

# Technical Data Sheet



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**Product Name:**

Paint, Finishing for General Service, Air Drying,  
Spraying to Specification

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**Product Number:**

IP80-55

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**Product Description:**

This finish is approved to a Ministry of Defence Standard and should be used strictly in accordance with individual contract requirements. This coating is a general services, semi-gloss cellulose nitrate paint that is quick drying and suitable for use on ammunition which will be stored in boxes or in circumstances where the level of durability outlined by Def Stan 80-55 is acceptable.

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**Approvals/Specifications:**

Released to the requirements of Defence Standard 80-55

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**Performance:**

Released to the requirements of Defence Standard 80-55.  
Provides an oil, grease and moisture resistant marking system for use over pre-coated surfaces or bare metallic and wooden substrates.

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**Components:**

Single component coating supplied ready for use. May be thinned with IP80-55-THINNER (Def 80-38) or AD THIN if required.

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**Application:****Surface Preparation:**

Substrates must be thoroughly cleaned, dry and free from contaminants, corrosion and grease prior to coating.

**Paint Preparation:**

Stir well before use.

**Application Method:**

Formulated for brush application. Small components may be dip coated.

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## Drying Curing:

### Air Dry:

- Surface Dry: 15-30 minutes
- Hard Dry: 1-1½ hours
- Full Properties: 7 days

### Forced Air Dry:

- Handleable: ≤20 minutes @ 40°C
- Full Properties: 7 days

## Technical Properties:

<b>Supply Viscosity:</b>	60 +/- 10 s, ISO5 @ 23°C
<b>Flash Point:</b>	≥ 10°C closed cup
<b>VOC Content:</b>	circa 640 g/ltr
<b>Colour:</b>	Refer to variant
<b>Pack Size:</b>	5 litre
<b>Density:</b>	0.98 – 1.05kg/l
<b>Gloss:</b>	Semi-Gloss to Matt
<b>Thinner:</b>	IP80-38-THINNER or AD-Thin
<b>Solvent/Clean Up:</b>	40006
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	10 sq/m litre @ 25 microns

## 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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