

IPAS 15

IP9029-R3 High Heat Resistant Aluminium Coating:

1. Scope

1.1. This document covers the Application and Curing of IP9029-R3 High Heat Resistant Lead Free Stoving Aluminium. This material is primarily designed for application to ferrous substrates although other applications may be applicable subject to end user approval.

1.2. 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. Abrasive Blast using 120/220 Aluminium Oxide grit is the recommended substrate preparation

N.B: Alternative methods may be employed subject to end user specifications / type testing

3. Coating Preparation

3.1. Ensure that the material is thoroughly mixed prior to use. The coating will 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 coating is supplied ready for use, or a solvent addition of up to 10% by volume of IP985-Reducer (thinner) may be used

3.3. Pot Life: IP9029 requires baking to cure and does not have a defined pot life. After mixing the Aluminium component of the coating will settle with time. Any Paint that is left in a spray gun and/or thinned for application must be suitably mixed before each use. Operators must ensure that any paint left in a spray gun is thoroughly mixed before each use. A guide value for the time paint is allowed to settle in a spray gun is 120 minutes maximum before the gun should be emptied and cleaned.

3.4. The coating is released at a viscosity of: 32-38 seconds ISO4 flow cup @ 23±2°C

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

4. Application and Stoving / Baking

4.1. The coating is designed for spray application using conventional or HVLP air atomising spray guns. Other methods may be employed subject to end user evaluation and approval for specific components

4.2. Parts shall be sprayed with wet on wet coats allowing a 2-5 minute dwell between each coat. This process may be used up to a maximum wet film thickness of 175 microns, nominal 50 micron dry film

- 4.3. Where coatings above 50 microns dry film thickness are required, intercoat stoving will be required.
Follow clause 4.3.1

4.3.1. Repeat clause 4.2 to give the required layer thickness, allow to air dry for 15 minutes. Stove /
bake at 150°C (300°F) for 30 minutes then allow to cool. Repeat as required.

- 4.4. Final cure shall be at 190±8°C (375±15°F) for a minimum of 2 hours.

4.5. Coating Application – Environmental Conditions

During coating it is recommended to work within a 30-70% Relative Humidity (RH) and temperature range of 15-30°C (59-86°F). During flash off before baking the coating requires consistent extraction to remove VOC's.

5. Coating Thickness

- 5.1. The recommended dry coating thickness is 25-70 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. Stoving must be performed as per clause 4.3 to 4.4