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**Product Name:**IP9064 Range

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**Product Number:**Please refer to the Product Range for full colour range

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**Product Description:**

A 2 part air drying epoxy finish for interior and exterior use. Used by Rolls Royce as both a decorative and protective coating e.g. matt black on fan frame composite castings, and an air drying marking paint. Initially available in the range of colours and finishes listed, this range will probably be increased to comply with customer demand. Resistant to abrasion, corrosion and most aircraft operating fluids and chemical. This range is also used for painting instruments and touching up our Textron grey stoving, and Pratt and Whitney Canada stoving systems.

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**Approvals/Specifications:**

- Def Stan 80-161
  - DTD 5555; 5567
  - MSRR 9064
  - BSX 32
  - BSX 33 (Type A & B)
  - HCP 355 (AEC's Paint Procedure)
  - Meets the performance requirements of MIL-PRF-23377 and MIL 22750
  - RPS 661/43
  - RPS 667/5
  - RPS 667/761
  - IP9064-THIN – NSN: 8010-99-7762-692
  - IP9064-Clear – NSN: 8010-99-1515-430
  - IP9064-8000 – NSN: 8010-99-9912-136
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**Performance:**

Tested on Magnesium, Aluminum and Steel to the following minimum specification. Actual performance will be in excess of the following:

- Resistant to 100 hours in salt water fog
  - Resistant to 100 hours dry heat at 180°C
  - Resistant to 100 hours at 150°C in lubricating oil
  - Resistant to 100 hours with engine fuel
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- After 7 days air drying, resistant to Skydrol for 3 hours 70°C (160°F)
- Resistant to 10 cycles 4 hours at 150°C (300°F) 20 hours in salt water fog
- Resistant to temperatures of down to at least -40°C

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## Components:

- IP9064-Base (Part A)
- IP9064-CAT (Part B) or IP9064-CAT-MAT (Part B)

IP9064-Thin (may be added if required for coating complex unit geometry).

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## Application:

Prior to application of the primer thorough cleaning of the substrate and the application of a conversion coating is vital, this can be the systems 2 pack chromate etch primer or other process.

The full system process is as follows:

- Applied by spray, but can be brushed
- Pot Life = 8 hours
- Etch Primer: Air dry for 1 hour prior to over coating
- Epoxy Primer: Air dry for 1-16 hours prior to over coating or flash off for 30 minutes and then stove at 125°C for 30 minutes

If the primer has been applied more than 72 hours in advance of being over coated, the surface must be wet flatted with 320 grade paper and have an additional light coat of primer applied to ensure the best inter-coat adhesion for the system.

Top Coats: Apply one double track coat to give a dry film thickness of 20-32 microns. Air dry for a minimum of 4 hours or flash off for 30 minutes and then stove at 125°C for 30 minutes.

Full chemical protection is achieved after 7 days (air dry at 18-20°C min)

## Surface Preparation:

Ensure that all surfaces are clean and free from dirt.

## Paint Preparation:

**Pre-Treatment:** Primer – pre-treat aluminium or steel surfaces with chromate or phosphate pre-treatment systems as specified. Finishes usually applied over IP9064-6362 chromate or IP9064-6500 chrome free primer.

**Mixing Instructions:** Refer to product range listings and label on the base component

**Thinner/Reducer Addition:** IP9064-THIN

## Application Method:

Apply by spray; Small areas can be applied by brush

## Drying Curing:

### Air Dry:

- *Touch Dry:* 2-3 hours
- *Hard Dry:* 16-24 hours

If you can flash off for 15 minutes and the force cure for 30 minutes at 115°C +/-, this would ensure Skydrol resistance.

### Heat Cure:

- *Flash Off:* 20-30 minutes
- *Cure:* 30 minutes @ 125°C

## Technical Properties:

<b>Supply Viscosity:</b>	70 – 100 seconds ISO5 @ 23+/- 2°C
<b>Flash Point:</b>	24-26°C
<b>VOC Content:</b>	400-480 g/l
<b>Colour:</b>	Available in a Variety of colours
<b>Pack Size:</b>	1 & 5 litre
<b>Density:</b>	1.02-1.40kg/l
<b>Gloss:</b>	Available in a Variety of Gloss Levels
<b>Thinner:</b>	IP9064-THIN
<b>Solvent/Clean Up:</b>	40006 or IP9064-THIN
<b>Catalyst:</b>	IP9064-CAT
<b>Theoretical Coverage:</b>	10-12 sq m per litre

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**Storage:**

Highly flammable liquid: store and use in accordance with flammable liquid regulations.

**Shelf Life:** 12 months Temperate; 6 months Tropical

**Before Use Please Refer to Product Safety Data Sheet**

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**Safety Data Sheets:**

For Safety Data Sheets please contact our Sales Department:

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