



NATIONAL CAN COATING PIGMENTED BUFF LACQUER (1004)  
PROTECTIVE COATINGS

TECHNICAL DATA SHEET

## NATIONAL CAN COATING PIGMENTED BUFF LACQUER (1004)

<b>PRODUCT DESCRIPTION</b>	A modified epoxy-phenolic based pigmented buff lacquer. It has good chemical resistance
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<b>RECOMMENDED USES</b>	Internal for 3-piece general line cans.
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### TECHNICAL DATA

<b>COLOUR, DRY FILM</b>	Buff
<b>FINISH, DRY FILM</b>	Smooth and Glossy
<b>SOLIDS BY WEIGHT</b>	52 ± 2%
<b>SPECIFIC GRAVITY</b>	1.20 ± 0.05
<b>VISCOSITY (FCB4 CUP)</b>	140 ± 10 sec. at 30°C
<b>FLASH POINT</b>	28°C
<b>RECOMMENDED FILM WEIGHT</b>	
<b>DRY</b>	9.0 – 11.0 g/m <sup>2</sup>
<b>WET</b>	18.0 – 22.0 g/m <sup>2</sup>
<b>SUBSTRATE</b>	Tinplate

### CURING DETAILS

<b>REQUIRED PMT</b>	180 – 200°C
<b>TIME AT PMT</b>	
<b>MINIMUM</b>	10 Minutes
<b>MAXIMUM</b>	12 Minutes

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

### ADVANTAGES

<b>NATIONAL CAN COATING PIGMENTED BUFF LACQUER (1004)</b>	High performance can coating for interior application. It has an excellent mechanical properties and superior solvent resistance.
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**APPLICATION DATA**

<b>APPLICATION METHOD</b>	Roller
<b>THINNER</b>	National Lacquer Thinner
<b>EQUIPMENT CLEANER</b>	National Lacquer Thinner
<b>CURE TYPE</b>	Sheet oven
<b>COATING PREPARATION</b>	Supplied ready for use. Coating must be stirred for 1 hour before use.

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

**STORAGE DETAILS**

<b>SHELF LIFE @ 30°C</b>	6 months, in original sealed container, with proper storage conditions. Protect from excessive humidity.
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**HEALTH & SAFETY**

<b>SAFETY PRECAUTIONS</b>	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**

<b>STORAGE</b>	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.  
 Issued: 0608

