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**Product Name:****Rockhard Stoving Varnish, Toluene Free Grade**

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**Product Number:****IP985-547**

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**Product Description:**

Rockhard clear stoving varnish is one of the best protective coatings for Magnesium and as such is recommended by Magnesium Elektron, the leading suppliers of Magnesium in the UK. Used where maximum protection is needed on Magnesium, against marine and other harsh environments.

Specifically formulated to give optimum product performance this product is low odour, and available as a crystal clear or green tinted version, to aid application.

IP985-547 is formulated on latest generation environmentally friendly solvents and is toluene free, to meet latest customer environmental requirements.

The product has also been found to be resistant not only to re-chromating, but also to re-heavy HAE anodising. This is useful for post machining on magnesium for maximum protection which means that whole castings can be machined and re-coated with Rockhard.

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**Approvals/  
Specifications:**

Safran Helicopter Engines(Turbomeca): CCT-LB 547  
Safran Landing Systems(Messier-Bugatti):  
Airbus Helicopters(Eurocopter): ECS 2264  
Rolls-Royce: MSRR 9226  
DTD 5562

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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 Component Varnish plus thinner/reducer

Base: IP985-547 Clear  
IP985-547GR Green Tinted

Thinner: IP985-Reducer

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## Application:

### Surface Preparation:

Ensure surfaces are clean and dust free. Typical surface pre-treatments include:  
Chromate conversion coating  
Chromic acid anodising  
Thin film sulphuric acid anodising  
HAE  
Tagnite  
Keronite

### Paint Preparation:

Stir well before use. Varnish can be used as supplied, but can be thinned with 10% maximum IP985-Reducer.

### Application Method:

Apply by spray: latest generation “compliant” guns recommended: follow gun manufacturers recommendations on atomising pressures etc.

Typically applied as a three-coat system, with part curing between coats, before final full cure of the last coat.

Three coat system will give a typical dry film thickness of 30-35 $\mu$ .

### Drying/Curing:

Flash off: 30-45 minutes at ambient temperature.

Intermediate coats: part cure: 30 minutes @ 150°C (300°F).

Final, full cure: Minimum 60 minutes at 180-190°C (355-375°F)

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## Technical Properties:

<b>Supply Viscosity:</b>	29±3 seconds/ISO4 cup/23±0.5°C
<b>Flash Point:</b>	≥22°C; ≤32°C
<b>VOC Content:</b>	669 gms per litre
<b>Density:</b>	0.958kg/litre
<b>Colour:</b>	Clear or Green Tinted
<b>Pack Size:</b>	5 litres
<b>Gloss:</b>	Full
<b>Thinner:</b>	IP985-Reducer
<b>Solvent/Clean Up:</b>	IP985-Reducer or 40006 Gunwash
<b>Theoretical Coverage:</b>	24.7 sq.metres per litre per coat @ 10µ.

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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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## Disclaimer:

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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