



# TECHNICAL DATA SHEET

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AMS 2503 GLOSS BLACK  
LOW BAKE ENAMEL  
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**PRODUCT:** A high gloss, single component, low temperature baking enamel formulated for interior and exterior metal surfaces.

**PROPERTIES:** COLOR.....#17038 GLOSS BLACK  
GRIND..... 7 Minimum  
SPECULAR GLOSS..... 80 Minimum

**BAKING SCHEDULE:**

- 1. AIR DRY: 30-45 minutes
- 2. BAKE: 45-60 minutes @ 200 - 225 degrees Fahrenheit

**ADVANTAGES:** (1). Interior / Exterior Use  
(2). High-Gloss Finish  
(3). Low Bake Schedule

**USES:** (1). Steel  
(2). Machinery  
(3). Tanks  
(4). Equipment



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## APPLICATION & REDUCTION:

AMS 2503 Low Bake Enamel can be applied by brush or spray. It is designed primarily for spray application; however, small areas can be brushed if necessary. Thin with Xylene or MIL-T-81772B Ty. III Thinner at 10-15% by volume for spray and brush applications. Spray one tack coat followed by one full wet coat. Allow part to air dry for 30-45 minutes at room temperature (75 degrees Fahrenheit). **Pre-heat** oven to 200-225 degrees Fahrenheit, place part in oven and bake for 45-60 minutes.

## SURFACE PREPARATION:

Surface must be properly prepared, clean, dry and free of all contamination before application.

## STEEL:

Surface must be clean and free of all oil, grease and foreign material. Badly rusted or pitted steel should be cleaned by commercial sandblasting and primed the same day. Wood surfaces must be sanded and primed before application of enamel.

## PRECAUTIONS:

Contents are FLAMMABLE.  
Keep away from heat and open flame.  
KEEP OUT OF THE REACH OF CHILDREN.  
Do not take internally.  
Avoid breathing vapor or mist.  
Do not use in tank or pit without proper protection.  
Read Material Safety Data Sheet before use of this product.