

## IPAS 666-4TU

### IPSEAL & Sermaseal Touch Up: Water Based Inorganic

#### 1. Scope

1.1. This document covers the application and drying / curing of PL270 and PL150-R1 water based inorganic high temperature touch up paints to several user specifications including MSRR 9394. These materials are primarily designed for use as a touch up on IPSEAL sealcoats Khaki (PL270) or Green (PL150-R1) used in the manufacture of aero engines, although other applications may be applicable subject to end user approval.

1.2. This procedure covers:

- PL270 Touch Up Coating: Khaki
- PL150-R1 Touch Up Coating: Green

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 thoroughly clean, grease and dust free prior to painting. Liquid degrease as per RRP 51000 or other approved degreasing method.

2.2. Lightly rub down the damaged area with 240 / 320 wet & dry paper; feather edges of sound coating around the area of damage. Remove all traces of sanding dust.

#### 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 base of the container is essential prior to coating application. Typically the coating can be mixed by running on rollers for 2-3 hours. Ensure coating is fully dispersed before application.

3.2. The coatings are designed for application at supply viscosity. Viscosity measurement prior to application may be performed at the discretion of the end user.

#### 4. Application and Drying, Stoving / Baking

4.1. The coating is designed for brush and / or spray application using conventional or HVLP air atomising spray guns. It is recommended that latest generation 'Fine Finish Compliant' spray guns are used (such as DeVilbiss Sri HD Transtech Gravity or SATA minijet 3000 BHVLP) to provide the best finish with minimal orange peel.

Application of too heavy films will give rise to poor surface wetting and can lead to failures in adhesion, blistering etc on stoving

4.2. Apply 1 coat to give an opaque finish to the touch up area

4.3. The range can be allowed to cold cure (air dry); however, it is recommended that the coating is 'fixed' by baking as detailed below

4.3.1. **Air Drying:** The product will dry in 15-30 minutes at typical ambient temperatures. However, when just air dried, the finish is moisture sensitive, and will 're-wet' in conditions of high humidity/

4.3.2. **Baking / Stoving:** Allow the applied coating to flash off for 15 minutes. Stove for 30 minutes @ 150°C metal temperature minimum

4.4. Note: Only stoved coatings exhibit some degree of water resistance, and only those operating above 400°C become totally resistant. If coated components are to be stored for any length of time then it is recommended that the full 400°C cure be given and / or a suitable desiccant is used in the packaging.

## 5. Coating Thickness

5.1. The recommended dry coating thickness is 5-10 microns

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