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**Product Name:**

2 Pack Low VOC Epoxy Chrome Free Anti-Corrosive  
Primer

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**Product Number:**

IP-714A; IP-714-2-A

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**Product Description:**

2 pack low VOC solvent based, high performance chrome free, air drying epoxy primer. Developed in conjunction with Pratt & Whitney to be low VOC, Toluene and Xylene free.

Available in Light/Mid Grey (IP-714A) and Dark Grey (IP-714-2-A) as per requirements of Pratt & Whitney.

IP-714-2-A colour matt grey is an approximate colour match to Fed Stan 595 colour number, 36173.

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**Approvals/Specifications:**

- Approved to CPW 714
  - PWA 36568
  - Approved for use in Pratt & Whitney overhaul & repair: Reference SPM SPOP 148 & SPOP 155
  - Low VOC alternate to CPW 619 & PWA 36519. Volvo 101082525
  - Meets Requirements of MSRR 9064; Def Stan 80-161 and others
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**Performance:**

**Heat Resistance:** 200°C±5°C (400°F±10°F) for 48 hours without evidence of chalking, blistering or flaking.

**Hot Oil Resistance:** Film, after immersion for eight hours in ASTM Service Fluid No. 101 (ref. ASTM D 471) at 170°C±5°C (350°F±10°F) shows no peeling, blistering or softening.

**Fuel Resistance:** Film withstands immersion in ASTM Reference Fuel (ASTM D 471) at room temperature for four hours without blistering, peeling or softening.

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# Technical Data Sheet



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## Components:

**Base:** IP-714A; IP-714-2-A  
**Catalyst:** IP-714B  
**Thinner:** IP-715-Reducer

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## Application:

### Surface Preparation:

Apply over suitably prepared surface. Ensure surface is clean and dust / dirt free. The minimum pre-treatment is to degrease the substrate.

May be used over chemical conversion coatings:

**Aluminium:** Chromate or Chromate free pre-treatment

**Magnesium:** CPW 489 Rockhard Sealer

### Paint Preparation:

Thoroughly mix base component (Part – A) before use.

Mix 7 parts base to 1 part catalyst by volume (95.2 parts base to 10 parts catalyst by weight)

**Induction time:** 15 minutes

### Application Method:

Apply by spray; conventional, HVLP or compliant guns.

Recommended shop conditions:

Temp: 15-25°C; Humidity: 30-75% RH

Refer to Application Instruction Sheet IPAS714 for full application details.

### Drying Curing:

**Air Dry:** 30-45 minutes touch dry; 16 hours hard dry

**Heat Cure:** 15-30 mins flash off

Cure: 20-30 mins at 125°C (257°F) metal temperature

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## Technical Properties:

<b>Supply Viscosity:</b>	Refer to IPAS 714
<b>Flash Point:</b>	27°C
<b>VOC Content:</b>	330 g per litre (mixed)
<b>Colour:</b>	Light/Mid & Dark Grey
<b>Pack Size (lt):</b>	Part-A: 3.5, Part-B: 1 or 0.5
<b>Density:</b>	Part-A: 1.30 ± 0.04 g/ml Part-B: 1.0 ± 0.02 g/ml

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# Technical Data Sheet



<b>Dry Film Density:</b>	1.58 +/- 0.03 kg / litre
<b>Gloss:</b>	Matt
<b>Thinner:</b>	IP-715 Reducer
<b>Solvent/Clean Up:</b>	40006 or IP-715-Reducer
<b>Catalyst:</b>	IP-714B
<b>Theoretical Coverage:</b>	Theoretical 22 m <sup>2</sup> /litre @ 25 microns

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## Storage:

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

**Shelf Life:** 12 months temperate; 6 months tropical

**Before use, refer to Product Safety Data Sheet**

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: [sales@indestructible.co.uk](mailto:sales@indestructible.co.uk)