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**Product Name:**

Rockhard Green Tinted Epoxy Stoving Enamel

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**Product Number:**

690-450-005

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**Product Description:**

Rockhard green tinted epoxy stoving enamel is made to the same formula as the Rockhard clear but has a dye added to aid spraying. It is one of the best protective coatings for metals, particularly Aluminium and Magnesium. Used for example as an erosion resistant coating on blades in the Rolls Royce Pegasus engine.

690-450-005 coatings have been widely used in the aircraft industry where maximum protection is needed on Aluminium, Steel, Titanium and Magnesium. One particular application is on the stator blades and other engine components on aircraft serving on aircraft carriers (e.g. the Harrier) where maximum protection against marine and other harsh environments is needed.

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**Approvals/Specifications:**

- DTD 5562
  - MSRR 9228, OMat 7 / 146
  - Previously 444 / 226
  - Nato Stock No (NSN): 8010-99-608-3363
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**Components:**

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

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**Performance:**

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

Resistant to humidity, trichloroethylene baths and re-chromating

Meets the requirements of multiple specifications to include:

- Salt Spray: 1,000 hours to ASTM-B117 (non-scribed)
  - High Temperature: 1,000 hours @ 220°C
  - Low Temperature Resistance: 24 hours @ -50°C
  - Aerospace Fuel Resistance: 48 hours @ 40±2°C
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## 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 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. Request RPS661/34 for Rolls Royce Parts.

Brush Application – use the coating at supply viscosity. Thinners may be added if required for application. A soft bristle brush is recommended to minimise brush strokes. Preparation, Drying and Curing is unchanged from spray application.

### Drying Curing:

**Air Dry:** 15 minutes

Part Bake between coatings: 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:

<b>Supply Viscosity:</b>	Clear, 19-24 seconds ISO5 @ 23±2°C
<b>Flash Point:</b>	24°C
<b>VOC Content:</b>	675 g/litre
<b>Colour:</b>	Green Transparent
<b>Pack Size:</b>	1 and 5 litre
<b>Density:</b>	0.96 kg/litre
<b>Gloss:</b>	Gloss
<b>Thinner:</b>	665-550-025

# Technical Data Sheet



<b>Solvent/Clean Up:</b>	40006 Gun Cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	11.7 sq m/litre @ 20 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:

For Safety Data Sheets please contact our Sales Department:

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