

---

**Product Name:** High Heat Resistant Lead Free Stoving Aluminium – Toluene Free

---

**Product Number:** IP9029-R3

---

**Product Description:**

A few products are dual sourced, but there are many instances where Indestructible Paint companies technical development has provided alternatives. IP9029-R3 is one example as a replacement for PL101, a higher heat resistant stoving enamel than PL101 and IP9139. With heat resistance increased from 500°C to 650°C, it also has superior thick film forming properties at up to 6 thou (150 microns). As part of the evolution of these high performance products, this has been developed Toluene free for certain US applications.

It has been warmly welcomed in America as being superior to the US spec: TT-P-28 for corrosion resistance to Skydrol and gear fluid.

---

**Approvals/Specifications:**

- MSRR 9029, OMat 7/1D
  - Similar to BAEP 3519 (Pending PWA 578F)
  - Alternative to AFS 977, PL101C2, E3746, 4863-A-8000
  - Glyptal Number: 86009-P6430 and SSP501/502, Allison EMS 26710
  - Supersedes IP9139 and IP9029-R1; IP9029-R2, Allied Signal/Textron
  - Significantly superior to TT-P-28, but does not air dry
  - Honeywell P6430, NGPS 134, NSN: 8010-99-258, 8010-99-749-4329
- 

**Performance:**

This material significantly exceeds the performance test for MSRR 9029, PWA 578, Textron and TT-P-28 tests on steel. Testing includes:

- 100 Hours at 650°C (1200°F) dry heat
-

- 100 Hours at 150°C (300°F) in Ester lubricants with 100 gram scratch resistance
- 3 Hours at 70°C (160°F) in Skydrol and 100 gram scratch (better than previous product)
- 100 Hours continuous salt spray

10 Cycles 220°C (430°F) 4 hours-20 hours salt spray cabinet  
BSTM.B117

---

## Components:

Single component product. May be thinned for application with IP985 Reducer or IP9151.

---

## Application:

### Surface Preparation:

Ensure that surfaces are clean and free from dirt

### 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:

Spray application, wet on wet coats to give film weights of 52-85g per square meter.

Indestructible method IPAS 15: Rolls Royce parts apply for RPS 661/15 for full process specs.

### Drying Curing:

Stove after 30 minutes flash off for 2 hours at 185-195°C (365-385°F). Apply for RPS 661/15 for full process specs.

---

## Technical Properties:

**Supply Viscosity:** 32-38 secs/ISO 4 cup @ 23+/- 2°C

**Flash Point:** ≥22°C & ≤32°C

---

<b>VOC Content:</b>	650 g/litre
<b>Colour:</b>	Aluminium
<b>Pack Size:</b>	1 and 5 litre
<b>Density:</b>	1.13 kg/l
<b>Gloss:</b>	Semi-Matt
<b>Thinner:</b>	IP985-Reducer or IP9151
<b>Solvent/Clean Up:</b>	40006 Gun cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	12.5 sq m/litre @ 25 microns

---

## 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 Sheets.**

---

## Disclaimer:

The information printed in this publication is based upon the research and experience of Indestructible Paint Ltd. No representation of warranty is made, however, concerning the accuracy or completeness of the information presented in this publication. Indestructible Paint Ltd make no warranty or representation of any kind, express or implied. Including without information limitation any warranty or merchantability or fitness for any particular purpose, and no warranty or representation shall be implied by law or otherwise. Any products sold by Indestructible Paint Ltd are not warranted as suitable for any particular purpose to the buyer. The suitability of any products for any purpose in particular to the buyer is for the buyer to determine. Indestructible Paint Ltd assumes no responsibility for the selection of products suitable to the particular purpose of any particular buyer. Indestructible Paint Ltd shall in no event be liable for any special, incidental or consequential damages.

---

## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: [sales@indestructible.co.uk](mailto:sales@indestructible.co.uk)

---