
Product Name: Single Pack Thick Film Abradeable Coating

Product Number: NML46

Product Description:

NML46 is a thick abradeable mastic coating, single pack product which is used on engine compressor components.

NML46 expands and contracts with the base metal to provide a replaceable wear away coating worn or damaged rings, which can be very costly and time consuming.

NML46 can be machined once cured, and is resistant to oils, fuels and abrasion.

Storage / Shelf Life:

NML46 is an unusual pre-catalysed product that needs careful storage to ensure consistent quality.

Storage in a freezer at $-20\pm 3^{\circ}\text{C}$ is required. A normal domestic freezer will meet this requirement.

For delivery overseas it is difficult to provide specific transport and storage requirements. Transport in Dry Ice is an option but this is only good for maintaining a very low temperature for 3 days. Our generic recommendation is:

- Store the NML 46 deep frozen until collection from our or a distributors facility. Despatch and transport as quickly as possible to the end user where the material is returned to deep frozen storage ($-20\pm 3^{\circ}\text{C}$).

During transit we are happy for a gap of 1-2 weeks out of a freezer storage environment but the material must be kept as cool as possible.

Approvals/Specifications:

- MSRR 9012
- Rolls Royce Code: 139252, 139019
- OMat 7 / 78
- MTU: MTS 1304

- RPS 340 / 4
- Turbomecca: TM9590000181
- Turbomecca to LB 538

Performance:

Abradable chemical resistant coating for use where engine compressor blade to casing tolerances are required to be kept at a minimum.

Components:

Single Pack Product.

Application:

Surface Preparation:

Ensure Surface is Clean and Free From Dirt

Paint Preparation:

De-frost before use. After de-frosting the material must be used immediately. Do not re-freeze the product.

Application Method:

Apply to RPS 340/ 4.

Various methods are in use; the main one being the substrate is thoroughly cleaned and then primed using NML 52.

The NML 46 is thawed and then rolled or pressed into a 'Kipper'. Using a release sheet, is it then applied to the component face, which may be heated to 60-80°C, using the release sheet as a backing strip. The compound may then be compacted into position with a small roller and the backing paper removed with great care –

Apply for RPS 482 / 31

Drying Curing:

- Heat for 1 hour at 80±5°C followed by an increase in temperature to 125±5°C over a period of 30 minutes
- Heat for 1 hour at 125±5°C followed by an increase in temperature to 180°C over a period of 30 minutes
- Heat for 2 hours at 180±5°C
- The cure cycle shall be continuous

Technical Properties:

Colour:	Grey or Black
Pack Size:	1 Kilo – Approx 4 Sticks Per Kilo
Density:	1.75 ±0.05kg/l
Gloss:	N/A
Solvent/Clean Up:	40006 Gun cleaner
Theoretical Coverage:	5.5 sq m/kg @ 1000 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:

For Safety Data Sheets please contact our Sales Department:

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