
IPAS 043d

IP9064 Range 2: 2 Component Epoxy Anti-Corrosive Primers:

1. Scope

- 1.1. This document covers the application and curing of the IP9064 range of 2 component epoxy primers, to include IP9064-6362; IP9064-6362-309 and IP9064-6500. These materials are primarily designed for use as the chromated or chrome free anti-corrosive primer 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 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 abrasive blast with 120 / 220 aluminium oxide grit. It is more normal to utilise either a chromated or chrome free immersion conversion treatment or a chrome free or chromated anodic pre-treatment.
- 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 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 required mixing with catalyst before use.
 - 3.2.1. Mixing Ratio: IP9064-6362 Strontium Chromate Primer
Mix in the ratio 4 parts by volume IP9064-6362 to 1 part by volume IP9064-CAT
 - 3.2.2. Mixing Ratio: IP9064-6362-309 Strontium Chromate Primer, yellow
Mix in the ratio 4 parts by volume IP9064-6362-309 to 1 part by volume IP9064-CAT

3.2.3. Mixing Ratio: IP9064-6500 Chrome Free Anti-Corrosive Primer

Mix in the ratio 2 parts by volume IP9064-6500 to 1 part by volume IP9064-CAT-MAT

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

3.2.5. Mixed pot life: 4 hours

3.3. The mixed material will be ready for use for spray application. As necessary, 5-10% thinner IP9064-THIN 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 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 wet on wet coats allowing a 2-5 minute dwell between each coat. This process will give a typical wet film thickness of 50 microns, nominal 20-25 micron dry film.

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

4.3.1. Air Dry:

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

4.3.2. Force Curing:

- *Air Dry / Flash Off:* 20-45 minutes at room temperature
- *Cure:* typically 60-90 minutes @ 70-90°C (160-195°F)

5. Coating Thickness

5.1. The recommended dry coating thickness is 18-30 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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