

IPAS 22

PL163 & IP9134-R1 Polyimide Clear Sealer and Aluminium Filled Coating

- 1. Scope
 - 1.1. This document covers the application and curing of PL163 Clear polyimide sealer and IP9134-R1 aluminium filled polyimide coating. These materials are primarily designed for use as in an aerospace coating system where high temperature and chemical resistance is a requirement, 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 on steels, or chromate or anodising of aluminium alloys. Reference should be made to any specifier drawings on specifications

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 product is thinned with 10-20% maximum S30 thinner.
- 3.2. Mixing: PL163. The material can be spray applied at the supply viscosity, but it is recommended that the product is thinned with 10-20% maximum S30 thinner.

Mixing IP9134-R1: The material can be spray applied at the supply viscosity, but it is recommended that the product is thinned with 10-20% maximum S30 thinner

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

4. Spray Room Conditions

- 4.1. Temperature and humidity within the spray area can affect the application properties of the coating.
- 4.2. Our current recommendations on spray room conditions are as follows:

Temperature:in the range 12-30°C (54-86°F)Humidity:in the range 30-80%

4.3. These guidelines should be read in conjunction with any indicated values quoted in end user application specifications

5. Application and Curing / Baking

5.1. The coating is designed for spray application using conventional or 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.

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- 5.2. Parts shall be pre-heated to a metal surface temperature of 60-80°C prior to coating application. Two thin but wet coats should be applied, to achieve a final dry film thickness of 8-13 microns. If further coats are required or specified film thickness, return to part to the oven so that the metal surface temperature can be re-established in the range 60-80°C.
- 5.3. The products are designed for high temperature stoving / baking
 - 5.3.1. Where part baking is required between coats, the coating should be cured for 30 minutes at 150° C. It is recommended that the applied coating is allowed to flash off at room temperature for 10-15 minutes, before being put in the oven at a temperature of 60-80°C, then raising the oven temperature to $150 \pm 5^{\circ}$ C.
 - 5.3.2. Full cure is achieved by stoving / baking the coating for 2 hours at $190 \pm 5^{\circ}C$

6. Coating Thickness

6.1. The recommended dry coating thickness is 8-13 microns

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