



NATIONAL CAN COATING BUFF LACQUER (2004) (FOOD GRADES)
PROTECTIVE COATINGS

TECHNICAL DATA SHEET

**NATIONAL CAN COATING BUFF LACQUER (2004)
(Food Grades)**

PRODUCT DESCRIPTION	High quality Buff lacquer for food cans based on epoxy phenolic system. It is tested according to 21 CFR 175.300 of the US FDA Regulations.
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RECOMMENDED USES	Flexible, sterilization resistance lacquer for internal and external 3-piece food cans bodies and ends.
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TECHNICAL DATA

COLOUR, DRY FILM	Buff
FINISH, DRY FILM	Smooth and Glossy
SOLIDS BY WEIGHT	47 ± 1%
SPECIFIC GRAVITY	1.20 ± 0.05
VISCOSITY (FCB4 CUP)	130 ± 10 sec. @ 30°C
FLASH POINT	28°C
RECOMMENDED FILM WEIGHT	
DRY	6.0 – 8.0 g/m ²
WET	12.76 – 17.00 g/m ²
SUBSTRATE	Tinplate, TFS (ECCS)

CURING DETAILS

REQUIRED PMT	180 – 200°C
TIME AT PMT	
MINIMUM	10 Minutes
MAXIMUM	12 Minutes

Oven air temperature must be set to achieve the specified PMT's where applicable

ADVANTAGES

NATIONAL CAN COATING BUFF LACQUER (2004)	High quality can coating for 3-piece food cans. Dried film has excellent mechanical and tooling properties.
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APPLICATION DATA

APPLICATION METHOD	Roller
THINNER	Ready to use.
EQUIPMENT CLEANER	National Lacquer Thinner
CURE TYPE	Sheet oven
COATING PREPARATION	Supplied ready for use. Coating must be stirred for 1 hour before use.
ADDITIONAL INFORMATION	Two coats required to give maximum chemical resistance.

Coating spillages should be cleaned up before the coating has dried up.

STORAGE DETAILS

SHELF LIFE @ 25°C	6 months, in original sealed container with proper storage conditions. Protect from excessive humidity.
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HEALTH & SAFETY

SAFETY PRECAUTIONS	As a general rule, avoid skin and eye contact by wearing overalls, gloves, goggles, and solvent mask etc. Spillage on skin should immediately be removed by thorough washing with water and soap or suitable cleaner. Eye should be flushed with fresh water. Avoid inhalation of vapours and paint mist by wearing suitable mask. In the event of ingestion and eye contact, seek medical attention immediately. Painting must be carried out in well-ventilated area. This product contains flammable materials and should be kept away from the sparks and open flames, smoking in the area should not be permitted. Local safety regulations should be followed.
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STORAGE & HANDLING

STORAGE	Store the paint in proper storage conditions as per the local regulations. Keep the paint container in sealed condition under shed, away from direct sunlight and extreme temperatures. Do not stock paint material near to any ignition sources. Do not put back the half or unused material back in original container, containing the supplied paint, to avoid contamination. Handle with care. Stir well before use.
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NOTE: We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests. We reserve the right to change data without prior notice. For surface preparation, safety details refer specifier and safety data.

This data sheet supersedes all previous issued.
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