



PERM-EPOX™ #550
EPOXY BAKE COATING
SERIES E550

SANDSTROM
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DESCRIPTION

Perm-Epoxy #550 is a single component epoxy bake system formulated to provide hardness, fluid, and chemical resistance.

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS) and Technical Data Sheet.

OUTSTANDING FEATURES/BENEFITS

- Quick Dry
- Resistance to Solvents, Chemicals, Abrasion, and Impact

COMPOSITION AND PHYSICAL PROPERTIES			
Net Weight per gallon	lbs./gallon (Theoretical)	Vehicle	Epoxy
Weight Solids	30.0-50.0% Depending on Color	Lubricating Pigment	None
Volume Solids	25.0-35.0% Depending on Color	Color	Red, White, Blue, Purple, Pink
VOC	4.80-5.20 lbs./gallon Depending on Color	Color Stability	Not for exterior use
Odor	Strong Solvent	Finish	Varies with color
Shelf Life	12 Months from Date of Shipment	Coverage Rate*	400 – 500 sq. ft./gallon @ 1 mil DFT
Storage Conditions	<100 °F	Recommended Coats	1, or 2 if Dip Spin applied
Freeze/Thaw Stability	Stable	Dry Film Thickness	.5 – 1.0 mils
Flash Point	<-5 °C/ 23 °F		
*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.			

PERFORMANCE AND FUNCTIONAL PROPERTIES			
MEK Solvent Resistance ASTM D5402	100+ MEK Double Rubs		

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY
 We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders or other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY

This product is currently designated in 'Commercial Product Development' stage. Depending on market conditions and product acceptance, this product may or may not be manufactured as a commercial product available to our customers. The final properties and specifications are subject to change from this current printed data sheet. Should the product be released for commercialized sale, the product name will change.

GENERAL

This coating consists of coloring pigments dispersed in a thermosetting resin system thinned with appropriate solvents and additives. For maximum coating performance, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

FILM THICKNESS & ENGINEERING TOLERANCE

Once thinned according to instructions, this product will yield a film thickness of about .3 – 1.0 Mil per spray application.

COVERAGE

One gallon of this material will cover 400- 500 sq. ft. with a dry film thickness of 1.0 Mil. Coverage depends upon methods of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION

Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

Application on steel. Pre-clean the steel surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 180-220 grit aluminum oxide (25-50 RMS optimum). Phosphate IAW MIL-DTL-16232 (weight should be 11-22 g/m²), type M, class 3 or type Z, class 3.

Application on stainless steels. Pre-clean the steel surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 120 grit aluminum oxide (25-50 RMS optimum). Passivate the surfaces with ASTM A967, types nitric 1, nitric 2 or nitric 3, as applicable.

Application on aluminum and aluminum alloys. Pre-clean the aluminum surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sulfuric acid anodize IAW MIL-A-8625 and seal the surface.

Application on titanium and titanium alloys. Degrease the surfaces to be coated with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surface with 180-220 grit aluminum oxide (25-50 RMS optimum) and alkaline anodize.

Application on copper and copper alloys. Pre-clean the copper surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 180-220 grit aluminum oxide (25-50 RMS optimum). Form a black oxide finish on the surfaces.

IMPORTANT! DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION. Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING

IMPORTANT! THIS COATING CONTAINS PIGMENTS WHICH COULD SETTLE. THEREFORE, IT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING USE.

THINNING**APPLICATION**

For conventional spraying – For fast dry, reduce up to 2 parts coating to 1 part Sandstrom D152 Thinner Blend. For ultra-fast dry, reduce up to 2 parts coating to 1 part Sandstrom D169 Thinner Blend.

For dipping - reduce up to 2 parts coating to 1 part Sandstrom D169 Thinner Blend.

DRYING

Allow the surface to dry at least 30 minutes before baking at 77°F ± 5°F and ≤ 70% relative humidity before baking.

BAKING

20 minutes @ 300°F

IMPORTANT! The time starts when **the part** reaches temperature, not when placed in a Class A oven.

CLEANUP

Use the same solvents for cleaning tools as recommended for thinning or use MEK.

REMOVAL

In the event it is necessary to remove Perm-Epoxy #550, physical removal is best (such as grit blasting, sanding or grinding).

WARNINGS: Constant stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY

We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders or other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY

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