

## Product Name

Smoothseal

## Product Description

Smoothseal is an inorganic protective coating used as a barrier on Ipcote IP9183-R1, Ipthin IP9356. Smoothseal cures to provide an ultra-smooth finish to improve dirt shedding and air flow properties.

All the Ipcote coatings are conductive, sacrificial coatings and inherently porous. Smoothseal seals this porosity without detracting from their sacrificial properties. It also creates an electrically non-conductive barrier coat. The use of Smoothseal on top of these products results in an ultra-smooth, harder coating which provides a barrier against carbon deposits etc, extending the useful life of the base coat, and ultra-smooth finish which enhances airflow characteristics and therefore engine efficiency. When used to give an alternative system to Sermatech's 5380 system, it is applied over specially prepared Ipcote IP9183, (apply for Rolls process Spec 666/5). A light golden yellow colour, it has similar appearance to 5380DP

## REACH Status

This coating contains Chromium Trioxide: CAS No: 1333-82-0. This is classified as a SVHC, and under annex XIV

## UK and EU Authorisation – October 2024

### October 2024 – UPDATE - UK

AFA032-01 – Chrome Conversion coating use Aerospace (DOW19)	<b>UKREACH/24/15/4</b>
AFA033-01- Formulation of mixtures	<b>UKREACH/24/16/1</b>
AFA037-01 – Slurry Coatings Aerospace use	<b>UKREACH/2024/18/1</b>
AFA045-01 – Formulation – Industrial	<b>UKREACH/24/22/0</b>
AFA045-02 – Industrial gas turbine use	<b>UKREACH24/22/1</b>

### October 2024 – UPDATE – EU

AFA344 – Slurry Coating	<b>REACH/24/68/3</b>
AFA337-02 – Chrome Conversion Coating Aerospace use	<b>REACH/24/61/1</b>

### Extension Dates from October 2024:

UK – 05/09/2036 (12 Years)

EU – 7 YEARS (Dates to be Confirmed – Still ongoing)

EU – DOW 19 a 12 year extension

## Approvals and Specifications

Release to MSRR3010, similar to MSRR9140  
RPS666/5  
NSN: 8030-99-371-0990  
Meets CPW 406  
Siemens: 552208

## Performance Properties

Smooth eggshell finish  
Typical thickness 4-6 microns per coat (0.2 thou)  
Operating temperature -40°C to 800°C (1420°F)  
Less than 0.6% hexavalent chrome

## Components

Single Pack Product. May be thinned with de-ionised water for spray application. Where low humidity is present within a spray facility the addition of 5-10% by volume of de-ionised water may be required.

## Application

*Refer to IPAS for full detailed instructions.*

<b>Surface Preparation</b>	Ensure that surfaces are totally clean and dirt free
<b>Paint Preparation</b>	Stir well before use. All separated material must be re-incorporated into the bulk product. No time limits are specified for the mixing operation. The operator must be satisfied that the product including any thinning solvent is thoroughly mixed before use. Where mechanical mixing is employed, care must be taken to not heat the product to above the maximum storage temperature. Mixing in open containers should be limited to <10-minute periods to ensure that solvent evaporation does not compromise the product. Shaking or rolling in closed containers is an acceptable mixing method for small volume products supplied ready for use.
<b>Mixing Ratio</b>	Single Pack Product
<b>Application Method</b>	Spray applied coating. Refer to application sheet IPAS666. Refer to RPS 666/5 for Rolls Royce parts
<b>Drying and Curing</b>	Air Dry: 10 minutes Heat Cure: Pre-bake for 30 minutes at 80-100°C, 30-60 minutes at 350°C

# Technical Data Sheet



IP9444

Edition February 2025 Revision 1

## Liquid Technical Properties\*\*

Supply Viscosity	Ready for Use
Flash Point	N/A – Aqueous Product
Density	1.2 g/ml
VOC Content	0
Colour	Yellow
Gloss	Matt
Thinner	De-ionized water
Solvent/Clean Up	De-ionized Water
Theoretical Coverage	7.9 to 10 m <sup>2</sup> per litre
Pack Size	1 Litre Containers
Pot Life	Single Pack product

\*\* - The values referenced are obtained from Batch testing using controlled Quality techniques.

## Storage

Water based corrosive and environmentally hazardous material.

Ensure product is stored in a warm, dry environment with a minimum temperature above 5°C (40°F). Do not allow to freeze.

Ensure storage complies with local environmental controls.

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

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

\*\*\* - Indestructible Paint decline any responsibility deriving from improper storage of Product and its Catalyst.

## Contact

For Safety Data Sheets or other Information please contact our sales Department:

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