

Technical Data Sheet



Product Name:

Erosion Coating Light Green

Product Number:

K900 - Rockhard

Product Description:

Designed as a turbine blade erosion resistant coating, to replace Du Pont's Teflon S. highly ground, lightly pigmented material for spray application and curing at 190°C.

Approvals/Specifications:

Preparatory Coating to be used where the performance quoted below is a primary requirement.

Performance:

Tested to DTD5562 including 6 months intermittent salt spray (DEF 1053 method 36)

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

- Salt Spray; 1,000 hours to ASTM-B117 (non-scribed)
 - High Temperature; 1,000 hours @ 220°C
 - Low Temperature Resistance; 24 hours @ -50°C
 - Aerospace Fuel Resistance; 48 hours @ 40+/- 2°C
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Components:

Single component coating – To be used with Thinner 665-550-025

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. May be used as an adhesion promoting coating on some composite substrates.

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:

The part shall be sprayed with one coat of K900 and allowed to air dry for a minimum period of 3 minutes. A further coat of enamel shall then be applied and allowed to air dry for a minimum of 15 minutes.

This will give a dry film thickness of approximately 0.025mm-0.050mm

Where further coats are to follow, the enamel shall be stoved at 150°C ±5°C, maintaining this temperature for 30 minutes.

Repeat the above until the required thickness has been reached.

Drying Curing:

The final coat shall be stoved at 190°C±5°C maintaining this temperature for 1 hour.

Technical Properties:

Supply Viscosity:	55-60 secs, ISO5 @ 23°C
Flash Point:	26°C closed cup
VOC Content:	552 g/l
Colour:	Light Green
Pack Size:	1, 5 litre containers
Density:	1.13 g/ml
Gloss:	Gloss
Thinner:	665-550-025 or alternatives
Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	N/A
Theoretical Coverage:	18 sq m/lt @ 20 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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