



PRODUCT NAME**69X0545 BLUE VARNISH**

DESCRIPTION

Excellent unpigmented coating for engine components and metal parts requiring corrosion resistance. Conforms to AMS 3132J and MIL-PRF-3043. Also meets requirements of PWA830 (Pratt & Whitney).

PRODUCT DATA

TYPE:	Thermosetting Phenolic Resin
SOLIDS:	30% \pm 1%
WEIGHT/GAL:	8.0 \pm 0.1 lbs/gal
VISCOSITY:	20 – 50 centipoise (or 40 – 47 sec. Z1) @ 77° F.
COLOR:	Blue in solution. Dry film turns to a greenish shade upon baking.
APPLICATION:	Dip or Spray
SUBSTRATES:	Clean Metals preferably degreased with chlorinated solvents.
REDUCTION:	None required or may be reduced with 80X0169 Thinner or 79X0434 (AMS 3132 Thinner.)
REC'D FILM THICKNESS:	0.3 – 0.5 mils
CURING:	Air dry to top coat 15 minutes @ 77° F. After 15 minutes air dry; the film should be baked 20 minutes @ 335° F or 50 minutes @ 290° F.
FLASH POINT:	60° – 70° F (Tag Open Cup).
STABILITY:	Keep in tightly closed containers and store between 40° - 90° F. Under these conditions, the product will remain stable up to 18 months from date of manufacture.



REMOVABILITY:

Option 1: Soak 1 hour in Methylene Chloride.
Option 2: Submerge in cleaning solution described below that is maintained at $200^{\circ}\text{F} \pm 5^{\circ}\text{F}$ ($93.3^{\circ}\text{C} \pm 2.8^{\circ}$). A soft bristle brush may be used, if necessary, to facilitate removal. Cleaning solution shall be prepared by dissolving 8 oz. of the following mixture in 1 gallon of water. Commercial grades of materials may be used.

Parts by weight

Sodium resinate	1
Sodium metasilicate	3
Trisodium phosphate	1
Sodium carbonate	2
Sodium hydroxide	4