
Product Name: Stoving and Primer Finishes

Product Number: IP80-152 Range

Product Description: Defence Standard 80-152 is a stoving finish paint suitable for application to suitably prepared and/or pre-tested metal substrates such as those used in the fabrication of service equipment and instruments.

System for up to 2 parts:

- IP80-152 365 P Vellum Primer
- Topcoat ; colours to be advised including 697 grey ; 537 ; 632 ; 693; 697; 9001 matt black

This system is used to coat pre-treated metal surfaces including aluminium and steel.

Available in either a semi-gloss or gloss finish

IP80-152 is available in a variety of colours, please state the colour specification before placing an order – some colours maybe subject to a minimum order quantity

Approvals/Specifications: - Defence Standard 80-152 / issue 2

Performance: Will comply with published Defence Standard 80-152 (when applied in accordance with standard or customer specification) which includes the following:

- **Bend Test:** No cracking or loss of adhesion, around 12mm mandrel
 - **Resistance to Humidity:** BS 3900: part F9 for a period of 10 days
 - **Resistance to Ester Lubricant:** No film deterioration and no penetration of the top coat
-

- **Scratch**
Resistance: No penetration of the top coat, BS 3900: Part E2 using a load of 2,000g

- **Specular Gloss:**
 - o Filler: ≤20 units
 - o Semi-Gloss: 55 ± 5 units (60° Geometry Gloss Meter)
 - o Gloss: ≥65 units (20° Geometry Gloss Meter)

Components:

Single Pack Product. May be thinned for application by using IP80-152-Reducer of up to 10%

Application:

Surface Preparation:

Degrease and shot blast as required

Paint Preparation:

Single Pack Product

Application Method:

Spray – can be used as supplied or thinned with up to 15% IP80-152-Reducer

Apply 1 coat primer to required dry film thickness. Either part cure and overcoat with topcoat or fully cure and de-nib / flat as required.

Apply 1-2 coats finish to achieve required dry film thickness

Drying Curing:

Primer:

- Flash off 20-30 minutes
- Part cure for 30 minutes @ 140-150°C

Topcoat

- Flash off 20-30 minutes
- Cure for 1 hour @ 140-150°C

Technical Properties:

Supply Viscosity:	60-65 / ISO 4 / 23°C
Flash Point:	≥21°C ≤32°C
VOC Content:	370-330gm / per litre
Colour:	As per customers requirements

Pack Size:	5 Litre
Density:	1.03 – 1.32 ± 0.02kg/l
Gloss:	Semi-Gloss / Full-Gloss
Thinner:	IP80-152-Reducer of up to 10%
Solvent/Clean Up:	IP80-152-Reducer or 40006
Catalyst:	-
Theoretical Coverage:	-

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

Disclaimer:

The information printed in this publication is based upon the research and experience of Indestructible Paint Ltd. No representation of warranty is made, however, concerning the accuracy or completeness of the information presented in this publication. Indestructible Paint Ltd make no warranty or representation of any kind, express or implied. Including without information limitation any warranty or merchantability or fitness for any particular purpose, and no warranty or representation shall be implied by law or otherwise. Any products sold by Indestructible Paint Ltd are not warranted as suitable for any particular purpose to the buyer. The suitability of any products for any purpose in particular to the buyer is for the buyer to determine. Indestructible Paint Ltd assumes no responsibility for the selection of products suitable to the particular purpose of any particular buyer. Indestructible Paint Ltd shall in no event be liable for any special, incidental or consequential damages.

Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: sales@indestructible.co.uk
