



## ROCKHARD CLEAR STOVING ENAMEL & MICROPOROUS CASTING SEALER



**IP CODE NUMBER:** 576-450-002-R1

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### PRODUCT DESCRIPTION

Known sometimes as a '961' based resin, Rockhard clear stoving enamel has proved its worth over 4 decades, as one of the best protective coatings for metals to erosion, corrosion, including salt water and chemical resistance at elevated temperatures particularly on Aluminium and Magnesium and as such is recommended by Magnesium Elektron, the leading suppliers of Magnesium in the UK.

Rockhard is used in many industries. For example; Volvo air intakes, coating turbine blades, computer chassis for insulation purposes, and heat exchangers and radiators where it has enabled Aluminium to replace Copper in some applications. It is acknowledged as a leading product for curing micro-porosity used on engine blocks and turbo pipes etc.

Its history includes protection of the Magnesium skins of the Westland Wessex helicopter and parts of the Comet Jet liner. Since then it has been widely used in the aircraft industry where maximum protection is needed on Aluminium, Steel, Titanium and Magnesium, in marine and other harsh environments. Amongst the latest organisations to approve this product are Sikorsky for use on their AH 60 helicopter, McDonnell Douglas on their MD 500 range, and Pratt and Whitney Canada on their PT6, PT100, and 4000 range. In February 1995, GE approved this material for use on the F110 gearbox housing. The most recent approval has been by Parker Hannifin (Nicholls Aircraft Division) on the G 4461 model.

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### APPROVALS / REFERENCES / SPECS

DTD5562; OMAT 7/146; Previous Reference 444/176;

P&W Canada: CPW 489 / CPMC 79964/ 07-017 / PWA – 36490; PWC 10183

Mc Donnell Douglas HP 4-133; Williams International CP4240; Hamilton Sundstrand HS 4675

Allied Signal (Textron) FP5109, P6426, P6404; Parker Hannifin (Nichols Aero engine division) MCS 145;

Quality paints and lacquers manufactured by: [Indestructible Paint Ltd](#)  
19-25 Pentos Drive, Sparkhill, Birmingham B11 3TA. Tel:0121 702 2485; Fax 0121 778 4338



GE - A8B84 - S  
Sikorsky Aircraft - SS8688  
Honeywell-AlliedSignal - FP5109  
Hamilton Sundstrand San Diego ESR 1187  
McDonnell Douglas(Boeing) HP 4-133  
CPW 489  
Pratt & Whitney Aircraft PWA 36490  
General Electric Aircraft Engines P6D2  
Nichols Aircraft Parker Hannifin MCS-145  
Williams International CP4240  
Boeing D210-13512-1

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## PERFORMANCE

Tested to DTD 5562, which includes: 6 months intermittent salt spray (DEF 1053 method 36), resistance to humidity, Trichloroethylene and re-chromating.

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## APPLICATION

Many different application specifications have been drawn up by users and advice is available from our technical department for various methods including dip and spray.

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## PHYSICAL PROPERTIES

Mixing Ratio	One Part Product
Thinner	665-550-025
Supply Viscosity	19-24 seconds B4 cup at 20°C
Cure	30-60 minutes at 170-200°C metal temperature
Colour	Golden Brown Clear
Gloss Level	Full Gloss
Film Thickness	Approximately 10 microns per coat
Flash Point / Class / UN No	24°C / 3 / Paint UN1263
Pack Size	1, 5 and 25 litre UN approved containers
Shelf Life	12 months