

# Technical Data Sheet



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**Product Name:** Issue 2 Stoving Matt Black Epoxy Finish Coat for Spraying Small Arms

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**Product Number:** IP80-56-9003

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**Product Description:** Epoxy modified stoving matt black paint for application to phosphated surfaces of small arms and components.

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**Approvals/Specifications:** - Def Stan 80-56 Issue 2 May 1995

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**Performance:** Approved by Ministry of Defence for resistance to the following:

- Gloss  $9 \pm 3$  units using 60° head
- Wettability
- Bend Test
- Impact – pendulum
- Scratch Resistance
- Oil Resistance
- Heat Resistance 250°C 2 hours
- Humidity BS3900, Part F9 for 4 days
- Continuous salt spray BS3900, Part F4 for 5 days
- Abrasion resistance
- Phosphoric acid resistance

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**Components:** Single Pack Product. May be thinned for application by using 665-550-025

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**Application:**

**Surface Preparation:** All surfaces must be oil and grease free. Coating may be applied onto bare metal, phosphate or pre-primed substrate.

**Paint Preparation:** Thin as required with 665-550-025 thinners

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**Application Method:** Intended for spray application. Small areas or components may be brush or dip coated.

**Drying Curing:** Flash off 15 minutes; stove 60 minutes at 180 - 200°C

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## Technical Properties:

<b>Supply Viscosity:</b>	Ready for Use
<b>Flash Point:</b>	24°C
<b>VOC Content:</b>	550 g/lit
<b>Colour:</b>	Clear
<b>Pack Size:</b>	5 Litres
<b>Density:</b>	1.15kg/l
<b>Gloss:</b>	Semi-Matt
<b>Thinner:</b>	665-550-025
<b>Solvent/Clean Up:</b>	40006
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	15 sq/m litre

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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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