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## Product Name

Stoving Primer and Finish Low cure (Chrome Free Primer)

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## Product Description

IP150 Range products are a lower cure stoving finish paint suitable for application to suitably prepared and/or pre-treated metal substrates such as those used in the fabrication of service equipment and instruments. It can be cured at lower temperatures than the full baking Rockhard range

Primer; For EU Reach law; use new IP150-PRIMER-GREY

Alternative to Praxair 1083; chrome free and 1321

Primer; chrome free low cure baking primer

Topcoat IP150-XXXX (according to colour code)

IP150-FS16187 grey to Honeywell spec MCS9227 (alternative to Praxair 1140)

This system is used to coat pre-treated metal surfaces including aluminium and steel.

Available in either a semi-gloss or gloss finish

IP150-RANGE is available in a variety of colours, please state the colour specification before placing an order – some colours may be subject to a minimum order quantity

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## Approvals and Specifications

Def 80-152.

Honeywell specs MCS 9227 and MCS 9228

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## Performance Properties

Will comply with published Defence Standard 80-152 (when applied in accordance with standard or customer specification) which includes the following: And other specs

- Bend Test: No cracking or loss of adhesion, around 12mm mandrel
- Resistance to Humidity: BS 3900: part F9 for a period of 10 days
- Resistance to Ester Lubricant: No film deterioration and no penetration of the topcoat
- Scratch Resistance: No penetration of the topcoat, BS 3900: Part E2 using a load of 2,000g
- In addition, this range will perform at higher temperatures.
- High temperature resistance; continual running (1000 + hours 220C / 430F ; higher temperatures to 260-270C ( 500 – 520F ) for shorter periods

## Components

Single Pack Product.

## Application

*Refer to IPAS for full detailed instructions.*

<b>Surface Preparation</b>	Degrease and shot blast as required
<b>Paint Preparation</b>	May be thinned for application by using 665-550-025 (and other suitable thinner such as IP985-thin) up to 10% by volume
<b>Mixing Ratio</b>	Single Pack Product may be thinned as above.
<b>Application Method</b>	Spray – can be used as supplied or thinned with up to 15% 665-550-025 thinner (IP985-thin). Apply 1 coat IP150 Grey Primer to required dry film thickness. Either part cure and overcoat with topcoat or fully cure and de-nib / flat as required if no topcoat is required. Apply 1-2 coats finish to achieve required dry film thickness
<b>Drying and Curing</b>	<p>IP150 Grey Primer:</p> <ul style="list-style-type: none"><li>• Flash off 20-30 minutes</li><li>• Part cure for 30 minutes @ 120-130°C – (250 – 265F)</li></ul> <p>Topcoat IP150 range of colours:</p> <ul style="list-style-type: none"><li>• Flash off 20-30 minutes</li><li>• Cure for 1 hour @ 140-150°C (285 – 300F)</li></ul>

# Technical Data Sheet



IP150 Range

Edition March 2025 Revision 1

## Liquid Technical Properties\*\*

Supply Viscosity	40-50s / ISO 4 / 23°C
Flash Point	26°C
Density	1.07 +/- 0.03kg/l
VOC Content	590 g/l
Colour	Primer; grey Top-coat Colour As per customer requirement
Gloss	Semi-Gloss / Full-Gloss
Thinner	665-550-025, (others by lab agreement)
Solvent/Clean Up	40006 Gun Cleaner
Theoretical Coverage	13 sq m/l
Pack Size	5 Litre
Pot Life	Not Applicable, Single Pack Product.

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

## 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**

\*\*\* - 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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Email: [sales@indestructible.co.uk](mailto:sales@indestructible.co.uk)

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