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**Product Name:**

Paint Ammunition Stoving Finish – Colour Range  
(Lead and Chromium free)

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**Product Number:**

IP80-25-(Range)

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**Product Description:**

Single coat quality stoving enamel for use on ammunition.

Resistant to a range of conditions and chemicals. Spray or dip.

For use in conjunction with Def 80-123 on ferrous and Def 80-124 on non ferrous ammunition, and non ammunition components, or as a single coating.

Under normal circumstances a single coat of Def 80-25 top coat is applied over suitably pre-treated substrates, e.g. ferrous substrates; phosphated (to Def Stan 03-11) or non ferrous substrates painted with pre-treatment primer to Def 80-15 (our IP80-15).

Full system will protect exterior of phosphated steel ammunition for up to 10 years under all but the most arduous of conditions.

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**Approvals/Specifications:**

- Def Stan 80-25 / 3
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**Performance:**

- Tested to Defence Standard 80-25
  - **Colour:** to Order
  - **Gloss:** Matt, Semi-Gloss or Gloss
  - **Bend test:** 6mm mandrel
  - Scratch BS3900; E2; 1000gm load
  - Impact BS3900; E8; no sign of removal
  - Resistance to white spirit
  - Resistance to mineral oil
  - Humidity resistance BS3900; F9; 10 days
  - Salt Spray BS3900; F12; 14 days
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**Components:**

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

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## Application:

### Surface Preparation:

Surfaces must be clean and grease free. Suitable for application over ferrous substrate primed with Def 80-123 primer. Non-ferrous substrate primed with Def 80-124. Under normal conditions a phosphate in accordance with Def 03-11 or a BS2X32 Etch primer may be used.

### Paint Preparation:

Stir well before use.

### Application Method:

Thin to application viscosity with 5 - 10% (vol) 665-550-025  
Spray to 25-35 microns dry film thickness

### Drying Curing:

**Air Dry:** 15-20 minutes  
**Heat Cure:** stove 1 – 1.5 hour at 150 +/-8°C

## Technical Properties:

<b>Supply Viscosity:</b>	95-105 Sec / ISO 5 flow cup @ 23±2°C
<b>Flash Point:</b>	≥22°C & ≤32°C
<b>VOC Content:</b>	520 gm / per litre
<b>Colour:</b>	To Order
<b>Pack Size:</b>	5 Litres
<b>Specific Gravity:</b>	1.29 g / cm <sup>3</sup>
<b>Gloss:</b>	Matt, Semi-Gloss, Gloss
<b>Thinner:</b>	665-550-025
<b>Solvent/Clean Up:</b>	40006 Gun Cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	17m <sup>2</sup> / litre @ 25 micron dft *

\* At 100% transfer efficient

## 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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