
Product Name: Rockhard Clear Stoving Enamel & Microporus Casting Sealer

Product Number: 576-450-002

Product Description:

Known sometimes as '961' Baked Resin, Rockhard Clear Stoving Enamel has proved its worth over 4 decades as one of the best protective coatings for metals to erosion, corrosion, including salt water and chemical resistance at elevated temperatures particularly on Aluminium and Magnesium and as such is recommended by Magnesium Electron, the leading supplier of Magnesium in the UK.

Rockhard is used in many industries, for example Volvo air intakes, coating turbine blades, computer chassis for insulation purposes, heat exchangers and radiators where it has enabled Aluminium to replace Copper in some applications. It is acknowledged as a leading product for curing micro-porosity used on engine blocks and turbo pipes etc.

Its history includes protection of the Magnesium skins of the Westland Wessex Helicopter and parts of the Comet Jet liner. Since then it has been widely used in the aircraft industry where maximum protection is needed on Aluminium, Steel, Titanium and Magnesium, in marine and other harsh environments. Amongst the latest organisations to approve this product are Sikorsky for use on their AH 60 helicopter, McDonnell Douglas on their MD 500 range, and Pratt and Whitney Canada on their PT6, PT100 and 4000 range. In February 1995, GE approved this Hannifin (Nicholls Aircraft Division) on the G 4461 model.

Approvals/Specifications:

- DTD5562
- OMat 7/146
- Previous Code: 444 / 176
- P&W Canada: CPW 489
- CPMC 79964
- 07-017
- PWA 36490

- PWC 10183
- CPW 489
- GE: A8B84 S
- Boeing: D210-13512-1
- Sikorsky: SS8688
- McDonnell Douglas: HP 4-133
- Williams International: CP4240
- Hamilton Sunstrand: HS 4675
- Allied Signal (Textron): FP5109, P6426, P640
- Parker Hannifin (Nichols Aero Engine Division): MCS145
- Honeywell-Allied Signal: FP5109
- Hamilton Sunstrand San Diego: ESR 1187
- McDonnell Douglas (Boeing): HP 4-133
- Pratt & Whitney Aircraft: PWA 36490
- General Electric Aircraft Engines: P6D2
- Nichols Aircraft Parker Hannifin: MCS-145
- Williams International: CP4240

Performance:

Tested to DTD 5562, which includes 6 months intermittent salt spray (Def 1053, Method 36). Resistance to humidity, trichloroethylene and re-chroming.

Components:

Single component baking coating. Requires thinning for application with 665-550-025 Rockhard Standard Thinner.

Application:

Surface Preparation:

Substrate must be clean and grease free as a minimum. May be applied over abraded, phosphate or chromated substrate, and latest anodic chrome free treatments.

Paint Preparation:

Stir well before use. All separated material must be re-incorporated into the bulk product. No time limits are specified for the mixing operation. The operator must be satisfied that the product including any thinning solvent is thoroughly mixed before use/ Where mechanical mixing is employed care must be taken to not heat the product to above the maximum storage temperature. Mixing in open containers should be limited to <10 minute periods to ensure

that solvent evaporation does not compromise the product.
Shaking or rolling in closed containers is an acceptable mixing method for small volume products supplied ready for use.

Application Method:

Designed for Spray or Dip application.

Many different application specifications have been drawn up by users and advise is available from our Technical Department for various methods including dip and spray.

Drying Curing:

Air Dry: 15 minutes

Part Bake between coats: 150 ± 10°C for 30-60 minutes

Full Cure (standard): 190±5°C for 60-90 minutes

Care must be taken to comply with end user requirements where customer approval to an alternative baking schedule has been agreed.

Technical Properties:

Supply Viscosity:	19-24 secs ISO 5 Cup (B4 equivalent) @ 20°C
Flash Point:	25°C closed cup
VOC Content:	674 g/litre
Colour:	Amber liquid
Pack Size:	1, 5 and 25 litres
Density:	0.96 kg/l
Gloss:	N/A – cures to gloss finish
Thinner:	665-550-025
Solvent/Clean Up:	40006 gun cleaner
Catalyst:	N / A
Theoretical Coverage:	11.9 sq m/litre @ 20 micron

Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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