
Product Name:

Rockhard Epoxy Stoving Enamel - Black

Product Number:

- 985-111-901 – Semi-Gloss
 - 985-111-902 – Semi-Matt
 - 985-111-903 - Matt
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Product Description:

Rockhard Stoving enamels are one of the best protective coatings for metals, including Aluminium, Magnesium, Steel and Titanium and as such it is recommended by Magnesium Electron, the leading suppliers of Magnesium in the UK. Used where maximum protection is needed against marine and other harsh environments.

Approvals/Specifications:

- DTD 5562
 - MSRR 9226
 - DEF1053 method 36
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Performance:

Tested to DTD 5562 including 6 months intermittent salt spray (DEF 1053 method 36)

Tested as a system with Primer 700-155-003, meets the requirements of multiple specifications to include:

- Salt Spray: 1,000 hours to ASTM-B117 (non-scribed)
 - Cyclic, 10 cycles, dry heat 220°C – 4 hours, then 20 hour's hot salt fog
 - High Temperature: 100 hours @ 220°C
 - Low Temperature Resistance: 24 hours @ -50°C
 - Aerospace Fuel Resistance: 48 hours @ 40±2°C
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Components:

Single Pack Product. May be thinned for application using 665-550-025 or IP985-Reducer

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 or IP985-Reducer may be required for application. An application viscosity of 30-40 seconds ISO 5 is recommended.
Application Method:	Apply by spray; conventional or HVLP. For full details, refer to Indestructible Application Guide IPAS-21. Request RPS661/21 for Rolls Royce parts.
Drying Curing:	<p>Flash off: 15 minutes</p> <p>Part Bake between coats: 150±10°C for 30-60 minutes</p> <p>Full Cure (standard): 190±5°C for 60-90 minutes</p> <p>Care must be taken to comply with end user requirements where customer approval to an alternative baking schedule has been agreed.</p>

Technical Properties:

Supply Viscosity:	Clear; 60-70 seconds ISO5 @ 23±2°C
Flash Point:	24°C
VOC Content:	Average 555 g/litre
Colour:	Black
Pack Size:	1 & 5 Litre
Density:	1.1-1.17 kg/litre
Gloss:	Semi-Gloss, Semi-Matt, Matt
Thinner:	665-550-025 or IP985-Reducer
Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	N/A
Theoretical Coverage:	15sq m/litre @ 25 micron

Technical Data Sheet



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:

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