Contact Triangle representatives directly for guidelines and recommendations.

APPLICATION:

Bakote is designed for brush and spray application. Rolling will produce a roller texture and may cause bubbling. Mitts are recommended for pipes. Where brushing is required, the use of Chinese bristle brushes will hold the most paint, drip less and apply a smoother finish. Apply as necessary for complete coverage and finish with light vertical strokes. Use airless spray for large surface maintenance, and conventional, HVLP or air assist airless for shop finishing. HVLP or conventional for field finishing. NIOSH respirators, hoods and gloves are recommended when spraying.

Airless: ⅓ gpm pumps or larger; .013 – .015 tips.

Air Assist Airless: Maximum fluid pressure possible to 2,000 psi; .011" tip and air pressure as necessary to eliminate tails or orange peel.

HVLP: .040" – .055" fluid nozzles (1.0 – 1.4 mm), fluid, pressure as needed for 6" stream without air cap, air to gun 60 – 80 psi and 16 – 18 CFM, air cap pressure, 10 psi.

Conventional Spray: Fluid nozzle .040" – .050"; air cap appropriate for available air, feed (pressure or siphon) and spray viscosity. Typical psi with pressure feed. 20 – 40 fluid, 60 – 80 air.

CLEANUP: ..... AT17 Wash Thinner

Rinse with mineral spirits. Xylene or lacquer thinner can be substituted for AT17.

SAFETY AND HANDLING

FLASH POINT: [setaflash] ..... 108° F. (42° C.)
SHIPPING DESCRIPTION: [CFR 49].
Domestic Ground: ..... Not regulated
Air/Vessel: ..... Paint, 3, UN1263, PG III
Required Label: ..... FLAMMABLE LIQUID
Required Marking: ..... PAINT UN1263
IMDG PACKAGING:
FLAMMABLE LIQUID, class 3.3, UN1263, III
IMDG STOWAGE: ..... Category A
UNIFORM FIRE CODE: [CFR 29] ..... CLASS II
STORAGE TEMPERATURE: ..... 120° F. max.
SHELF LIFE: [warranted] ..... 1 Year
"HMIS" RATINGS: ..... **H** - 2; **F** - 2; **R** - 0; **PP** - H

(05/12/99)

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