

Stokes Low Bake Stoving Finish

Product Description	Modified alkyd/amino resin gloss finish for metal fabrications.			
Features & Use	<ul style="list-style-type: none"> • Low temperature curing system • Short stoving schedules allow for fast production • Designed for use with Stokes Low Bake ZP Primer to produce a highly decorative, hard wearing system • Use for all types of metal fabrications and tools 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Gloss			
Volume Solids	45 ± 2% (varies with colour)			
VOC Content	467 ± 20 g/litre (varies with colour)			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	30 µm	67 µm	15 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 30 microns DFT			
	Stoving schedule	20 min @ 100°C metal temperature		
	For other stoving schedules, please consult Axalta Coating Systems			
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
Colours	Shades to customers' requirements			
Product Code	20LOW-			
SG	1.19 kg/lt (varies with colour)			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 12 months if stored as above in unopened containers			
Flash Point	23-60°C			

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Surface Preparation	<ul style="list-style-type: none"> This product is a finish coat and should be applied over an appropriate primer such as Stokes Low Bake ZP Primer All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination 														
Mixing	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.														
Thinner	No.4 or TH035 Thinners		Equipment Cleaner No.4 or TH035 Thinners												
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="419 831 675 904">Method</th> <th data-bbox="675 831 903 904">Airless Spray</th> <th data-bbox="903 831 1166 904">Conventional Spray</th> <th data-bbox="1166 831 1339 904">Brush</th> <th data-bbox="1339 831 1487 904">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 904 675 958"></td> <td data-bbox="675 904 903 958">Yes</td> <td data-bbox="903 904 1166 958">Yes</td> <td data-bbox="1166 904 1339 958">No</td> <td data-bbox="1339 904 1487 958">No</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No				
Method	Airless Spray	Conventional Spray	Brush	Roller											
	Yes	Yes	No	No											
<ul style="list-style-type: none"> Conventional and Airless spray: thinning may be required Dipping: thin as required Brush: not recommended other than for small areas of touch-up 															
Product Notes	<ul style="list-style-type: none"> Designed to be applied over Stokes Low Bake ZP Primer Good resistance to most hot and cold lubricating oils. Tests for suitability for any particular oil should be carried out before application Heat resistant up to 150°C 														
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.														

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