
Product Name:Rockhard Two Pack Clear Epoxy Gloss

Product Number:750-450-004

Product Description:

Rockhard two pack epoxy clear gloss is for use where the use of a stoving coating is not possible or desirable. This coating can be used on a wide variety of substrates including, metals, wood, asbestos, many synthetic rubbers and plastic. 750-450-004 is used as the touch up coating for 576-450-002 Rockhard Epoxy Stoving clear coat.

Approvals/Specifications:

- AFS 641
 - DTD 900-4492 (viper engines)
 - CPW approved
 - FW 02651
 - Omat 7/162
 - Historical reference – 444/709
 - NSN: 8010-98 & 8010-99
 - NSN: 8010-99-794-0121
 - NSN: 8010-992447020
-

Performance:

Tested as a system with IP9064-6362 Primer on Magnesium, Aluminum and Steel to the following minimum specification. Actual performance will be in excess of the following:

- Resistant to 100 hours in salt water fog
 - Resistant to 100 hours dry heat at 180°C
 - Resistant to 100 hours at 150°C in lubricating oil
 - Resistant to 100 hours at 180°C in dry heat
 - Resistant to 100 hours with engine fuel
 - After 7 days air drying, resistant to Skydrol for 3 hours 70°C (160°F)
 - Resistant to 10 cycles 4 hours at 150°C (300°F) 20 hours in salt water fog
 - Resistant to temperatures of down to at least -40°C
-

Components:

- 750-450-004-Base (Part A) 1:1 parts by volume with:
- 656-450-002 (Part B)

665-550-025 Thinner (may be added if required for coating complex unit geometry).

Application:

Prior to application thorough cleaning of the substrate is essential. This coating can be applied over bare metal, 2 pack primer, damaged Rockhard Stoving Coatings or other process.

If primer has been applied more than 72 hours in advance of being over coated, the surface must be wet flatted with 320 grade paper and have an additional light coat of primer applied to ensure the best inter-coat adhesion for the system.

Clear Coat: Apply one double track coat to give a dry film thickness of 20-32 microns. Air dry for a minimum of 4 hours or flash off for 30 minutes and then stove at 125°C for 30 minutes.

Full chemical protection is achieved after 7 days (air dry at 18-20°C min)

Surface Preparation:

Ensure that all surfaces are clean and free from dirt.

Paint Preparation:

Pre-Treatment: Primer – pre-treat aluminium or steel surfaces with chromate or phosphate pre-treatment systems as specified. May be applied over IP9064-6362 chromate or IP9064-6500 chrome free primer, used as a standalone coating or as touch up for 576-450-002.

Mixing Instructions: 1:1 parts by volume, Part A to Part B

Thinner/Reducer Addition: 665-550-025

Application Method:

Apply by spray; Small areas can be applied by brush

Drying Curing:

Air Dry:

- *Touch Dry:* 2-3 hours
- *Hard Dry:* 16-24 hours

If you can flash off for 15 minutes and the force cure for 30 minutes at 115°C +/-, this would ensure Skydrol resistance.

Heat Cure:

- *Flash Off:* 20-30 minutes
- *Cure:* 30 minutes @ 125°C

Technical Properties:

Supply Viscosity:	70 – 100 seconds ISO5 @ 23+/- 2°C
Flash Point:	21 < 32 °C
VOC Content:	400-480 g/l
Colour:	Available in a Variety of colours
Pack Size:	1 & 5 litre
Density:	1.02-1.40 kg/litre
Gloss:	Available in a Variety of Gloss Levels
Thinner:	665-550-025
Solvent/Clean Up:	40006 or 665-550-025
Catalyst:	656-450-002
Theoretical Coverage:	15 sq m/litre @ 25 micron

Storage:

Highly flammable liquid: store and use in accordance with flammable liquid regulations.

Shelf Life: 12 months Temperate; 6 months Tropical

Before Use Please Refer to Product Safety Data Sheet

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.

Technical Data Sheet



Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: sales@indestructible.co.uk