

P-1066

Bake Enamel Wrinkle Coating



Product P-1066 Bake Enamel Wrinkle Coating

Item Class Specialty Coating

P-1066 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

Single Component	Thinner (Optional)
P-1066	CM100

Shake product 10-15 minutes. Material may be reduced to desired viscosity using 3CHEM thinner CM100, using caution as use of solvents will increase VOC. Only use enough thinner to achieve desired atomization of product. Use of thinner is optional and not required.

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 Gloss Gray FS 16473

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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866-324-3666