

IP9447-R1 Green Smoothseal

IP9447-R1 Green Smoothseal is sprayed as a light mist coat followed by wetter applications to give a smooth homogenous finish. Spraying is normally done at about 40-50psi, preferably over a lightly peened surface.

IP9447-R1 is a solid, bright green, glossy when wet and dries to a matt green, not unlike a pool table beige.

After spraying, Ipseal should be left for 15 minutes to flash off, then stoved at 80°C, then raise temperature to 350°C and hold at temperature for 30 minutes. On no account should Ipseal be left after the 80°C process, as it can 'green back'. This means that it takes up moisture from air, and becomes wet again but restoving gives an unsatisfactory finish.

Before application, ensure Ipseal is well dispersed e.g. shake or roll.

Apply to titanium or suitably cured, conductive Ipcoat IP9183, IP9356 or IP9442 (R1)

Application

Apply successive light mist coats, until a deep, uniform gloss coating is attained. An ideal gun pressure is approximately 40psi.

Curing

Flash off **in a warm, dry atmosphere for a minimum of 15 minutes**; the sealcoat will give a dry, matt appearance when read to be stoved

Final Cure

Raise temperature to 350°C and stove for minimum of 30 minutes. If the oven is incapable of this temperature, transfer to a suitable oven and the components shall then be removed from the oven and allowed to cool to room temperature.

Note

Care should be taken with the Ipseal process as it can 'green back'. This means it takes up moisture from the air and becomes wet again. If this happens re-stoving gives an unsatisfactory finish

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