

## IPAS 043e

### IP9064 Range 2 Component Epoxy Finishes

#### 1. Scope

1.1. This document covers the application and curing of the IP9064 Range of 2 component epoxy finishes. These materials are primarily designed for use over IP9064 2 component epoxy chromated or chrome free anti-corrosive primers in an aerospace coating system, although other applications may be applicable subject to end user approval.

1.2. This procedure covers all versions

1.3. Please read this document in conjunction with any specifier drawing or application information sheets.

#### 2. Substrate Preparation

2.1. All substrates must be clean, grease and dust free prior to painting

2.2. IP9064 finishes are normally applied as the finish coat over IP9064 2 component epoxy primers, both chromated and chrome free.

2.3. In certain cases IP9064 finishes can be applied to correctly pre-treated metal substrates. The minimum requirement would be degrease and grit blast using 120-220 aluminium oxide grit, or chromated or chrome free conversion coatings.

2.4. 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 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. **Mixing:** The IP9064 range is a two component product, and requires mixing with IP9064-CAT or IP9064-CATM before use. Please refer to the base component can label for the correct volumetric mixing ratio (NOTE: the mixing ratio can vary from colour to colour)

3.2.1. An induction time of 15 minutes is required following addition of the catalyst. Re-stir the mix before use.

3.2.2. Mixed Pot Life: 4 hours

3.3. The mixed material will be ready for use for spray application. An additional 5-10% IP9064-Thin may be added to ease atomisation and for applying thin films onto complex components.

#### 4. Application and Curing / Baking

**4.2 Application Parameters:**    Temperature range: 12-30°C  
Relative Humidity: 30-70%RH

4.4 The range can be allowed to cold cure (air dry) or can be force cured.

- Minimum room temperature 12°C (55°F)
- Surface dry / handleable: 4 hours
- Hard dry to overcoat: minimum 16 hours
- Full chemical hardness: 7 days

- Air dry / flash off: 20-45 minutes at room temperature
- Cure: Typically 60-90 minutes @ 70-90°C (160-195°F)

5.1 The recommended dry coating thickness is 25-35 microns

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 feathered 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 4.4.1. or 4.4.2.