

IPAS 115

IP9138-R1 – Air Drying Heat and Skydrol Resistant Aluminium Coating

1. Scope

- 1.1. This document covers the application and drying of IP9138-R1 Heat and Skydrol Resistant Air Drying Aluminium. This material is primarily designed as a touch up for IP9029-R2, 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. As used as a touch up, the damaged area should be liquid degreased, rubbed down and the edge feathered, using either 240 or 320 grade abrasive paper, then re-degreased using a liquid degreaser.
- 2.3. Where used as a stand-alone coating, abrasive blast using 120/220 aluminium oxide grit is the recommended substrate preparation

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 for brushing, or a solvent addition of up to 10% by volume of 665-550-025 thinner may be used for spray application.
- 3.3. The coating is released at a viscosity of: 30-40 seconds ISO4 flow cup @ 23±2°C

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

4. Application and Drying

- 4.1. For touching up small areas the coating should be applied using a clean bristled brush. One or two coats should be applied, slightly overlapping the un-damaged areas.
- 4.2. On larger areas, the coating is suitable 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
- 4.3. Parts shall be sprayed with 2 coats, allowing a flash off of approximately 30 minutes between coats.

- 4.4. The product will air dry. Minimum room temperature to ensure correct drying: 12°C (55°F) allow minimum 1 hour before handling or packing

5. Coating Thickness

- 5.1. The recommended dry coating thickness is 15-25microns

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