

Technical Data Sheet



Product Name: Lead Free Stoving Ammunition Lacquer

Product Number: IP80-25 (09982)

Product Description: Lead free stoving ammunition lacquer for use on various ammunition components including naval shells missiles etc. For use by Triservice, Army, Navy and RAF. Previously known as CS 3100 B

Approvals/Specifications:

- Was released to Def Stan 80-35, Issue 1, which was cancelled in June 2001. Nevertheless, we still test this product to the requirements of Def Stan 80-35
- CS 3100

Performance: Released to the requirements of Defence Standard 80-25

Components: Single component baking product. May be viscosity adjusted for application with 665-550-025 Thinner.

Application:

Surface Preparation: 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 primer may be used.

Paint Preparation: Stir well before use.

Application Method: By spray over suitable pre-treatment. Normally 2 coats.

Drying Curing: Cure 1 hour at 140°C

Technical Properties:

Supply Viscosity:	45±5 seconds (ready to use)
Flash Point:	≥21°C & <32°C
VOC Content:	nominal 500 g/lt
Colour:	Clear
Pack Size:	5 Litres
Density:	1.1 – 1.3kg/l
Gloss:	Glossy
Thinner:	665-550-025
Solvent/Clean Up:	40006
Catalyst:	N/A
Theoretical Coverage:	16 sq / m per liter @ 25 microns

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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