
Product Name:Rockhard Stoving Enamel

Product Number:IP9166 – Grey

Product Description:

Grey tinted epoxy stoving enamel. Grey BS381C, 693 formulated for a low odour high flash coating with optimum performance to MSRR9032.

Formulated for Rolls Royce for use in areas such as engine support frames and airframe components. The latter being specifically for companies such as Grumman. MSRR9302 is now an obsolete standard and the use of coatings to MSRR9226 commonly replace this coating variant.

Approvals/Specifications

- MTU Spec – MTS 1012
- MSRR9032, now cancelled. Use MSRR9226 as alternative
- Was OMAT 730A, alternative to P13114, 1824-P-6140, PP478 – RR code 139101

Performance:

Tested to MSRR9032

Tested as a system with Primer 700-155-003, meets the requirements of multiple specifications to include:

- 10 Cycles, 4 hours @ 220°C (430°F), followed by 20 hours continuous salt spray
- 100 Hours resistance to salt water fog
- High Temperature; 100 hours @ 220°C (430°F)
- 3 Hours at 70°C (160°F) resistance to Skydrol
- 100 Hours resistance to lubricating oil

Application:**Surface Preparation:**

Substrates must be clean, dry and grease free. Bare metal adhesion is improved through abrasion or grit blasting. Normally applied to clean metal or pre-treated substrate.

Paint Preparation:	Single pack range of products – may be applied at supply viscosity. Thinning with up to 10-20% 665-550-025 may be required for application. An application viscosity of 30-40 seconds ISO 5 is recommended.
Application Method:	Apply by spray; conventional or H.V.L.P.
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.

Technical Properties:

Supply Viscosity:	Clear; 60 - 70 seconds ISO5 @ 23±2°C
Flash Point:	24°C
VOC Content:	average 510 g/litre
Colour:	Grey
Pack Size:	5 Litre.
Density:	1.09 kg/litre
Gloss:	Gloss
Thinner:	665-550-025
Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	N/A
Theoretical Coverage:	15.5 sq m/litre @ 25 micron

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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