Product Description

Chem-Bake® One Step 4:1 Low VOC is a 2 component hi-solids acrylic polyurethane finish with excellent color and gloss retention. It is designed as a self-priming system for repainting prefinished metal surfaces including SMP coil coated sheet metal used in rolling steel doors, roofs, gutters, and metal siding. It can also be used as a DTM (direct to metal) finish on steel. High-Gloss finish. Requires activator.

Key Benefits

- Low VOC, meeting all California VOC standards
- Exterior applications
- Direct to metal applications
- Self-priming on many substrates
- Excellent colorfastness and gloss retention
- Excellent exterior durability
- Good flexibility
- Good flow and leveling
- Available in many colors

Product Characteristics

Color	40+ Standard. Unlimited custom
Finish	High Gloss (90+ GU @ 60°)
Resin	Acrylic Polyurethane
Solids by Volume	57% ± 2%
Solids by Weight	65% ± 2%
Weight Per Gallon (mixed)	10-12 lb/gal
VOC (mixed excluding exempts)	74 g/L = 0.62 lbs/gal
VOC (mixed including exempts)	46 g/L = 0.38 lbs/gal
Viscosity	20 - 40 seconds BYK Zahn Cup #3 @ 78°F
Components	Two
Pot Life	1 -2 hours
Flash Point	-4°F TCC
Packaging:	Short fill 1 gallon can, short fill 5-gallon bucket
Storage:	Store indoors at 45°F - 120°F. Protect from freezing.
Shelf Life:	1 year from date of manufacture in factory sealed container.

Theoretical Coverage Rate Per Gallon

	Maximum	Recommended
Sq ft coverage rate per gallon	365	305
Wet mil film application rate (mil)	4.38	5.25
Dry mil film thickness achieved (mil)	2.50	3.00

Film builds below 2.5 mils total DFT will not provide maximum film properties. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, or method of application. Actual coverage may vary.

Drying Schedule @ 4.5 mils wet

Drying Schedule @4.5 mils wet *Tiempo de secar @4.5 mils mojado*

Applied @ 50% RH		**78°F**	**90°F**
To touch	*-seco al tacto*	3 hours	2 hours
To handle	*-seco al manejo*	8 hours	6 hours
To recoat	*-para recubrir*	5 hours	3 hours
To full cure	*-curado total*	7 days (depending on ambient conditions)	
Pot Life	*-vida útil*	2 hours	1.5 hours
Induction Time	*-tiempo de inducción*	N/A	N/A
Activation	*-activación*	X67HP-CLE38405	

Important: product dries to handle in 8 hours but requires 7 days for full adhesion / curing. If finish is scratched before product is fully cured peeling may occur. Masking must be removed or a razor blade used to cut along edge as soon as possible or coating may adhere to masking.

Application Conditions

Do not apply if the application surface or ambient temperature is below 55°F (13°C) or above 100°F (38°C), or if the atmospheric temperature is within 5°F of the dew point. Relative humidity should be below 85%. Do not apply when there is a risk of rain or freezing temperatures within 12 hours after application. Do not apply within 2 hours of sunset if the temperature is below 60 degrees.

Recommended Uses

Designed as a coating for repainting prefinished metal surfaces including SMP coil coated sheet metal that is used in the manufacturer of rolling steel doors, roofs, gutters, and metal siding.

- Self Storage Facilities
- Repainting interior or exterior metal wall systems.
- Premier refinish system for roll-up doors
- Gutters, downspouts and trim
- Swing Doors

Not Recommended for:

- Immersion service
- Floors
- Direct application to rusted surfaces

Recommended Substrates

- Previously painted surfaces
- Primed steel
- Aluminum
- Galvanized metal
- SMP coil coated steel

Compatibility with other Coatings

Compatible with most coating types. It may be used over most aged and hard-cured coatings in good condition. Can be used overtop all Endura-Clad & Chem-Bake primers. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings.

Surface Preparation

The service life of the coating is directly related to the surface preparation. Surfaces to be painted should be clean, dry and free from wax, grease, dust, silicone, oil and excessive chalk. Do not use hydrocarbon solvents for cleaning. If solvent cleaning is required use acetone.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Seal stains from water, smoke, ink, pencil, grease, etc. with the appropriate primer/sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Existing Painted Surfaces: Remove all oil, dust, grease, dirt, chalk, rust, loose or peeling paint and all foreign matter. Scrape and sand peeled or checked paint to a sound surface. Steel rust and mill scale must be removed using sandpaper, wire brush, or other abrading method. Bare steel must be primed the same day as cleaned. Glossy or smooth hard surfaces should be dulled and/or abraded using Zap-It! Chalk & Grime Buster, abrading brushes, silicon carbide sandpaper, Scotch-Brite® or other abrading medium to create a surface profile.

Aluminum and Galvanized Steel: Can be applied over properly prepared surfaces.

Masonry, Concrete, Block, Stucco: Not Applicable.

Wood, Plywood, Composition Board: Not Applicable.

Mildew: Prior to attempting to remove mildew, it is recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised. Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach/water solution.

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

Mixing & Reduction

Mixing: Chem-Bake One Step is a two-component product. Use X67HP-CLE38405 activator. Mix contents of each container in a strict **4:1 ratio**. 4 parts paint to 1 part activator. Additives may be needed to optimize product for specific requirements.

Thinning: Thinning not required but if desired, use up to 5% reducer grade acetone.

Application Instructions

Airless Sprayer: Recommended. Use spray equipment that delivers paint at an even consistent pressure without “surge”. The sprayer, hoses and gun must be thoroughly clean and flushed with solvent. Always use a hose that is dedicated for spraying solvent based coatings, separate from spraying water-based products. Spray with the least amount of pressure that still atomizes the paint properly. Recommended tip size and type: .010 -.014 fine finish.

When spraying use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle. Application in two light coats is generally better than one heavy coat.

Roller: High quality 1/4” - 1/2” nap non-shedding

Brush: High quality Nylon or Nylon/Polyester

When rolling, add 1 oz. per activated gallon of 9M05 Rolling Thinner to reduce bubbling. Any thinning may hamper ability to achieve high film builds and may cause sagging. Application by brush or roller may require additional coats to achieve recommended dry film thickness. Once rolling thinner is added, product CANNOT be sprayed.

NOTE: Airless sprayer is strongly recommended. Brush or roll applications may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Clean-Up

Clean spills and spatters immediately with acetone. Clean hands and tools immediately after use with acetone or lacquer thinner. Never leave material in equipment when not in use. Dried paint film, spray

equipment, and mixing equipment can be cleaned by soaking and scrubbing with acetone.

Safety & Handling

For use by trained professional personnel only. Before use, read and follow all label directions, Technical Data Sheet (TDS) and relevant Safety Data Sheets (SDS). Refer to the product's Safety Data Sheet (SDS) for complete safety information.

Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. When handling, mixing, or spraying, wear a properly fitted NIOSH-approved respirator with organic vapor cartridges as needed. See SDS for TLV information. Contents are FLAMMABLE. Keep from heat, sparks or open flame. Allergic reactions are possible. Avoid use by people with respiratory problems. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling. If swallowed, do not induce vomiting and get medical attention immediately.

Skin Contact: May cause irritation. Wear chemical-resistant gloves and protective clothing. Wash exposed skin thoroughly with soap and water. Launder contaminated clothing before reuse. If irritation persists, seek medical attention.

Eye Contact: Can cause irritation. In case of contact, flush eyes with water for at least 15 minutes and seek medical attention.

Mixtures: If the product is mixed with other components, all associated hazards apply to the mixture.

General Precautions: Keep out of reach of children. Apply only in well-ventilated areas.

Cured Product: Once fully cured, this product is considered non-hazardous.

Warranty

All products are warranted to be free of manufacturing defects. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Published technical data and instructions are subject to change without notice.