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<b>Product Name:</b>	Thin Film High Heat Resistant Sacrificial Aluminium Coating
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<b>Product Number:</b>	IP9356
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<b>Product Description:</b>	<p>Sacrificial Aluminium Coating that is part of a range of corrosion resistant coatings designed for use in challenging environments such as aero engine, power generation and marine situations.</p> <p>Spray applied IP9356 is used, on turbine blades, rotors, shafts and landing gear to protect components from salt laden atmospheres, high temperature oxidation, chemicals and abrasives.</p> <p>The coating provides corrosion and oxidation protection to iron, steel, heat treated stainless steel alloys, titanium and other metallic substrates at temperature of up to 700°C. IP9356-R1 can also be super or vibro polished (RPS 619) to enhance flow of air in aircraft engines where smooth surfaces are essential to enhance energy efficiency (See also Ipseal IP9184 and Smoothseal IP9444).</p> <p>IP9356-R1, when vibro polished achieves a Ra surface finish of <math>\leq 12</math> micro inches.</p>
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<b>EU REACH Status</b>	<p>This coating contains Chromium Trioxide (Chromic Acid): CAS No: 1333-82-0. This is classified as a SVHC, and under annex XIV has a sunset date of September 2017. Continued use of this coating after this date will be restricted to authorised uses (uses 1, 4 &amp; 5 as defined in authorisation) under the REACH chemical restriction process, for a defined time period: 4 years for industrial uses and 7 years for aerospace use.</p>
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<b>Possible Chrome free Alternatives</b>	IP
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<b>Approvals/Specifications:</b>	<ul style="list-style-type: none"><li>- MSRR 9356</li><li>- OMat 7/167A</li><li>- Alternative to Sermetal 709, 762 and 962</li><li>- ITP: SMM-919</li></ul>
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## Performance:

### Salt Spray

corrosion resistance - ASTM.B117 - Minimum 1000 hours at 40-50 micron film thickness. Externally tested to achieve >3000 hours ASTM B117 exposure.

Surface Conductivity - positive over complete film.

540 – 560°C cure – Electrically conductive post cure.

350°C cure – Electrically conductive post burnish process.

Adhesion - 1mm Cross hatch. BS EN ISO 2409, class 0

Dry Heat - 1000 Hours at 600°C (1100°F)

Cyclic salt water fog/heat at 450°C (840°F) - 240 Hours (480 Hours with Ipseal)

Cyclic salt water fog/heat humidity/heat at 450°C (840°F) - 240 Hours (480 Hours with Ipseal)

Operating Temperature: -40°C (-40°F) to 700°C (1290°F)

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## Components:

Single Pack Product. May be thinned for application using demineralised / deionised water

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## Application:

### Surface Preparation:

Ensure that surfaces are totally clean and dirt free

**Pre-Treatment:** Typically de-grease then grit blast with 120/220 aluminium oxide. Surfaces must be dust free prior to coating.

### Paint Preparation:

De-ionised Water; up to 5% by volume as required

### Application Method:

Spray Conventional or HVLP. Fluid tip sizes between 0.8 and 1.6mm dependent upon component size and geometry. Gravity, syphon or pressure feed equipment may be used.

### Drying Curing:

540°C (2 hours) – 560°C (1 hour) (1000 – 1040°F) - dull matt grey - surface finish approximately 70 micro inches.

350°C (1 hour)

(660°F) – dull matt grey finish, non-conductive - bead peened - shiny bright conductive aluminium similar to metal. Surface finish approximately 70 micro inches.

Refer to process sheet IPAS666 for complete Ipcote range application instructions.

## Technical Properties:

<b>Supply Viscosity:</b>	ISO3 @ 23 +/- 2°C – 30 +/- 5 seconds as supplied
<b>Standard dry film thickness:</b>	0.01-0.03mm per coat Recommended. May be Applied down to 0.005-0.01mm May be applied down to 0.005-0.01mm
<b>Flash Point:</b>	N/A – Aqueous product
<b>VOC Content:</b>	N/A
<b>Colour:</b>	Grey/Green solution. Dull Grey after baking.
<b>Pack Size:</b>	1 and 5 litre
<b>Density:</b>	1.6 ± 0.02kg/l
<b>Gloss:</b>	N/A
<b>Thinner:</b>	Demineralised/Deionised Water
<b>Solvent/Clean Up:</b>	Water
<b>Catalyst:</b>	N/A
<b>Theoretical Coverage:</b>	7.9 – 10 m <sup>2</sup> per litre

## 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**

## Disclaimer:

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# Technical Data Sheet

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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