

# Technical Data Sheet



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**Product Name:**

Rockhard Gloss Black Stoving Enamel

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**Product Number:**

614-150-002-R1

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**Product Description:**

Rockhard epoxy stoving gloss black enamel is part of the 961 resin family that has a long history of corrosion protection for metals including Aluminium, Magnesium and Steel. Resistant to a wide range of environments it is currently being used on aircraft components, heat exchangers, actuators, engine components and a wide variety of other applications.

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**Approvals/Specifications:**

- DTD 5562
  - Previous reference 444/1081
  - NSN 8010-99-8421727
  - NSN 8010-99-8598122
  - SL3057-9111-C-8000
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**Performance:**

Tested to DTD 5562 which includes: 6 months intermittent salt spray (Def 1053 method 36), resistance to humidity, Trichloroethylene cleaning and re-chromating.

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**Components:**

Single part product.  
May be thinned for application using 665-550-025 Thinner

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

Substrates must be clean, dry and grease free. Bare metal adhesion is improved through abrasion or grit blasting. To be applied over 700-155-003 chromate or IP985-6500 Rockhard non-chromate primers.

**Paint Preparation:**

Single pack range of products – may be applied at supply viscosity. Thinning with up to 20% 665-550-025 may be required for some applications.

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**Application Method:** Apply by spray; conventional or H.V.L.P. For full details, refer to Indestructible Application Guide IPAS-21.

**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.

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## Technical Properties:

**Supply Viscosity:** 35-40 seconds ISO4 cup at 20°C (70°F)  
**Flash Point:** 25°C  
**VOC Content:** 655 g/litre  
**Colour:** Black  
**Pack Size:** 1 and 5 Litres  
**Density:** 1.2 g/ml  
**Gloss:** Full Gloss  
**Thinner:** 665-550-025  
**Solvent/Clean Up:** 40006 Gun Cleaner  
**Catalyst:** N/A  
**Theoretical Coverage:** 9 sq m/lt @ 25 micron

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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:

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