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**Product Name:** Paint Ammunition Stoving Finish – Colour Range  
(Lead and Chromium free)

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**Product Number:** IP80-25-(Range)

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**Product Description:** Single coat quality stoving enamel for use on ammunition. Resistant to a range of conditions and chemicals. Spray or dip. For use in conjunction with Def 80-123 on ferrous and Def 80-124 on non ferrous ammunition, and non ammunition components, or as a single coating.

Under normal circumstances a single coat of Def 80-25 top coat is applied over suitably pre-treated substrates, e.g. ferrous substrates; phosphated (to Def Stan 03-11) or non ferrous substrates painted with pre-treatment primer to Def 80-15 (our IP80-15).

Full system will protect exterior of phosphated steel ammunition for up to 10 years under all but the most arduous of conditions.

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**Approvals/Specifications:** - Def Stan 80-25 / 3

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**Performance:**

- Tested to Defence Standard 80-25
- **Colour:** to Order
- **Gloss:** Matt, Semi-Gloss or Gloss
- **Bend test:** 6mm mandrel
- Scratch BS3900; E2; 1000gm load
- Impact BS3900; E8; no sign of removal
- Resistance to white spirit
- Resistance to mineral oil
- Humidity resistance BS3900; F9; 10 days
- Salt Spray BS3900; F12; 14 days

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**Components:** Single Pack Product. May be thinned for application by using 665-550-025

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## Application:

<b>Surface Preparation:</b>	Surfaces must be clean and grease free. Suitable for application over ferrous substrate primed with Def 80-123 primer. Non-ferrous substrate primed with Def 80-124. Under normal conditions a phosphate in accordance with Def 03-11 or a BS2X32 Etch primer may be used.
<b>Paint Preparation:</b>	Stir well before use.
<b>Application Method:</b>	Thin to application viscosity with 5 - 10% (vol) 665-550-025 Spray to 25-25 microns dry film thickness
<b>Drying Curing:</b>	<b>Air Dry:</b> 15-20 minutes <b>Heat Cure:</b> stove 1 – 1.5 hour at 150 +/-8°C

## Technical Properties:

<b>Supply Viscosity:</b>	95-105 Sec / ISO 5 flow cup @ 23±2°C
<b>Flash Point:</b>	≥22°C & ≤32°C
<b>VOC Content:</b>	520 gm / per litre
<b>Colour:</b>	To Order
<b>Pack Size:</b>	5 Litres
<b>Specific Gravity:</b>	1.29 g / cm <sup>3</sup>
<b>Gloss:</b>	Matt, Semi-Gloss, Gloss
<b>Thinner:</b>	665-550-025
<b>Solvent/Clean Up:</b>	40006 Gun Cleaner
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	17m <sup>2</sup> / litre @ 25 micron dft *

\* At 100% transfer efficient

## 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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