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**Product Name:**

Red Akard Def Stan 80-92/2 30%

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**Product Number:**

30% - 27524 (previously 18683)

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**Product Description:**

Stoving lacquer for brass, aluminium and steel inside shells in direct contact with explosives. Phenol Formaldehyde lacquer for application to suitable prepared metal substrates. The lacquer provides a corrosion resistant finish against salt water spray. The three lacquers being differentiated by the non-volatile content, 22%, 30% and 39%. Designation QX indicates that the material is a quality likely to be suitable for application to a high degree if compatibility with explosives is a requirement and it can be tinted black, red, yellow, green or clear for identification purposes.

As a replacement for L3128, it has been used by such customers as Rolls Royce and Smiths Industries, in applications like VC10 fuel tanks.

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**Approvals/Specifications:**

- Conforms to Def Stan 80-92, issue 2 (previously CS 2465)
  - MIL L6806 as approved for use on the G222 Italian Aircraft
  - Manufactured with a rein replacement for Bakelite L-3128
  - NSN: 8010-99-587-3774
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**Performance:**

The product conforms to Def Stan 80-92, issue 2, which includes the following:

- Resistance to salt spray BS3900, Part F4 for 10 days
  - Resistance to water BS3900, ANX D
  - Resistance to nitro-benzene – ANX D no loss
  - Resistance to bend test – around 10mm mandrel
  - PH of aqueous extract  $6.5 \pm 1.5$
  - Coloured products contain less than 1% of approved dye
  - Resists acetone to BS509
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**Components:**

Single Pack Product. Do not thin.

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## Application:

<b>Surface Preparation:</b>	Substrate must be clean and grease free as a minimum. May be applied over abraded, phosphated or chromated substrate.
<b>Paint Preparation:</b>	Stir well before use. All separated material must be re-incorporated into the bulk product. No time limits are specified for the mixing operation. The operator must be satisfied that the product including any thinning solvent is thoroughly mixed before use. Where mechanical mixing is employed care must be taken to not heat the product to above the maximum storage temperature. Mixing in open containers should be limited to <10 minute periods to ensure that solvent evaporation does not compromise the product. Shaking or rolling in closed containers is an acceptable mixing method for small volume products supplied ready for use.
<b>Application Method:</b>	Can be applied by spray or dip (brush on small areas). Use at supply viscosity; do not thin. Solids content defines final dry film thickness.
<b>Drying Curing:</b>	<b>Flash off:</b> 20-30 minutes <b>Stove:</b> 30 minutes at 135°C (275°F)

## Technical Properties:

<b>Supply Viscosity:</b>	45-60s ISOC3 @ 23±2°C (BS3900.A6 obsolete specification is now ISO2431)
<b>Flash Point:</b>	14°C (closed cup method)
<b>VOC Content:</b>	661 g/litre
<b>Colour:</b>	Red
<b>Pack Size:</b>	5 Litre
<b>Density:</b>	0.93 - 0.96kg/litre
<b>Gloss:</b>	Gloss Lacquer
<b>Thinner:</b>	N / A
<b>Solvent/Clean Up:</b>	18662
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	10 sq m/litre

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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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