

Technical Data Sheet



Product Name:

Rockhard Stoving Matt Black Epoxy Coating

Product Number:

615-155-001

Product Description:

Rockhard Stoving Matt Black has been developed to meet the latest requirements of the aerospace industry and multiple customer specifications. The coating is designed for use primarily on aero-engine, heat exchanger and helicopter gearbox components on a variety of substrates including magnesium / aluminium / steel and titanium. The cured coating is a tough durable weather resistance finish that will withstand many hard environments and chemical resistance requirements.

Uses include non-reflective coatings on optical instruments, laser enclosures and military non-reflective applications.

Approvals/Specifications:

- DTD 56D
 - BAE P3507 (S26-350 nNow Airbus ABP 4-2131)
 - MSRR 9226, OMat 7 / 174A, RR Code: 138435
 - NGPS 126, Type 2B
 - Previous Reference: 444 / 80
 - Nato Stock No: 8010-99-225-3339
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Performance:

Meets the requirements of multiple specifications to include:

- Salt Spray: 1,000 hours at ASTM-B117
 - High Temperature: 1,000 hours @ 220°C
 - Low Temperature Resistance: 24 hours @ -50°C
 - Hydraulic Fluid (Skydrol) Resistance: 168 hours @ 70°C followed by 1,500 grams scratch
 - 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

Application:

Surface Preparation: Substrate must be clean, dry and grease free. Bare metal adhesion is improved through abrasion or grit blasting. To be applied over 700-155-003 chromate or IP985-6500 Rockhard non-chromate primers.

Paint Preparation: Single Pack range of products – may be applied at supply viscosity. Thinning with up to 20% IP-Reducer may be required upon application.

Application Method: Apply by spray; conventional or HVLP. For full details refer to Indestructible Application Guide IPAS-21.

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.

Technical Properties:

Supply Viscosity:	18-24 secs ISO5 @23±2°C 47-53 secs ISO4 @23±0.5°C
Flash Point:	≥21-≤32°C
VOC Content:	559 g/litre
Colour:	Black
Pack Size:	1 and 5 Litres
Density:	1.15kg / litre
Gloss:	Matt
Thinner:	665-550-025
Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	N / A
Theoretical Coverage:	14 sq m/litre @ 25 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:

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