
Product Name:Rockhard Stoving Enamel

Product Number:

- 985-000-693 – Grey
 - 985-000-694 – Green
 - 985-000-695 – White
 - 985-000-696 – Black
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Product Description:

Rockhard stoving finishes formulated for use over 700-155-003 Rockhard chromate primer. Can also be used over IP985-6500 chromate free primer when specified.

Grey BS381C, 693 is specifically formulated for a low odour high flash coating with optimum performance to MSRR 9226. Rolls Royce alternative to 580-0097-6.

The green and white have been formulated specially for Rolls Royce Canada and are for use in such areas as engine support frame products and airframe components for companies like Grumman. Black gloss is for use also by RR Canada the Nene engine, although not released to MSRR 9226 all colours are tested to meet the MSRR 9226 standard.

Approvals/Specifications:

- DTD 5562
 - MSRR 9226, RPS661/21, OMat 7 / 99A (Grey Only)
 - Turbomeca within CT610 to LB714
 - CPW 489.2 (LCPMC 71489) (Black Only)
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Performance:

Tested to DTD 5562 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 Pack Product. May be thinned for application using 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:

Apply by spray; conventional or HVLP. For full details, refer to Indestructible Application Guide IPAS-21. Request RPS661/21 for Rolls Royce parts.

Drying Curing:

Flash off: 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 555 g/litre
Colour:	Grey, Green, White, Black
Pack Size:	1 & 5 Litre
Density:	1.1-1.17 kg/litre
Gloss:	Gloss
Thinner:	665-550-025

Technical Data Sheet



Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	N/A
Theoretical Coverage:	15.5sq 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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