

# P-1046

## Bake Enamel Wrinkle Coating



**Product** P-1046 Bake Enamel Wrinkle Coating

**Item Class** Specialty Coating

P-1046 is a bake dry, general-purpose wrinkle finish for aerospace applications.

**Specifications** Product is manufactured to meet the performance requirements of the following specifications:

MIL-P-5558A

**Surface Preparation** Prepare substrate per OEM requirements. Contact your local 3Chem representative or distributor for assistance.

**Mixing Instructions**

<b>Single Component</b>
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Shake product 10-15 minutes.

**Spraying Viscosity** 18-24 Seconds with #2 Zahn cup

**Film Thickness** 2-4 mils DFT. Wet film thickness should be 5 – 7 mils total

### Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

#### Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi

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### **Application Instructions**

Preheat oven to 275-325° Fahrenheit. Apply product using conventional or HVLP spray method per table above. Bake coated substrate for 2-2.5 hours then allow oven to return to room temperature before removing painted component. 3Chem recommends spraying a test panel to confirm desired finish is achieved. Applicator's expertise and baking conditions will dramatically affect wrinkle and gloss finish.

**Color** Black

**Volatile Organic Compound** 400-420 g/l

**Shelf Life** 24 Months (When stored in climate-controlled environment between 60-80° F)  
\*Product may be re-certified upon inspection by 3Chem.

**Safety Instructions** Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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**PRODUCT TECHNICAL DATA SHEET**

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