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**Product Name:**Rockhard Stoving Enamel Clear

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**Product Number:**576-450-002-R1

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**Product Description:**

Rockhard Clear Stoving Enamel has proved its worth over 4 decades as one of the best protective coatings for metals to erosion, corrosion, including salt water and chemical resistance at elevated temperatures particularly on Aluminium and Magnesium and as such is recommended by Magnesium Electron, the leading supplier of Magnesium in the UK. The R1 version of 576-450-002 removes an environmentally unacceptable solvent from the wet coating. The dry film remains identical to the previous version.

Rockhard is used in many industries, For example Volvo air intakes, coating turbine blades, computer chassis for insulation purposes, heat exchangers and radiators where it has enabled Aluminium to replace Copper in some applications. It is acknowledged as a leading product for curing micro-porosity used on engine blocks and turbo pipes etc.

Its history includes protection of the Magnesium skins of the Westland Wessex Helicopter and parts of the Comet Jet liner. Since then it has been widely used in the aircraft industry where maximum protection is needed on Aluminium, Steel, Titanium and Magnesium, and in marine and other harsh environments.

Approvals include: Sikorsky for use on their AH 60 helicopter, McDonnell Douglas on their MD 500 range, and Pratt and Whitney Canada on their PT6, PT100, and 4000 range. In February 1995, GE approved this material for use on the F110 gearbox housing. The most recent approval has been by Parker Hannifin (Nicholls Aircraft Division) on the G 4461 model.

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**Approvals/Specifications:**

- DTD5562
  - OMat 7 / 146
  - Previous Code: 444 / 176
  - P&W Canada: CPW 489
  - CPMC 79964
  - 07-017
  - PWA 36490
  - PWC 10183
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- CPW 489
- GE: A8B84 S
- Boeing: D210-13512-1
- Sikorsky: SS8688
- McDonnell Douglas: HP 4-133
- Williams International: CP 4240
- Hamilton Sunstrand: HS 4675
- Allied Signal (Textron): FP5109, P6426, P640
- Parker Hannifin (Nichols Aero Engine Division): MCS 145
- Honeywell-Allied Signal: FP5109
- Hamilton Sunstrand San Diego: ESR 1187
- McDonnell Douglas (Boeing): HP 4-133
- Pratt & Whitney Aircraft: PWA 36490
- General Electric Aircraft Engines: P6D2
- Nichols Aircraft Parker Hannifin: MCS-145
- Williams International: CP4240

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## Performance:

Tested to DTD 5562, which includes 6 months intermittent salt spray (Def 1053, Method 36). Resistance to humidity, trichloroethylene and re-chroming.

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## Components:

Single component Baking coating. Requires thinning for application with 665-550-025 Rockhard Standard Thinner.

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## Application:

### Surface Preparation:

Substrate must be clean and grease free as a minimum. May be applied over abraded, phosphate or chromated substrate, and latest anodic chrome free treatments.

### Paint Preparation:

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.

## Application Method:

Designed for Spray or Dip application.

Many different application specifications have been drawn up by users and advice is available from our technical department for various methods including dip and spray.

## Drying Curing:

**Air dry:** 15 minutes.

Part Bake between coats: 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>	19-24 seconds ISO5 cup (B4 equivalent) @ 20°C
<b>Flash Point:</b>	25°C closed cup
<b>VOC Content:</b>	674 g/litre
<b>Colour:</b>	Amber liquid
<b>Pack Size:</b>	1, 5 and 25 litre
<b>Density:</b>	0.96 kg/litre
<b>Gloss:</b>	N/A – cures to gloss finish
<b>Thinner:</b>	665-550-025
<b>Solvent/Clean Up:</b>	40006 Gun cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	11.9 sq m/litre @ 20 micron

## 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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## Disclaimer:

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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