



Gillespie Coatings, Inc.
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G.C.I. PRODUCT DATA SHEET 713 SERIES ALKYD BAKING ENAMEL

DESCRIPTION	A full gloss Alkyd/Melamine Baking Enamel
CHARACTERISTICS	<ul style="list-style-type: none">- VOC and HAPs compliant coatings- High gloss baking enamel with outstanding service- Excellent gloss retention- Direct to metal baking- Good single coat protection- Good exterior durability- Single component system- Contains no Lead or Chromate pigments- Broad range of colors available- Typical uses <p>Production baking enamel Enhance appearance of finish and protection</p>
GLOSS AND COLOR	High gloss finish 95°+ on 60° gloss meter Semi-gloss / Matte finishes available
PHYSICAL DATA	
Vehicle	Alkyd / Melamine
Pigment type	Prime pigments selected for exterior applications
Solvent type	Compliant mixed solvent blend
VOC	3.1 – 3.9 lbs. per gallon - (Varies with color)
Weight per Gallon	8.3 lbs. to 9.6 lbs. /gallon (Varies with color)
Flash point	78° F
Recommended	
Dry film thickness	One Coat: DTM 1.5 – 2 mils DFT Two Coat: 1.5 – 2 mils DFT over a primed surface
Theoretical spread	
Spread rate	620ft ² at 1 dry mil (Coverage will vary with color)
Volume solids	35%-42% (Varies with color)
Volume weight	44%-57% (Varies with color)
Viscosity	50 ± 5 Ku @ 78°F
SPECIFICATIONS	
Baking schedule	Flash off time: 5 to 10 minutes Bake time: 30 minutes @ 275° F

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Performance	Adhesion Test (ASTM D3359) classification 5B, no failure Minimum film Hardness (ASTM D3363) minimum film hardness of B – pencil test Salt Spray (ASTM B117) pass 300 hours
Package Life	Shelf life is 3 years from the date of manufacture.
Limitations	Not for severe service including: acid or base conditions, continuous temperatures above 250° F, or prolonged water immersion.

APPLICATION

Application Method	Spray – Designed for Ransburg spray systems Spray – Airless/Conventional	
Surface Preparation	Coatings performance is dependent upon surface preparation. Surface must be clean, dry and free from all oil, grease, rust, dirt, dust, or other foreign material.	
	Direct to Metal (DTM) Steel – metal preparation SSPC 6	
	Primed substrate Surface must be clean, dry and free from all oil, grease, dirt, dust or other foreign material.	
Recommended Primer	None; for two coat requirements, use GCI PR-9001 Baking Primer.	
Mixing	Paint must be thoroughly mixed to a uniform consistency with a low speed air powered or explosion proof power agitator prior to use.	
Application Equipment	For proper spray characteristics, changes in pressure, flow rate and type size may be needed dependent upon type of equipment used.	
	Airless pump ratio 30:1 Non-cycling, air pressure to pump, approximately 40 - 50 psi Tip pressure approximately 1200 psi Tip size: .013-inch to .015-inch	
Film Thickness	Direct to Metal (DTM)	Minimum / Maximum
	Wet mils	3.5 mils 4.5 mils
	DFT mils	1.5 mils 2 mils
	Primed surface	Minimum / Maximum
	Wet Milis	3.5 mils 4.55 mils
	DFT Milis	1.5 mils 2 mils

G.C.I. PRODUCT DATA SHEET

713 SERIES ALKYD BAKING ENAMEL

Film thickness below minimum or over maximum may degrade coating performance

Recommended Thinner None recommended with Ransburg spray equipment using inline heater.

Airless Spray - Normally no thinning is required. Under certain conditions use of GCI ES-2 to obtain proper atomization.

Application conditions Coatings material must be above 50° F before use. Air and substrate surface temperature must be above 50° F

Surface temperature must be a minimum of 5° F above dew point to prevent condensation formation
Do not apply when humidity is high and condensation is possible

Clean Up: Clean equipment and tools immediately after use with GCI ES-2Xylene.

All surplus materials and empty containers should be disposed of according to regional regulations

PACKAGING Five gallon size container

SHIPPING DATA DOT Name Paint
UN Number UN1263
Hazardous Class 3, Flammable Liquid
Packing Group PG III

CAUTION STATEMENT

WARNING - Flammable Liquid FOR INDUSTRIAL USE ONLY

GCI 713 Series coatings are flammable. Keep away from open flames and heat. Use adequate ventilation. Avoid contact with skin and breathing of vapors or spray mist. Improper use and handling of this product can be hazardous to health and cause fire.

The information and instructions provided in this Product Data Sheet are subject to change without notice. Consult your Gillespie Coatings representative to obtain the most recent information.

Gillespie Coatings, Inc. is responsible for technical accuracy and conformation to GCI specifications.