

IPAS 6/3

Processing of IP9253-R2 Chrome Free Organic Sacrificial Coating

Read in conjunction with RPS 666 / 3

Pre-Agitation

IP9253-R2, like our Ipcote inorganic sacrificial aluminium, needs significant agitation before spraying. It is more stable and less prone to settling than competitive products, but ideally it should be spatulated up and then when possible rolled on paint rollers for a minimum of 24 hours before application. It can also be agitated on typical paint shakers.

Spray Guns

IP9253-R2 can be applied by most available spray guns, including Binks Bullows 630 guns, DeVilbiss JGA, HVLP and GTI compliant. Each has their own technique, but a pressure of about 40 psi on the 630 gun is about right although the pressure is dictated by the sprayers finger on the trigger.

Processing IP9253-R2

IP9253-R2 needs to be sprayed onto perfectly clean, preferably lightly blasted surface. If the material appears to go into globules, either surface treatment is not good enough, or the sprayer is trying to apply too much. A first mist coat often helps and 2, 3 or 4 coats can be applied wet on wet. A typical coat of IP9253-R2 will be 25 microns thick, (1 thou). IP9253-R2 when applied will appear a wet yellowy grey colour, which dries to matt grey.

Normal processing them is flash off 15 minutes, or to matt grey, for best smoothness of coating, 30 minutes at 190°C, then the final cure.

Final Cure

This is the process that ensures sacrificial protection

Process 'A'

The component shall then be loaded into an oven not exceeding 350°C, temperature raised to 560°C and maintained at this temperature for 1 hour minimum. Alternatively – 4 hours @ 540°C

Final cure should produce a conductive coating

Process 'B'

The component shall then be loaded into an oven not exceeding 350°C, temperature raised to 490 ± 5°C and maintained at this temperature for 2 hours minimum.

When cool, the finish is bead peened to produce a conductive coating.

Burnishing

Burnish surface with glass bead (soda lime type to CSS8), size AB, using 12 mm nozzle at an approximate distance of 150mm

Surface must be conductive after burnishing.