

## IPAS 25

### IP9064-4853 / 4854: 2 component chromate etch primer

### IP3-4853/4854: 2 component chrome free etch primer

#### 1. Scope

- 1.1. This document covers the application and curing of the IP9064-4853 / 4854 2 component chromate etch primer and IP3-4853/ 4854 chrome free etch primer. These materials are primarily designed for use as adhesion or wash primers, typically on aluminium in place of chemical conversion coatings, to aid adhesion and improve corrosion resistance
- 1.2. This procedure covers all versions
- 1.3. Please read this document in conjunction with any specifier drawings or application information sheets

#### 2. Substrate Preparation

- 2.1. All substrates must be clean, grease and dust free prior to painting
- 2.2. The normal minimum surface preparation should be solvent or aqueous degrease and dry. Abrasive blast with 120/220 aluminium oxide grit will give improved performance.
- 2.3. For certain applications, on small parts, a mechanical abrasive clean with abrasive paper can be used, subject to end user evaluation / approval

#### 3. Coating Preparation

- 3.1. Ensure that the material is thoroughly mixed prior to use. The base component could settle on standing due to the technical composition of the material. Thorough mixing that is designed to lift any settled material from the base of the container is essential prior to coating application
- 3.2. **Mixing:** Both IP9064-4853 / 4 and IP3-4853 / 4 are two component products and requires mixing with catalyst before use
  - 3.2.1. Mixing Ratio: IP9064-4853 / 4 chromate etch primer  
Mix in the ratio 1 part by volume IP9064-4853 base to 1 part volume IP9064-4854 activator
  - 3.2.2. Mixing Ratio: IP3-4853 / 4 chrome free etch primer  
Mix in the ratio 1 part by volume IP3-4853 base to 1 part volume IP3-4854 activator
  - 3.2.3. Mixed Pot Life: 4 hours

- 3.3. The mixed material will be read for use for spray application. As necessary 5-10% thinner IP9064-TDXL may be added

Viscosity measurement prior to application may be performed at the discretion of the end user.

## 4. Application and Curing / Baking

- 4.1. The coating is designed for spray application using conventional or HVLP air atomising spray guns. It is recommended that latest generation 'compliant' spray guns are used to provide the best finish with minimal orange peel. Other methods may be employed subject to end user evaluation and approval for specific components
- 4.2. Parts shall be sprayed with one thin wet coat. This process will give a typical wet film thickness of 15 microns, nominal 7-8 micron dry film thickness.
- 4.3. The etch primers can be allowed to cold cure (air dry) or can be force cured.

### 4.3.1. Air Drying / Cold Curing:

- Minimum room temperature: 12°C (55°F)
- Surface dry / handleable: 20-30 minutes
- Hard dry to overcoat: 1-2 hours

### 4.3.2. Force Curing:

- Air dry / flash off: 20-45 minutes at room temperature
- Cure: Typically 30 minutes @ 70-90°C (160-195°F)

## 5. Coating Thickness

- 5.1. The recommended dry coating thickness is 5-16 microns

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