

## Firwood 2402

### High Solids, Finishing For Ammunition, Stoving Semi-Gloss to Def Stan 80-25

<b>Description</b>	A general purpose stoving semi-gloss paint for exterior use.			
<b>Features</b>	<ul style="list-style-type: none"> <li>• Designed as a finish for ammunition to DEF STAN 80-25.</li> <li>• Can be used as a one coat finish, or applied over a suitable primer for extended durability.</li> <li>• A full system of one coat of primer plus one coat of finish, applied over a phosphated steel substrate, will protect against corrosion for up to 10 years, in all but the most aggressive conditions.</li> </ul>			
<b>Finish</b>	Semi-gloss.			
<b>Complies With</b>	DEF STAN 80-25.			
<b>Product Code</b>	2402- .			
<b>Volume Solids</b>	58% ± 2%.			
<b>VOC's</b>	Below 380 g/l.			
<b>Colour Range</b>	Service Brown and special shades made to order.			
<b>Film Thickness &amp; Coverage</b>	<b>Typical:</b>	<u>Dry</u> 50 µm	<u>Wet</u> 86 µm	<u>Theo. Coverage</u> 11.6 m <sup>2</sup> /l
	Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.			
<b>Drying &amp; Overcoating Times</b> at Typical DFT	<p><b>Flash Off:</b> a flash-off period of approx. 10 min should be allowed before stoving.</p> <p><b>Conventional Stoving:</b> 30 min at 120°C.</p> <p><b>Radiant Heat (Infra-Red):</b> this product is suitable for radiant heat curing, but due to the many variables such as weight, configuration, reflectivity and distance from heat source, a suitable project schedule must be determined.</p> <p>Stoving schedules will vary with the size and weight of the coated article, and the type of equipment used. The above information is given as a general guide.</p>			

**TECHNICAL DATA SHEET****Firwood 2402****High Solids, Finishing For Ammunition, Stoving Semi-Gloss to Def Stan 80-25**

<b>Surface Preparation</b>	<ul style="list-style-type: none"><li>All surfaces should be dry and cleaned as necessary to remove all oil, grease, corrosion or other contamination.</li><li>Where a Ministry Approved Primer is directed to be used, the following is normally specified: <b>Ferrous Metals:</b> Trimite D14570 - Paint, Priming, Zinc Phosphate, Air Drying/Stoving, Spraying to Specification DEF STAN 80-123 and 80-126 Eau-De-Nil.</li></ul>
<b>Mixing</b>	Thoroughly stir the coating before use. A power mixer is highly recommended. A wide-bladed stirrer is essential for adequate mixing if only hand stirring. Stir occasionally during use to maintain an homogenous mix.
<b>Mix Ratio</b>	Not applicable – single pack product.
<b>Application Conditions</b>	Throughout the application and the drying/curing time of coatings: (a) good ventilation is required; (b) do not apply when damp weather conditions are likely; (c) the substrate temperature should be at least 3°C above the Dew Point; and (d) the RH (Relative Humidity) should be below 85%. It is advisable not to apply the product when the ambient temperature falls below 5°C. The paint temperature at the time of application should ideally be 15° - 20°C.
<b>Application Details</b>	<ul style="list-style-type: none"><li>Ministry Approved for conventional spraying. This material is supplied 'Ready for Use Spraying'. Thinner ST60 may be added up to 10% by volume, to obtain a suitable viscosity at application temperature.</li></ul>
<b>Thinner/Cleaner</b>	Firwood 113 Thinner (for cleaning).
<b>SG</b>	1.57 ± 0.15 kg/l.
<b>Flash Point</b>	23°C – 60°C.
<b>Shelf Life</b>	Minimum of 2 years from date of manufacture when correctly stored in unopened containers.
<b>Storage</b>	The product should be stored in cool, dry, frost-free conditions, in sealed containers. Most paint materials will apply optimally when at 15° - 20°C.
<b>Health &amp; Safety</b>	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
<b>Date of Issue</b>	Sep 2022.

Information provided in this leaflet is given in good faith but without warranty or assumed liability, as the conditions of application and use are beyond our control. Data are accurate to the best of our knowledge at the time of issue but may be revised in the light of new knowledge and the user should check that data are current before use. The user must satisfy themselves about the product's suitability for their own purpose and refer to the Safety Data Sheet for this product before use. For industrial use only unless specifically stated otherwise.