

## IPAS 78

### IP7800: Heat Resistant Coatings

#### 1. Scope

- 1.1. This document covers the application and curing of the IP7800 range of air drying heat resistant coatings. These materials are primarily designed for use as rapid air drying coatings to resist temperatures up to 300°C, although other applications may be applicable subject to end user approval.
- 1.2. This procedure covers all clear and pigmented versions
- 1.3. Please read this document in conjunction with 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. Minimum surface preparation should be shot blast to SA 2-2½, or grit blast using 120 / 220 grit aluminium oxide

#### 3. Coating Preparation

- 3.1. Ensure that the material is thoroughly mixed prior to use. The coating 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. The stirred material will require thinning for spray application. Typically 10-15% of thinner IP7800-Reducer is required to give best atomisation.

#### 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 application 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 a mist coat, followed by two cross coats, to achieve a typical 30-40 micron dry film thickness.
- 4.3. The range should be allowed to air dry (cold cure) but can be force cured as / if required
  - 4.3.1. **Air Drying / Cold Curing**
    - Minimum room temperature: 12°C
    - Surface dry: 30 minutes
    - Hard Dry to pack / ship: minimum 4-5 hours
    - Allow 24 hours before using coated product.

#### 4.3.2. Force Curing:

- Air dry / flash off: 30 minutes at room temperature
- Cure: 1 hour @ 100°C (212°F)

#### 5. Coating Thickness

- 5.1. The recommended dry coating thickness is 30-40 microns

#### 6. Touch-Up

- 6.1. Damaged areas may be spot repaired in accordance with end user specifications
- 6.2. The coating immediately adjacent to the damaged area should be feather using 240-320 grade abrasive paper or equivalent. The damaged area must be thoroughly cleaned and degreased. The touch in coating may be spray or brush applied. Air dry or force cure as per clauses 4.3.1. or 4.3.2.

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