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**Product Name:** Rockhard Clear Stoving Enamel & Microporous Casting Sealer

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**Product Number:** 985-111-800

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**Product Description:**

Rockhard clear stoving enamel is one of the best protective coatings for metals, particularly Aluminium and Magnesium and as such is recommended by Magnesium Elektron, the leading suppliers of Magnesium in the UK.

Used where maximum protection is needed on Aluminium, Steel, Titanium and Magnesium. Provides a Clear coat for protection against marine and other harsh environments including applications where a high level of chemical resistance to industrial solvents, oils and hydraulic fluids is necessary.

Specifically formulated to give optimum product performance this product is crystal clear, low odour and high flash making it ideal for dip tanks as well as spraying.

This product has also been found to be resistant not only to re-chromating, but also to HAE heavy anodising. This is useful for post machining on magnesium for maximum protection. Approved in February 1995 by Lucas Western for use on the BRR 710 gearbox, this product caused interest due to resistance to heavy re-anodising, which means that whole castings can be coated with Rockhard machined and recoated with Rockhard. In addition, it is also found that a variant can be processed to temperatures as low as 125°C (225°F) which means that it can be recoated after steel inserts have been inserted into magnesium castings.

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**Approvals/Specifications:**

- Alternative to CV115
- DTD 5562
- Allied Signal spec PCS 5623
- SL3057 9111-C-8000
- BAEP 3512
- De Havilland DH177/1

# Technical Data Sheet



- Previous  
Reference – 444-20 (19)

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## Performance:

Tested to DTD 5562 which includes: 6 months intermittent salt spray (DEF 1053 method 36); resistance to humidity; Trichloroethylene and re-chromating.

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## Components:

Single Part Product – To be used with Thinner 665-550-025

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## Application:

### Surface Preparation:

Substrates must be clean, dry and grease free. Bare metal adhesion is improved through abrasion or grit blasting. Normally applied to clean metal or pre-treated substrate. May be used as an adhesion promoting coating on some composite substrates.

### Paint Preparation:

Single pack range of products – may be applied at supply viscosity. Thinning with up to 10-20% 665-550-025 may be required for application. An application viscosity of 30-40 seconds ISO 5 is recommended.

### Application Method:

Apply by spray; conventional or H.V.L.P. For full details, refer to Indestructible Application Guide IPAS-21. Request RPS661/21 for Rolls Royce parts.

### 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.

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## Technical Properties:

**Supply Viscosity:** ISO 4 Cup; 25-38 Secs at 23±2°C

**Flash Point:** 24°C

**VOC Content:** 680 g/l

**Colour:** Clear

# Technical Data Sheet



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<b>Pack Size:</b>	1, 5 and 25 Litre
<b>Density:</b>	0.98 g/ml
<b>Gloss:</b>	Full Gloss
<b>Thinner:</b>	665-550-025
<b>Solvent/Clean Up:</b>	40006 Gun cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	12 sq m/lt @ 20 micron

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**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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