

Product Name: Phenol Formaldehyde Range of Stoving Type QX
Lacquers

Grades 22%, 30% & 39% - to Def Stan 80-92

Product Number:

- **Clear**
 - o 22% - 27520 (previously 18669)
 - o 30% - 27521 (previously 18668)
 - o 39% - 18670
- **Red**
 - o 22% - 27523 (previously 18679)
 - o 30% - 27524 (previously 18683)
- **Yellow**
 - o 39% - 27531
- **Green**
 - o 30% - 26740

Product Description:

Stoving lacquer for brass, aluminium and steel inside shells in direct contact with explosives. Phenol Formaldehyde lacquer for application to suitable prepared metal substrates. The lacquer provides a corrosion resistant finish against salt water spray. The three lacquers being differentiated by the non-volatile content, 22%, 30% and 39%. Designation QX indicates that the material is a quality likely to be suitable for application to a high degree of compatibility with explosives is a requirement and it can be tinted black, red, yellow, green or clear for identification purposes.

As a replacement for L3128, it has been used by such customers as Rolls Royce and Smiths Industries, in applications like VC10 fuel tanks.

Approvals/Specifications:

- Conforms to Defence Standard 80-92, Issue 2, previously CS 2465
- Previously CS 2465
- MIL L6806 approved for use on the G222 Italian Aircraft
- Manufactured with a resin replacement for Bakelite L-3128
- NSN 8010-99-587-3774

Performance:

The product conforms to Def Stan 80-92, Issue 2, which includes the following:

- Resistance to salt spray BS3900, Part F4 for 10 days
- Resistance to water BS3900, ANX D
- Resistance to nitro-benzene – ANX D no loss
- Resistance to bend test – around 10mm mandrel
- PH of aqueous extract 6.5 ± 1.5
- Coloured products contain less than 1% of approved dye
- Resists acetone to BS509

Components:

Single Pack Product. Do Not Thin.

Application:

Surface Preparation:

Ensure all surfaces are clean and free from dirt

Paint Preparation:

Use as supplied

Application Method:

Can be applied by spraying or dip (brush on small areas). Use at supply viscosity; do not thin. Solids content defines final dry film thickness.

Drying Curing:

Flash off: 20-30 minutes

Stove: 30 minutes @ 135°C (275°F)

Technical Properties:

Supply Viscosity:	Ready for Use
Flash Point:	-
VOC Content:	-
Colour:	See List
Pack Size:	5 Litres
Density:	-
Gloss:	Full Gloss
Thinner:	18662
Solvent/Clean Up:	18662

Technical Data Sheet



Catalyst: N/A

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

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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