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**Product Name:**

Low VOC 2 Pack Polyurethane Finishes to BS2X34  
A&B ; RRMS 40030 and MSRR 1006

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**Product Number:**

IP6 Range

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**Product Description:**

A low VOC (less than 420gm at application) air drying, pigmented polyurethane finishing scheme formulated to provide a flexible and chemically resistant coating for all light alloys used in aircraft construction, coupled with exceptional colour and gloss retention. Normally used in conventional VOC BSX33 chromate primer, or more recently our chrome free 2 pack epoxy primer, and if necessary BSX32 etch primer, or latest technology chrome free version.

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**Approvals/Specifications**

- BS2X 34 Type A and BS2X 34 Type B
  - MSRR 1006
  - RRMS 40030
  - HAL (India RWDC for use on Advanced Light Helicopter)
  - Meggitt Aircraft Braking Systems – PR0599 (ML-TR 100018)
  - Aero Engine Controls HCP 355
  - Supersedes DTD 5580
  - Meets the performance data requirements of MIL-PRF-85285, class H
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**Performance:**

- **Pot Life:** 4 hours
  - **Cupping Test:** No cracking Indentation of 6mm
  - **Impact Test:** No cracking at Indentation of 3.8mm
  - **Adhesion:** 1mm spacing; ≤ class 1
  - **Hardness:** No penetration under load of 1500gms
  - **Water Resistance:** 168 Hours
  - **Skydrol Hydraulic Fluid Resistance:** 1000 hours at 70 ±2°C
  - **Artificial Weathering:** 500 hours UVB Lamps
  - **Dry Heat:** 100 hours at 180°C
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**Components:**

**Base:** IP6-Range  
**Catalyst:** IP6-CAT

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**Thinner:** IP985-Reducer; 665-550-025 or IP-MEG-REDUCER

Thinner selected is dependent on spray shop conditions and article.

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## Application:

### Surface Preparation:

Ensure that all surfaces are clean and free from dirt

Usually applied over 2 Pack Low VOC Epoxy Primer – to BS2X33 in Aluminium, Def Stan 80-216 on composite

### Paint Preparation:

Refer to product range chart.

Allow 15 minutes after mixing before use and re-stir before using.

**Mixed Pot Life:** 4 hours

### Application Method:

Apply by spray; it is recommended that the latest quality compliant spray to allow for best transfer efficiency and atomisation. Can however be applied through conventional or HVLP guns.

Please refer to our application instruction sheet IPAS-050 / IPAS-050-A for additional information. Apply in accordance with RPS 661 / 50 for use on Rolls Royce parts.

### Drying Curing:

#### Air Dry:

- *Touch Dry:* 4-6 hours
- *Hard Dry:* 16-24 hours

#### Force Cure:

- *Flash off:* 30-45 minutes
- *Cure:* 60-90 minutes @ 60-80°C

#### Dry to Handleable (forced dry @ nominal 50°C)

- *Flash off:* 15-20 minutes
- *Cure:* minimum 90 minutes @ 50°C (provides a finger-print resistant handleable finish)

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## Technical Properties:

<b>Supply Viscosity:</b>	Gloss: 60-80 seconds/Iso5cup/23±0.5°C
<b>Flash Point:</b>	≥21≤32°C
<b>VOC Content:</b>	≤420 gm / litre VOC
<b>Colour:</b>	Various
<b>Pack Size:</b>	5 Litre
<b>Density:</b>	Range 1.05-1.35 ± 0.02kg/l
<b>Gloss:</b>	Matt (<5GU) Semi-Matt (10-30 GU) & Gloss (>85 GU)
<b>Thinner:</b>	665-550-025, IP985-Reducer, IP-MEG-Reducer
<b>Solvent/Clean Up:</b>	40006 Gun Cleaner
<b>Catalyst:</b>	IP6-CAT
<b>Theoretical Coverage:</b>	12-18m <sup>2</sup> / litre
<b>HDMI (hexamethylene-diisocyanate) content</b>	Theoretical 0.14 – 0.15 % by weight immediately after mixing parts A and B. Curing/drying reaction within the coating will reduce this value to zero.

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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 Please Refer to Product Data Safety Sheet**

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:  
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