IPAS 16

IP9188-R2: High Heat Resistant Erosion Coating

1. **Scope**

1.1. This document covers the Application and Curing of IP9188-R2 range High Heat Resistant Stoving Erosion Resistant Coating. This material is primarily designed for application to ferrous substrates 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. Abrasive Blast using 120/220 Aluminium Oxide grit is the recommended substrate preparation

N.B: 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, or a solvent addition of up to 10% by volume of IP985-Reducer (thinner) may be used

3.3. The coating is released at a viscosity of: 45-55 seconds ISO4 flow cup @ 23±2ºC

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

4. **Application and Stoving / Baking**

4.1. The coating is designed for spray application using conventional or HVLP air atomising spray guns. Other methods may be employed subject to end user evaluation and approval for specific components

4.2. Parts shall be sprayed with 2 wet on wet coats allowing a 3-5 minute dwell between each coat.

4.3. After application of the second coat, allow minimum 30 minutes before stoving / curing

4.4. Final cure shall be at 193±8ºC (379±15ºF) metal (part) temperature for a minimum of 2 hours.

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5. **Coating Thickness**

5.1. The recommended dry coating thickness is 25-50 microns

6. **Touch-Up**

6.1. Damaged areas may be spot repaired in accordance with end user specifications

6.2. The coating immediately adjacent to the damaged area should be feather using 240-320 grade abrasive paper or equivalent. The damaged area must be thoroughly cleaned and degreased. The touch in coating may be spray or brush applied. Stoving must be performed as per clause 4.c to 4.d

6.3. Where stoving touch up is not possible, damaged area shall be painted with cold cure 2 pack epoxy paint to MSRR9064 (IP9064 range), applied in accordance with IPAS 43e.