

## IPAS 043b

### IP9042 2 Pack Epoxy Gloss Kit

#### Introduction

IP9042 kit is a three part kit designed to provide an air drying touch up system for components coated with Rockhard 576 stoving varnish.

The product consists of three parts:

- **Base:** IP9041 (also known as 750-450-004)
- **Catalyst:** IP9039 (also known as 656-450-002)
- **Thinner:** IP9038 (also known as 665-550-025)

#### Approvals

Complies with various aerospace specs including Pratt and Whitney Canada, Textron, (Allied Signal etc), Rolls and DTD 5555.

- IP9041 Base: PWC07-038; PWC50069; CPMC 71330; NSN: 8010-99-752-6083
- IP9039 Catalyst: PWC07-039; PWC03055; CPMC 71331; NSN: 8010-99-797-4869
- IP9038 Thinner: NSN: 8010-99-517-2527

#### Mixing

2 pack product; base & catalyst must be mixed in the following ratio prior to use:

- IP9041 Base: 1 Part by Volume
- IP9039 Catalyst: 1 Part by Volume

Stir thoroughly; allow mixed liquid to catalyse for 15 minutes before use.

Stir again thoroughly before use.

**Mixed pot life:** 4-6 hours dependent upon temperature & humidity conditions.

#### Application:

The mixed product can be applied by spray and brush (on small areas) when applying by brush, use as mixed.

When applying by spray, use as mixed – Can be thinned if required (dependent upon spray gun) by an addition of up to 10% thinner.

Clean up: use thinner IP9038 to clean all equipment etc

## Drying / Curing

Product will air dry (cold cure) or can be force cured

- **Air Dry:** Times for both surface dry and hard dry will be dependent upon temperature; the lower the temperature, the longer the cure. Times quoted here are at 20°C (68°F)
  - o *Surface/ Dust Dry:* 45 minutes to 1 hour
  - o *Hard Dry:* 16-24 hours
- **Force Cure:** Typically:
  - o 20 minutes @ 125°C (257°F)
  - o 40-60 minutes @ 80°C (175°F)

For chemical hardness will be achieved after 7 days

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