
Product Name: Low VOC 2 Component Specialist Sealant & Repair Systems
for Non-Ferrous Metals and Composites

Product Number:

- IP2222 Clear
- IP2307 Black
- IP2439 Green Tinted
- IP2539 Brown

Product Description: Two component low VOC coatings used as porosity sealants and repair coats where high temperature stoving/baking is not possible or desirable. Can air dry or be force cured at various temperatures including 60°C, 80°C or 125°C

Approvals/Specifications:

- Rolls Royce Indianapolis Inc – EPS 11435 (IP2307 black only as a magnesium sealer).
- Bombardier (green tinted version as a composite sealer)
- Sikorsky SS 8688 (IP2539 brown version as a repair touch up for brown fully cured Rockhard)

Meets the performance requirements of several aerospace and defence specifications, Pratt and Whitney Canada, Textron (Allied Signal etc), Rolls Royce MSRR 9064, Def Stan 80-161 (DTD 5555). Low VOC version similar to IP9039 / 9041; IP9042 kit approved Honeywell etc; Not dissimilar to MIL 22750

Performance: Typical performance criteria include:

- 100 hours resistance to salt water fog
- Resistance to engine oils and fuels
- Resistance to dry heat 1000 hours (180°C; 355°F)
- Resistance to dry heat 12 hours at 240°C; 450°F

Components:

Base: IP2307A; IP2439A; IP2539A; IP2222A
Catalyst: IP2307B; IP2439B; IP2539B; IP2222B
Thinner: IP3-Reducer

Application:

Surface Preparation:

Ensure that surfaces are clean and free from dirt

Pre-treatment:

- Magnesium / Aluminium – apply over chromate free (such as Iptreat 12) pre-treatment or chromate conversion coating. Follow manufacturer's instructions.
- Composites – Pre-wipe surface with IPA or similar cleaner

Paint Preparation:

- IP2307A: Mix in the ratio 5:2 pbv with IP2307B
- IP2439A: Mix in the ratio 5:2 pbv with IP2439B
- IP2539A: Mix in the ratio 5:2 pbv with IP2539B
- IP2222A: Mix in the ratio 5:2 pbv with IP2222B

Thinner Addition: IP3-Reducer – 5-10% addition to crystalized mix

Application Method:

Spray – Compliant guns recommended

Brush – May be rush Applied for Small Areas and in Confined Spaces such as Engine Room Applications

Drying Curing:

Air Dry: Touch Dry: 2-4 hours

Hard Dry to Handleable: 16-24 hours

Over Painting: Minimum Drying time 4 hours, recommended maximum time before over painting 24 hours at room temperature. No abrasive keying is required within this time scale. If abrasive keying is preferred, light abrasion with maximum 240 grit abrasive paper or Scotch Bright Pads may be used.

Heat Cure: Flash off: 30-45 mins

Cure: 20 mins @ 125°C, 60 mins @ 80°C

or 75 mins @ 60°C

Technical Properties:

Supply Viscosity: 16-20 secs/ ISO 4 Cup /23±2°C

Solids: 62 ± 2% w/w

Flash Point: ≥22°C; ≤32°C

VOC Content: **Base:** 340g/l

Catalyst: 250g/l

Technical Data Sheet



Colour:	Black, Green Tint, Clear, Brown
Pack Size:	5 Litre
Density:	1.04 ± 0.020
Gloss:	Full
Thinner:	IP3-Reducer
Solvent/Clean Up:	40006 Gunwash

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:

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