
Product Name:**High Temperature Ceramic Bonding Agent**

Product Number:**IP2902TM**

Product Description:

IP2902TM is an Inorganic High Temperature Ceramic Bonding agent that matures to a machinable, highly bonded, insoluble surface layer. The matured coating is designed to be unaffected by hot and cold water, mineral spirits, jet fuel, hydraulic oils, hot degreasing vapours and is resistant to temperatures up to 540°C, (1000F). Designed as a non-chrome alternative to Sermabond 481.

Approvals/Specifications:

Safran Helicopter Engines (Turbomeca) spec CCT600

Patent applied for:

INPI (French Patent Office) on December 15th, 2017, concerning an "ADHESIVE FOR BONDING ABRADABLE FELT".
V/REF: SNM012475 N/REF: S62565 FR NP-T.

Performance:

Original Type testing included testing bonding at >_ 7 MPa pulled travel speed 2 mm / minute to ASTM D1002 / EN2243-1 at 450C +/- 5C (840F).

Heat Resistance: prolonged exposure to 540°C (1000F)

Organic Solvent and Oil tests:

Jet Fuel	- unaffected
Mineral spirit	- unaffected
Lubricating Oil	- unaffected
Water (room temperature)	- unaffected
Water (70°C)	- unaffected
Skydrol (70°C, 3 hours)	- unaffected

Application:

Surface Preparation:

Surfaces must be clean, grease and oil free and clear of any prior coatings.

For optimum performance the substrate should be vapour de-greased using 1,1,1-trichloroethane or equivalent. Grit blast with 90-120 aluminium oxide grit to produce a surface profile suitable for bonding.

Paint Preparation:

Mix the powder part A into part B liquid. Mix thoroughly to ensure that a homogenous mixture with no large agglomerates is produced. Any large powder agglomerates may be broken down to facilitate thorough mixing.

The mixed product must be allowed to stand for a minimum of 18 hours before use.

The product is supplied pre-weighed. Mix part A and part B as supplied.

Application Method:

The matured paste can be applied in open areas with appropriate spatulas or straight blades. In narrow or confined areas, the paste may be applied using a syringe or sealant gun method.

Application equipment can be cleaned in warm water. Where a syringe or sealant gun is used the tip should be wiped clean between applications to prevent material blockages.

Drying Curing:

Leave the applied coating to air dry for 24 hours minimum. After air drying, stove for 2 hours @ 80 °C, followed by 4 hours @ 100 °C, then raise temperature to 340 °C and stove for 1 hour. For large components, the 100 °C stove can be extended, to help with curing. Please note – All curing times are for when the components have reached full metal temperature.

Technical Data Sheet



Technical Properties:

Supply Viscosity:	Two-part product Viscosity increases to give a paste after minimum 18 hour induction time.
Flash Point:	N/A
VOC Content:	0 g/litre
Colour:	Grey
Pack Size:	1 Kg kit; 400gm fluid part A 600gm Powder Part B
Specific Gravity:	1.76 g/ml (mixed product)
Gloss:	Matt
Thinner:	de-mineralised or de-ionised water
Solvent/Clean Up:	Water
Catalyst:	N/A
Theoretical Coverage:	0.4 m ² @ 500-micron dft

Storage:

Water Based Material – store above 5°C (>5°C).

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:

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