

IP9136-R1 PL239 Eq. Dry Film Lubricant:

Application and Curing Procedure

1. Scope

- 1.1. This document covers the Application and Curing of IP9136-R1 Graphite Dry Film Lubricant. This material is primarily designed for application to ferrous and aluminium 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, green and dust free prior to painting
- 2.2. Surfaces shall be prepared by wet abrasive blasting with 280 / 500 mesh Aluminium Oxide.
- 2.3. Abrasive Blast using 120/220 Aluminium Oxide grit can be used for steel substrates
- 2.4. On aluminium substrates, abrasive blasting may be omitted where the surface has been anodised or treated with a chemical conversion coating

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 665-550-025 or IP9151 thinner may be used.
- 3.3. 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 atomizing spray guns. Other methods may be employed subject to end user evaluation and approval for specific components.
- 4.2. Parts shall be sprayed with one coat and allowed to air dry for 10 minutes before applying

4.3. The following table indicates the number of coats required to achieve required thickness:

Total Coating Thickness (mm)	No of coats to be applied
0.003-0.015	3
0.008-0.030	4
0.025-0.051	6
0.047-0.076	8

4.4. The applied coating shall be allowed to flash off for 15-30 minutes

4.5. Final cure shall be at $190 \pm 8^{\circ}\text{C}$ ($375 \pm 15^{\circ}\text{F}$) for minimum of 2 hours

5. Touch-Up

5.1. Damaged areas may be spot repaired in accordance with end user specifications

5.2. 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 4c to 4d

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