SEMI-FLAT BAKING ENAMEL
RTB-1204

A single-pack, semi-flat baking finish coat with excellent adhesion, outdoor stability and mechanical resistance as well as anti-corrosive properties.

USES AND SUITABLE TOP-COATS

Recommended Uses	Top-coat or single coating system for industrial products such as electrical and electronic equipment cases, steel furniture and metallic finished goods.
Suitable Top-Coats	RTB-1204 can be over-coated by RTB-1205 (Gloss Baking Enamel).

CHEMICAL COMPOSITION

Type of Binder	Melamine – Alkyd Resins	Solid Content	68 ± 1% By Weight
Number of Component(s)	1 Component		49 ± 2% By Volume
Curing Mechanism	Thermosetting	Flash Point	29°C (84°F)

PHYSICAL PROPERTIES

Finish	Semi flat
Colour	Wide range available according to the RAL and BS colour systems.
Specific Gravity	1.35 ± 0.05 gr/cm³

APPLICATION DETAILS

Surface Preparation: All oil, grease, dirt and other contaminants must be removed from the surface. Degreasing and chemical preparation or wire brush is recommended.

Theoretical Consumption: 110 gr/m² @ 40 Microns DFT

Paint Application

Methods	Airless Spray	Air Spray	Brush	Roller
Nozzle Size	0.009" – 0.013"	1.80 mm	---	---
Pump Ratio	1 / 28	---	---	---
Air Pressure	4 – 6 Bar	3 – 4 Bar	---	---
Thinning	5 – 10% T-1206	10 – 20% T-1206	3 – 5% T-1206	3 – 5% T-1206

Film Thickness

	Recommended	Minimum	Maximum
Wet Film Thickness (µm)	80	50	100
Dry Film Thickness (µm)	40	25	50

Baking Conditions

Flash-Off Time	5 – 10 Minutes at Room Temperature
Stoving Time	30 Minutes at 120°C or 20 Minutes at 150°C

Application Limits

Relative Humidity	Min. ---	Max. 80%
Temperature	Min. +5°C	Max. +40°C
Substrate Temperature*	Min. +5°C	Max. +45°C

**Please note that the substrate temperature should be at least 5°C above the dew point*

Recommendations: Clean tools thoroughly before and immediately after use with cleaning solvent T-111, T-726 or T-1206.

PACKING, STORAGE AND SAFETY

Packing: 20 Litres Containers (25 kgs. Net)

Storage Conditions: To be stored in cool and dry conditions in original sealed containers. Keep away from direct sunshine.

Shelf Life: At least 12 months after delivery in original sealed containers and proper storage conditions with temperature of 25°C.

Safety: This product contains organic solvents and flammable materials. Keep away from sparks, fires, electrical cables and equipments,direct sunshine and out of children's reach.

Protect skin, eyes, and avoid prolonged breathing of solvent vapor during application. Use with adequate ventilation.